

SAUEREISEN

CONOGLAZE - EPOXY NOVOLAK NO. 228

ConoGlaze - Epoxy NovolaK No. 228 is a chemically-resistant, 100% solids, epoxy novolak coating system. It is used as a topcoat for Sauereisen ConoCrete or FibreCrete systems or as a coating to protect concrete and steel from chemical attack.

ConoGlaze may be used in many kinds of manufacturing, processing, storage, and shipping areas. It is specifically formulated as a sealer to resist strong oxidizing environments, especially high concentrations of sulfuric acid. This material can be applied by roller or spray and provides an economical protective barrier against processing chemicals and higher temperatures.

The ConoGlaze system utilizes Sauereisen ConoWeld No. 501 as a bond enhancing primer for applications over concrete and steel.

CHARACTERISTICS

- Excellent resistance to sulfuric acid.
- Authorized by USDA for use in federally inspected meat and poultry plants.
- Easy to clean surface.
- Colors: 53 gray, 63 tile red.

AREA PREPARATION

Temperature of Working Area

For optimum conditions, maintain a temperature of 60°-85°F on air, substrate, Liquid, and Hardener components during mixing, application, and cure.

The monolithic components should be maintained at 65°F to 80°F for 48 hours prior to beginning work.

At temperatures below 65°F, the application becomes more difficult and curing is retarded. Above 80°F, the material working time decreases.

PHYSICAL PROPERTIES

Application time (ASTM C-308 modified)	
Working time at 70°F	30 minutes
Components	2 part
Thickness	10 mils
Bond strength to concrete (ASTM D-4541)	Concrete failure
Maximum service temperature (Dry)	180°F (82°C)

Physical properties were determined on specimens prepared under laboratory conditions using applicable ASTM procedures. Actual field conditions may vary and yield different results; therefore, data are subject to reasonable deviation. Data should not be used for specification purposes.

Application in direct sunlight and rising surface temperature may result in blistering of the materials due to expansion of entrapped air or moisture in the substrate. In rising temperatures it may be necessary to postpone the application or apply during cooler hours.

Surface Preparation

Metal - Abrasive blast to a nominal 2.5 mil profile employing SSPC-SP5 White Metal Blast for immersion and SSPC-SP10 for other service conditions. All welds must be continuous, free of flux and have a smooth rounded radius without any sharp edges.

Concrete - Refer to SSPC-SP13/NACE 6 "Surface Preparation of concrete" for detailed guidelines.

Surfaces should be free of oil, grease, water, and other contaminants that may inhibit bond. This can be achieved by chemical cleaning.

New Concrete - All structures must have the necessary strength to withstand imposed loads during normal use and operation. Surface should be floated free of ridges or depressions and all voids filled with Sauereisen Underlayment No. F-120 or No. 209 Filler Compound. The choice of underlayment will depend on the severity of the voids to be filled. Surfaces should be sloped a maximum 1/4 inch per foot for drainage.

Abrasive blast, high-pressure water blast, or acid etch concrete to remove laitance and obtain uniform surface texture exposing fine aggregate resembling coarse sandpaper.

Old Concrete - Concrete must be dry, firm and must have the necessary strength to withstand imposed loads during normal use and operation. Mechanical methods should be utilized to remove old paints, protective coatings, and deteriorated concrete.

Abrasive blast, high-pressure water blast, or acid etch concrete to remove laitance and to obtain a uniform, sound substrate.

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

EXPANSION/CONTROL JOINTS

Joints are to be placed over existing expansion joints, around all fixed objects, peripheries of rooms and all points of movement in the base slab. Consult Sauereisen for recommendations.

APPLICATION

ConoWeld No. 501 is the epoxy primer recommended for metal, concrete and other porous substrates. Apply ConoWeld prior to the ConoGlaze installation to enhance bond strength.

Mixing

Primer - ConoWeld primer is supplied in premeasured containers. Remix individual containers before using.

Packaging of Primer No. 501 consists of Hardener Part A and Resin Part B which must be mixed together. Completely empty contents of Hardener Part A into Resin Part B container. Using a slow speed 1/2 inch drill motor with a "Jiffy" type blade, mix thoroughly until blended for three minutes. Primer is ready for use immediately after mixing.

ConoGlaze - Packaging consists of pre-measured unitized containers of Hardener Part A and Resin Part B. Remix Part A and B before combining.

Completely empty contents of Hardener Part A into Resin Part B. Using a slow speed 1/2 inch drill motor affixed with a "Jiffy" type blade, mix three to five minutes until thoroughly blended.

Mix only complete batches. Material which has begun to set must be discarded. Do not add any solvent, additive, or adulterant to any component or mixed material.

Installation

Primer - Apply primer to concrete or steel using either a short nap adhesive roller with a nondegradable core, or a nylon bristle brush. For horizontal applications, pour primer onto the surface and spread with a squeegee before backrolling or brushing.

ConoWeld may also be sprayed using airless spray equipment. Typical application thickness is 5-10 mils. Consult Sauereisen for specific details.

Prior to application of the Sauereisen epoxy topcoat, inspect the primed surface for voids, bubbles or defects that may result in blistering or pinholes in the lining. Repair with Sauereisen Filler Compound No. 209 Fast Set to ensure a sealed surface.

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Roller application - Material should be delivered to finishers immediately after mixing. Do not let 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 - ConoGlaze may be spray applied at a thickness of approximately 10 mils per coat. Installation by airless spray should be done with a 50% overlap in a "cross hatch" pattern to reduce the possibility of pinholes and to assure complete coverage. Recoat times shall not exceed 24 hours at 70⁰ F.

Measures such as water traps, dryers, or filters should be used to prevent pump freeze up.

After ConoGlaze has sufficiently cured, a holiday detector should be utilized to ensure a continuous pinhole-free lining. Consult a Sauereisen representative for details.

The following equipment is typically used for spray application:

Airless Spray Pumps - ConoGlaze 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 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' whip end, 3/8" i.d.; working pressure 5,000 psi, 16,000 psi burst.

Material hose - 0-25' overall, 1/2" i.d.; working pressure 4,000 psi, 16,000 psi burst.

Material hose - 25-75' overall, 3/4" i.d.; working pressure 4,000 psi, 12,000 psi burst.

Air compressor - 180 ft³ per minute at 100 psi, minimum.

Air hose from compressor - 3/4" to 1" i.d.: 100' maximum length to mastic pump.

COVERAGE

ConoWeld	200 ft ² per gal. at 8 mils
ConoGlaze	160 ft ² per gal. at 10 mils

Coverage is theoretical and will vary depending upon surface conditions, porosity, application techniques and specific project conditions.

SETTING/CURING

Do not allow water or chemicals on the material surface for a minimum of 24 hours. For harsh chemical or physical environments cure a minimum of 72 hours prior to exposure.

PACKAGING

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

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

CLEAN-UP

All equipment should be cleaned with MEK before material cures. If removal is required after cure, consult Sauereisen for specific recommendations.

SHELF LIFE

ConoGlaze and ConoWeld have a shelf life of one (1) year when stored in unopened, tightly sealed containers in a dry location at 70°F. Avoid freezing. 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 hazards in handling these materials.

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.

- **Distributors and agents in major cities throughout the world. Consult manufacturer for locations.**
- **Information concerning government safety regulations available upon request.**
- **Sauereisen also produces inorganic compounds for assembling, sealing, electrically insulating and grouting.**

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