

### PRODUCT DESCRIPTION

**Generic:** Waterborne Epoxy Polyamide

**General Description:** A high performance, two-package, chemically-cured waterborne gloss epoxy coating for use as a hard, durable high performance architectural coating (HIPAC). Features easy application, low VOC, high flash point, lower odor than solvent-based epoxies, and a hard, tough, stain-resistant finish. May be used in areas subject to continuous high moisture such as shower rooms.

**Typical Uses:** Use on interior properly prepared poured concrete, concrete block, drywall, metal and wood. Ideal for hard usage areas of schools, hospitals, restaurants, public buildings and factories.

### SPECIFICATION DATA

**Color:** White & custom colors

**Finish:** Gloss, 90 units minimum @ 60°

**Clean-up Solvent:** Soap and water

**Weight/Gallon (mixed):** 10.1 lbs./gal. (1.21kg/L)-varies with color

**VOC (mixed):** 1.72 lbs./gal. (206 g/L) - varies with color

**Solids By Volume (mixed):** 43% ± 2% - varies with color

**Theoretical Coverage at 1.0 Mil Dry:** 690 sq. ft./gal. (17 m<sup>2</sup>/L)

**Practical Coverage:** Apply at 235-320 sq. ft./gal. (6-8 m<sup>2</sup>/L) on smooth, sealed surfaces. Actual coverage may vary depending on substrate and application method. May be spray applied at 120-235 sq. ft./gal. (3-6 m<sup>2</sup>/L).

**Recommended Film Thickness:** 2.0-5.0 mils (50-125 microns) dry - 5.0-11.0 mils (125-275 microns) wet

**Systems:** Please consult the appropriate system guide, the particular job specification or your ICI Paints Representative for proper systems using this product. Systems must be selected considering the particular environment involved.

**Minimum Dry Time (ASTM D 1640):** At 3 mils (75 microns) DFT & 50% RH

Substrate	Temperature
Minimum Recoat	77°F (25°C)
Dry Hard	16 Hours
Maximum Recoat	24 Hours
Self	No Limit

Ventilation, film thickness, humidity, thinning and other factors can influence the rate of dry.

**Warning:** The above table provides general guidelines only. Always consult your ICI Paints Representative for appropriate recoat windows since the maximum aged recoat time of this product may be significantly shortened or lengthened by a variety of conditions, including, but not limited to humidity, surface temperature, and the use of additives or thinners. The use of accelerators or force curing may shorten the aged recoat of individual coatings. The above recoat windows may not apply if recoating with a product other than those listed above. If the maximum aged recoat window is exceeded, please consult your ICI Paints Representative for appropriate recommendations to enhance adhesion. Failure to observe these precautions may result in intercoat delamination.

**Shelf Life:** 1 year minimum - unopened

**Mix Ratio By Volume:** 1 (base): 1 (converter)

**Induction:** 30 minutes - above 70°F (21°C), 45 minutes - below 70°F (21°C)

**Pot Life:** 6-8 hours @ 77°F (25°C)

### FEATURES

**Advantages:**

- Chemical and stain resistant
- Resists splash and spillage of alkalis, salts, moisture, oils, grease, foodstuffs and detergents
- Abrasion resistant
- Low odor and a high flash point
- Use over alkyd, latex or epoxy coatings
- Long lasting tile-like finish
- Easily washed and cleaned
- Low VOC
- Performance alternate for Federal Specifications TT-C-535B (Type II) and TT-C-550C (Class A)

**Limitations of Use:** Not recommended for immersion service. Exterior exposure will cause early dulling and loss of gloss, but does not affect protective properties. Epoxy coatings may yellow during application and cure if exposed to the combustion by-products of improperly vented fossil fuel burning heaters.

