

ConoGlaze HC 222 is a two component, novolac epoxy lining system that is used to protect concrete, steel and other substrates from chemical attack. ConoGlaze HC 222 is specifically formulated for maximum resistance to heat and chemical attack typically found in flue-gas and refining applications. When used as a topcoat for ConoCrete or FibreCrete systems, ConoGlaze improves appearance and ease of cleaning.

CHARACTERISTIC

- Excellent chemical resistance in high temperatures
- NovolaK formulation
- Available in colors: 25 beige, 50 gray, 53 gray, 63 tile red, 99 white

AREA PREPARATION

Temperature of Working Area

Maintain a temperature of 50 - 85°F on air, substrate and materials during mixing, application and cure. Material temperature must be maintained between 65 - 80°F for a minimum of 48 hours prior to use. Lower temperatures will require a longer cure time. Above 80°F working time decreases.

Application in direct sunlight and/or rising surface temperature may result in blistering of materials due to entrapped air, entrained air or moisture escaping from the substrate. When surface temperatures are rising, it may be necessary to delay installation, or apply materials during cooler hours.

Surface Preparation

New Concrete - The concrete must have the necessary physical strength to withstand the imposed loads during normal use and operation. Concrete should be floated free of ridges or depressions and all voids filled with Sauereisen Underlayment No. F-120. Concrete should be sloped a maximum 1/4" to the foot for drainage.

Chemical cleaning with Degreaser 809 and/or ConoClean 704 may be neces-

sary to remove oil, grease and other contaminants that may inhibit bond of the epoxy monolithic. Abrasive blast or high pressure water blast to remove laitance and obtain a firm, uniform surface texture exposing fine aggregate resembling coarse sandpaper.

Old Concrete - Concrete must have the physical strength to withstand the imposed loads during normal use and operation. Mechanical methods should be utilized to remove old paints, protective coatings, and deteriorated concrete. Chemical cleaning with Degreaser 809 and/or ConoClean 704 may be necessary to remove oil, grease and other contaminants. Abrasive blast or high pressure water blast to remove laitance and obtain a firm, uniform surface texture exposing fine aggregate and resembling coarse sandpaper. All structural cracks should be repaired, and all slopes reestablished with Sauereisen Underlayment No. F-120.

All prepared surfaces must be allowed to thoroughly dry prior to epoxy monolithic application. Regardless of preparation method used, all surfaces must be vacuumed to remove any loose deposits or contamination.

Metal - Metal must be structurally sound as specified by architect/engineer. Mechanical methods should be utilized to remove old paints or protective coatings. Chemical cleaning may be necessary to remove oil, grease and other contaminants. All welds must be continuous, free of flux, and have a smooth rounded radius without any sharp edges. Abrasive blast to a nominal 2.5 mil profile employing SSPC SP-5 White Metal Blast for immersion conditions and SSPC SP-10 Near White Metal Blast for splash and spill or severe atmospheric environments. Recommendations for less severe environments consult a Sauereisen representative.

EXPANSION/CONTROL JOINTS

Joints are to be placed over existing expansion/control joints. Consult Sauereisen for recommendations.

APPLICATION

Mixing

Primer - ConoWeld 501/502 are recommended for concrete and other porous surfaces. ConoPrime 506 is recommended for use on metallic surfaces where flash rusting cannot be controlled.

Primers are packaged in premeasured containers consisting of Hardener and Resin which must be mixed together before use. Remix all components before combining.

Completely empty contents of Hardener Part A into Resin Part B and mix for 3 - 5 minutes with a Jiffy mixing blade affixed to a slow speed 1/2" drill motor. Primer is ready for use immediately after mixing.

ConoGlaze - Packaging consists of premeasured unitized containers of Hardener Part A and Resin Part B components. Remix components before using.

Completely empty contents of Hardener Part A into Resin Part B and mix for 3 - 5 minutes with a Jiffy mixing blade affixed to a slow speed 1/2" drill motor. Mix only complete units of material - do not mix partial batches.

Installation

Primer

ConoWeld 501/502 - Apply to concrete using a short nap adhesive roller with a nondegradable core, or nylon bristle brush. For horizontal surfaces, ConoWeld 501/502 must be allowed to cure at least two hours, but not more than 24 hours prior to application of ConoGlaze. For vertical or overhead surfaces, allow a cure of 8 - 24 hours to eliminate sagging of the ConoGlaze material. For best results, ConoGlaze should be applied when primer is slightly tacky. If recoat time exceeds 24 hours, contact Sauereisen.

ConoPrime 506- Apply to steel with a short nap adhesive roller with a nondegradable core, nylon bristle brush, or suitable airless spray equipment. Allow ConoPrime to cure approximately 8-24 hours prior to ConoGlaze application. For best results, ConoGlaze should be applied when ConoPrime is tack-free.

