

Water Borne Epoxy

PRODUCT DESCRIPTION An economical, two package, chemically cured waterborne gloss epoxy finish.

INTENDED USES For use as a durable high performance architectural coating (HIPAC) on interior poured concrete, concrete block, concrete floors, drywall, metal and wood.

Features easy application, very low VOC, high flash point, lower odour than solvent-based epoxies, and a tough, stain-resistant finish.

Ideal for hard usage areas of schools, hospitals, restaurants, public buildings and factories.

Suitable for use in USDA-inspected facilities.

PRACTICAL INFORMATION FOR TRU-GLAZE-WB 4438

Colour	White and pastel custom colours using waterborne colourants
Gloss Level	Gloss and Semi-Gloss
Volume Solids	31% ± 2%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 161-323 microns (6.4-12.9 mils) wet
Theoretical Coverage	4.10 m ² /litre at 75 microns d.f.t and stated volume solids 166 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Roller, Air Spray, Brush
Drying Time	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
25°C (77°F)	*1	24 hours	16 hours	Extended

*1 Not Applicable

REGULATORY DATA

Flash Point (Typical)	Part A 96°C (205°F); Part B 96°C (205°F); Mixed 96°C (205°F)		
Product Weight	1.35 kg/l (11.3 lb/gal)		
VOC	43 g/lit (0.36 lbs/gal)	Calculated	
See Product Characteristics section for further details			

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SURFACE PREPARATION

All surfaces should be clean, dry and free from contaminants including, but not limited to curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitance.

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 using Tru-Glaze-WB 4438 thinned 8:1 with water or prime with Tru-Glaze-WB 4030 or 203 waterborne epoxy primers. Dry over night to recoat. Fill concrete block with Tru-Glaze WB 4015 filler. These fillers must dry overnight before coating.

Drywall:

Prime using Tru-Glaze-WB 4438 or Devcryn 1440 prime and finish.

Wood:

Prime using Tru-Glaze-WB 4438 reduced one-half pint per gallon with water.

Steel:

Tru-Glaze-WB 4438 should be applied to a substrate which has been correctly prepared and primed using Tru-Glaze WB 4030 or Devran 203 waterborne epoxy primers. See primer datasheet for further information.

Galvanized Metal and Aluminium:

Tru-Glaze-WB 4438 should be applied to a substrate which has been correctly prepared and primed using Tru-Glaze WB 4030 or Devran 203 waterborne epoxy primers. See primer datasheet for further information.

Glazed Brick, Ceramic Tile and Fiberglass:

Scuff sand and prime with Devoe Tru-Glaze WB 4030 or Devoe Devran 203 waterborne epoxy primers.

Previously Painted Surfaces:

The water borne 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.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified. (1) Agitate Base (Part A) with a power agitator. (2) Agitate Curing Agent (Part B) with a power agitator. (3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator. Mix thoroughly and scrape sides of can to ensure thorough blending. Allow the mixed material to stand 15 minutes before use. Do not add flow-control materials.	
Mix Ratio	1 part(s) : 1 part(s) by volume	
Working Pot Life	25°C (77°F) 3 hours	
Airless Spray	Recommended	Use a 0.38mm (15 thou) tip size and adjust pressure as needed. Spray is preferred for appearance and build.
Brush	Suitable	Only for small areas or touch ups
Roller	Suitable	Use clean medium nap synthetic roller (new rollers must be free of loose fibres).
Work Stoppages	Do not allow mixed material to remain in hoses, gun or spray equipment.	
Clean Up	Clean immediately after use with warm, soapy water. Rinse pumps and hoses using xylene after cleaning.	

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PRODUCT CHARACTERISTICS

Advantages:

- Chemical and stain resistant
- Resists splash and spillage of alkalis, salts, moisture, oils, grease, foodstuffs and detergents
- Abrasion resistant
- Low odour and a high flash point
- Use over alkyd, latex or epoxy coatings
- Easily washed and cleaned
- Low VOC, < 50 g/l
- OTC, CARB, SCAQMD Compliant

Tru-Glaze-WB 4438 is not suitable for immersion.

In common with all epoxy coatings Tru-Glaze-WB 4438 may chalk or discolour on exterior exposure. Rate of chalking will depend upon climatic conditions, will have no adverse effect on chemical resistance properties and will be limited to a thin surface layer.

Tru-Glaze-WB 4438 may yellow during application and cure if exposed to the combustion by-products of improperly vented fossil fuel burning heaters.

If tinting is required, use compatible waterborne colourants in Part A and mix thoroughly before Part B is added.

For best opacity, tint primers toward finish coat colour. Certain shades of yellow, orange, pink and red may require multiple coats.

For maximum gloss development, two coats of Tru-Glaze-WB 4438 are recommended. In some cases, one coat may be sufficient depending on the application method, colour used and smoothness desired.

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point.

When applying Tru-Glaze-WB 4438 by brush or roller, it may be necessary to apply multiple coats to achieve the required film build.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Suitable primers are:

Devcryl 1440
Devran 203
Tru-Glaze-WB 4015
Tru-Glaze-WB 4030
Tru-Glaze-WB 4438

For additional primer recommendations consult International Paint Protective Coatings.

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	1 US gal	1 US gal	1 US gal	1 US gal	1 US gal
	5 US gal	5 US gal	5 US gal	5 US gal	5 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	1 US gal	11.5 lb		11.5 lb	
	5 US gal	56.6 lb		56.6 lb	
STORAGE	Shelf Life	12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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