### PERFORMANCE DATA

PROPERTY	TEST METHOD	RESULTS
Abrasion Resistance	ASTM D 4060, CS-17 wheels, 1000g load, 1000 cycles	180mg loss
Pencil Hardness	ASTM D 3363	B
Flexibility	ASTM D 522, Method B, 1/8"	No cracking or flaking
Impact Resistance	ASTM D 2794	>100 in-lbs
Water Resistance	ASTM D 2247, 1000 hours	No blistering and 90% gloss retention
Washability	ASTM D 6142, Fed. Std. 141C, 10,000 cycles	No wear through
Service Temperature Limit:		250°F (121°C) in air. May discolor at temperatures over 140°F (60°C).
Flame Spread Rating:	ASTM E 84	Class A (0-25) over noncombustible surfaces

Read Label and Material Safety Data Sheet Prior to Use. See other cautions on last page. DSF1-0690

## GENERAL SURFACE PREPARATION

All surfaces must be sound, dry, clean and free of oil, grease, dirt, mildew, form release agents, curing compounds, efflorescence, loose and flaking paint and other foreign substances.

**New Surfaces: Concrete, Plaster and Masonry-** Cure at least 30 days before painting. pH must be 10.0 or lower. Remove laitance and roughen unusually slick poured or pre-cast concrete by acid etching or abrasive sweeping. Follow acid manufacturer's application and safety instructions. Rinse thoroughly with water and allow to dry. Remove loose aggregate. Prime with this product thinned 8:1 with water or prime with TRU-GLAZE-WB™ 4030 epoxy primer. Dry overnight to recoat. Fill concrete block in areas not subject to moisture with BLOXFIL® 4000 or PREP & PRIME® 3010 filler. In moisture prone areas, fill with this product or TRU-GLAZE-WB 4015 filler. These fillers must dry overnight before coating. **Drywall** - Prime with this product or PREP & PRIME GRIPPER® 3210 primer. **Wood**- Prime with this product reduced one-half pint per gallon with water or prime with waterborne primer PREP & PRIME GRIPPER 3210. **Steel** - Prime with TRU-GLAZE-WB 4030 epoxy primer. **Galvanized Metal and Aluminum**- Prime with TRU-GLAZE-WB 4030

epoxy primer. **Glazed Brick, Ceramic Tile and Fiberglass** - Scuff sand and prime with TRU-GLAZE-WB 4030 epoxy primer.

**Previously Painted Surfaces:** The waterborne components of this product generally allow use over most old coatings. Old coatings should be tested for lifting. If they lift, remove them. Wash to remove contaminants. Rinse thoroughly with water and allow to dry. Dull glossy areas by light sanding. Remove sanding dust. Remove loose paint. Prime bare areas with primer specified under **New Surfaces**.

**WARNING! If you scrape, sand, or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to [www.epa.gov/lead](http://www.epa.gov/lead).**

## DIRECTIONS FOR USE

**Tinting:** Tint the appropriate 4408-XXXX Component A base with ICI Paints Colorants. Mix thoroughly before 4408-9999 Component B is added.

**Mixing:** Power mix while slowly adding 4408-9999 Component B to 4408-XXXX Component A in a 1:1 ratio. Mix thoroughly and scrape sides of can to ensure thorough blending. Allow the mixed material to stand 45 minutes at temperatures below 70°F (21°C) before use. Above 70°F (21°C) allow 30 minutes induction time. Always restir before use. Mixed material is usable for six to eight hours; if it thickens, do not add thinner, but discard and mix fresh material. If initial thinning is necessary, use up to one-half pint water per gallon. Do not thin with solvents or solvent thinned coatings. Do not add flow-control materials. Avoid storing or placing containers in direct sunlight.

**Spreading Rate:** Apply at 235-320 sq. ft./gal. (6-8 m<sup>2</sup>/L) or 5.0- 7.0 mils wet (2.0-3.0 mils dry) on smooth, sealed surfaces. Actual coverage may vary depending on substrate and application method. May be spray applied at 120-235 sq. ft./gal. (3-6 m<sup>2</sup>/L) or 7.0-11.0 mils wet (3.0-5.0 mils dry). For best hiding, tint primers toward finish coat color. Certain shades of yellow, orange, pink and red may require multiple coats.