ConoGlaze

Roller Application- Material should be delivered to finishers immediately after mixing. Do not let mixed material remain in the mixing vessel. If application is for floor areas, spread the material with a squeegee to the desired thickness. To improve the surface texture of floor applications, lightly backroll the material with a short nap adhesive roller with a nondegradable core. For vertical application, material shall be lightly backrolled to desired thickness. All finishing and backrolling must be completed within 30 minutes from mixing.

Spray Application -

If spray application is chosen, contact Sauereisen for complete details on equipment requirements. The following equipment is typically used for spray application:

Airless Spray Pumps - SewerGard Glaze may be sprayed with a minimum 45:1 piston-primed, airless pump such as the model formerly manufactured by Graco. Alternative equipment such as the Graco 56:1 King Piston Primed Airless, Model 236-477 is also suitable. The current specification is the Graco Xtreme Sprayer X60 - MDL#X60-DH4. Remove all filters including the filter from surge tank.

Other pumps may be suitable, depending on the job site requirements.

Moisture Air Dryer - RFI Model DA-300 or equivalent. Moisture air dryer must be placed at least 50' from air compressor on air line.

Gun - Graco's Ultra-Lite pistol grip Flo-Gun, Model 235-628 is preferred. This gun must be combined with Seat Adapter Model 235-006. Alternatively, the Graco Flo-Gun Model 224-991 is acceptable.

Gun tip -Use Tip Housing Part No. XHD-001 with Graco Reversa Tips MDL No. XHD with orifices of 0.025 to 0.031 inch tip works best. Alternative brand tips may be suitable, however, never use tips that contain a diffuser pin.

Material Hose - 6 Foot whip end 3/8" i.d., 5,000 psi working pressure, 16,000 psi burst pressure.
0-25 Foot overall, 1/2" i.d., 4,000 psi working pressure, 16,000 psi burst pressure.
25-75 Foot overall, 3/4" i.d., 4,000 psi working pressure, 16,000 psi burst pressure

Air Compressor - Minimum 100 cubic foot per minute at 100 psi.
Air Hose - 3/4" - 1" i.d.; 100 foot maximum length to mastic pump.

To prevent sagging on vertical surfaces, the required coverage should be applied in two equal coats. Application should be done with a 50% overlap in a "cross hatch" pattern to reduce the possibility of pinholes and to assure complete coverage. If recoat time exceeds 24 hours, contact Sauereisen.

COVERAGE

ConoWeld - 200 ft² per gallon at 8 mils.
ConoPrime - 400 ft² per gallon at 4 mils.
ConoGlaze - 160 ft² per gallon at 10 mils.

All coverage rates are theoretical and will vary depending upon surface conditions, porosity, application techniques and specific project conditions.

CLEAN UP

All equipment should be cleaned with acetone, xylene or MEK before ConoWeld, ConoPrime or ConoGlaze material cures.

SETTING/CURING

Do not allow water, chemicals or traffic on the ConoGlaze for a minimum of 24 hours at 70°F. For harsh chemical or physical environments allow a minimum of 72 hours at 70°F prior to exposure.

PACKAGING

Unit Size	Part A	Part B
1 gallon	1 gal can	1 gal can
3 gallon	1 gal can	3.5 gal pail
5 gallon	2 gal pail	6 gal pail

Containers are filled by weight, not volume. Container size does not indicate volume of contents.

SHELF LIFE

ConoGlaze Hardener, and Resin have a shelf life of six (6) months when stored in unopened, tightly sealed containers in a dry location at 70°F. If there is a doubt as to the quality of the materials, consult a Sauereisen representative.

CAUTION

Consult Material Safety Data Sheets and container label caution statements for any hazards in handling this material.

WARRANTY

We warrant that our goods will conform to the description contained in the order, and that we have good title to all goods sold. WE GIVE NO WARRANTY, WHETHER OF MERCHANTABILITY, FITNESS FOR PURPOSE OR OTHERWISE, EXPRESS OR IMPLIED, OTHER THAN AS EXPRESSLY SET FORTH HEREIN. We are glad to offer suggestions or to refer you to customers using Sauereisen cements and compounds for a similar application. Users shall determine the suitability of the product for intended application before using, and users assume all risk and liability whatsoever in connection therewith regardless of any suggestions as to application or construction. In no event shall we be liable hereunder or otherwise for incidental or consequential damages. Our liability and your exclusive remedy hereunder or otherwise, in law or in equity, shall be expressly limited to our replacement of nonconforming goods at our factory or, at our sole option, to repayment of the purchase price of nonconforming goods.