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5311 Foundation Blvd.
New Albany, IN 47150

CHESTER EPOXY SPECIFICATIONS

PRODUCT PROFILE

GENERIC DESCRIPTION	Epoxy
COMMON USAGE	Low temperature-cure, corrosion-resistant coating for protection against abrasion, immersion and mild chemical contact. Fast recoat at 75° F (24° C). NOTE: Epoxies chalk with extended exposure to sunlight. Lack of ventilation, incomplete mixing, miscatalyzation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may cause yellowing to occur.
FINISH	Satin

COATING SYSTEMS

PRIMERS	Steel: Self-priming Galvanized Steel and Non-Ferrous Metal: Self-priming Concrete: Self-priming

SURFACE PREPARATION

Consult Chester Epoxy Coating Application Procedure

TECHNICAL DATA

CURING TIME

Temperature	*To Touch*	*To Handle*	*To Recoat*	*Immersion*
75 F (24° C)	1 hour	2 – 3 hours	3 – 4 hours	3 days
65 F (18° C)	2 hours	4 – 5 hours	5 – 6 hours	4 – 5 days
55 F (13° C)	3 – 4 hours	6 – 8 hours	10 – 12 hours	6 – 7 days
45 F (7° C)	6 – 7 hours	12 – 14 hours	16 – 18 hours	9 – 10 days
35 F (2° C)	8 – 10 hours	16 – 18 hours	20 – 22 hours	12 – 14 days

Curing time varies with air and substrate temperature, air movement, humidity and film thickness.

	Unthinned	*Thinned 10%*
VOLATILE ORGANIC COMPOUNDS	**2.93 – 2.99 lbs/gallon (351 – 358 grams/litre)**	**3.29 – 3.34 lbs/gallon (394 – 400 grams/litre)**

THEORETICAL COVERAGE* 930 mil sq. ft./gal. (22.8 m2/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Two: Part A and Part B

PACKAGING 5 gallon (18.9L) pails and 1 gallon (3.79L) cans – order in multiples of 2.

NET WEIGHT PER GALLON* 12.50 ± 0.25 lbs. (5.67 ± .11 kg)

STORAGE TEMPERATURE Minimum 20° F (-7° C)
Maximum 110° F (43° C)

SHELF LIFE 12 months at recommended storage temperature.

FLASH POINT – SETA Part A: 82°F (28° C)
Part B: 64° F (18° C)

HEALTH & SAFETY Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product. Keep out of reach of children.

APPLICATION

COVERAGE RATES*

	Primer			*Intermediate/Topcoat*		
	Dry Mils (Microns)	Wet Mils (Microns)	Sq. Ft./Gal (m2/Gal)	Dry Mils (Microns)	Wet Mils (Microns)	Sq. Ft./Gal (m2/Gal)
Suggested (1)	4.0 (100)	7.0 (180)	232 (21.6)	5.0 (125)	8.5 (215)	186 (17.3)
Minimum	3.0 (75)	5.0 (125)	310 (28.8)	4.0 (100)	7.0 (180)	232 (21.6)
Maximum	5.0 (125)	8.5 (215)	186 (17.3)	6.0(150)	10.5(265)	155 (14.4)

(1) Note: Roller or brush application requires two or more coats to obtain suggested film thickness. Allow for overspray and surface irregularities. Film thickness is based on closest 0.5 mil (5 microns). Application of coating below minimum recommended dry film thicknesses may adversely affect coating performance.

MIXING

Power mix contents of each container, making sure no pigment remains on the bottoms. Pour a measured amount of Part B into a clean container large enough to hold both components. Add an equal volume of Part A to Part B while under agitation. Continue agitation until the two components are thoroughly mixed. Do no use mixed material beyond pot life limits. Note: When material temperature is below 50° F (10° C) allow mixed material to stand thirty (30) minutes before application; restir before using.

POT LIFE

16 hours at 35° F (2° C)
2 hours at 77° F (25° C)
½ hour at 100° F (38° C)

THINNING

Use Chester Epoxy thinner. For air spray, thin up to 10% or ¾ pint (380 ml) per gallon. For airless spray, roller or brush, thin up to 5% or ¼ pint (190 ml) per gallon.

SURFACE TEMPERATURE

Minimum 35° F (2° C)
Maximum 135° F (57° C)
The surface should be dry and at least 5 F (3° C) above the dew point. Coating will not cure below minimum surface

temperature. For optimum application properties during cold weather, keep material temperature above 60° F (16° C) until time of application. Do not apply coating if surface temperature is expected to drop below 35° F (2° C) within 8 hours of application.

APPLICATION EQUIPMENT ***Air Spray***

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVibliss MBC or JGA	E	765 or 78	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or ½" (9.5 or 12.7mm)	75-100 psi (5.2-6.9 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019" (380-485 microns)	1800-300 psi (124-207 bar)	¼" or 3/8" (6.4 mm or 9.5mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Note: Application over inorganic zinc-rich primers: Apply a wet mist coat and allow tiny bubbles to form. When bubbles disappear in 1 to 2 minutes, apply a full wet coat at specified mil thickness.
Roller: Roller application optional when environmental restrictions do not allow spraying. Use 3/8" or ½" (9.5 mm or 12.7 mm) synthetic nap covers.
Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

***Values may vary with color**