**Application:** May be applied by brush, roll or spray. No thinning required. For airless spray, use a .015" tip. Adjust pres-sure as needed. Spray is preferred for appearance and build. For roller application, use clean medium nap synthetic roller (new rollers

must be free of loose fibers). Brushing is best reserved for small areas of "cutting in". For maximum gloss development, two coats of this product are recommended. In some cases, one coat may be sufficient depending on the application method, color used and smoothness desired. Do not apply when surface or air temperature is below 50°F (10°C). Brushing and rolling may require multiple coats to achieve correct film thickness and/or hiding. DEVFLEX® 4207 Waterborne Retarding Additive may be used in TRU-GLAZE-WB 4408 epoxy coating to improve brushing.

**Note:** Surfaces coated with this product may become slippery when wet. For additional slip resistance in areas of pedestrian traffic, add one pound per gallon of coarse pumice or other texturing material.

**Drying Time (ASTM D 1640):** Application temperature range is 60°-95°F (16°-35°C). At 77°F (25°C) and 50% R.H., dries to touch in two hours and to recoat overnight. Full cure in seven days. Dries to light foot traffic on concrete floors in 48 hours. Low temperature, high humidity, thick films or poor ventilation will increase these times. Lack of ventilation and/or the use of portable fuel burning heaters that produce exhaust gases, during application and initial stages of curing, may cause yellowing to occur.

**Clean-up:** Clean immediately after use with warm, soapy water. Rinse pumps and hoses with xylene after cleaning.

## PRECAUTIONS

**WARNING! CAUSES EYE AND SKIN BURNS. HARMFUL OR FATAL IF SWALLOWED. ASPIRATION HAZARD-CAN ENTER LUNGS AND CAUSE DAMAGE. HARMFUL IF INHALED. MAY CAUSE CENTRAL NERVOUS SYSTEM EFFECTS, INCLUDING DIZZINESS, HEADACHE OR NAUSEA. CAUSES RESPIRATORY TRACT IRRITATION. MAY CAUSE ALLERGIC SKIN REACTION. MAY BE HARMFUL IF ABSORBED THROUGH SKIN. OVEREXPOSURE MAY CAUSE BLOOD, LIVER, KIDNEY DAMAGE. WHEN TINTED, CONTAINS ETHYLENE GLYCOL WHICH CAN CAUSE SEVERE KIDNEY DAMAGE WHEN INGESTED AND HAS BEEN SHOWN TO CAUSE BIRTH DEFECTS IN LABORATORY ANIMALS. USE ONLY WITH ADEQUATE VENTILATION. KEEP OUT OF THE REACH OF CHILDREN. NOTICE: Products in this series contain solvents.** Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal. For emergency information call (800) 545-2643. **Note: These warnings encompass the product series. Prior to use, read and follow product-specific MSDS and label information.** If sanding is done, wear a dust mask to avoid breathing of sanding dust. Do not breathe vapors or spray mist. Ensure fresh air entry during application and drying. Avoid contact with eyes and skin. If you experience eye watering, headaches, or dizziness, leave the area. If properly used, a respirator may offer additional protection. Obtain professional advice before using. Close container after each use. **FIRST AID:** In case of skin contact, wash thoroughly with soap and water. If any product remains, gently rub petroleum jelly, vegetable or mineral/baby oil onto skin, then wash again with soap and water. Repeated applications may be needed. Remove contaminated clothing. For eye contact, flush immediately with large amounts of water, for at least 15 minutes. **Obtain emergency medical treatment.** If swallowed, **obtain medical treatment immediately.** If inhalation causes physical discomfort, remove to fresh air. If discomfort persists or any breathing difficulty occurs, get medical help. **KEEP FROM FREEZING.**

DS257-1003

## SHIPPING

**Flash Point:** Over 200°F (96°C)  
**Packaging:** 2 gallon kit (7.57L) 10 gallon kit (37.95L)  
 1 gallon Component A 5 gallons Component A  
 1 gallon Component B 5 gallons Component B

**Shipping Weight:** 2 gallon kit - 23 lbs. (10.4 kg)  
 10 gallon kit - 113 lbs. (51.3 kg)

4408 (05/07)  
 Ad Stock #68622C



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