



CONOGLAZETM - CHEMICAL & FOOD GRADE NO. 202

ConoGlaze™ - Chemical and Food Grade No. 202 is a chemically-resistant, 100% solids, epoxy 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 to resist food acids, fats and oils. This material can be applied by roller or spray and provides an economical, protective barrier against processing chemicals and harsh cleaning solutions.

ConoGlaze™ - Chemical and Food Grade No. 202 conforms to USDA regulations for use in federally inspected meat and poultry plants.

CHARACTERISTICS

- Excellent resistance to food acids and by-products.
- Easily cleaned surface.
- Colors available in 25 beige, 50 light gray, 53 gray, 63 tile red, 99 white.

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.

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.

PHYSICAL PROPERTIES

Application time (ASTM C-308 modified)	
Working time at 70°F	30 minutes
Bond strength to concrete (ASTM D-4541)	Concrete failure
Components	2 parts
Maximum service temperature (Dry)	150°F (65°C)
Thickness	10 mils (0.25 mm)

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.

Surface Preparation

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

New Concrete - All structures must have the necessary strength to withstand imposed loads during normal use and operation. The surface should be floated free of ridges or depressions. Fill any voids 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.

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

Abrasive blast, high-pressure water blast, or acid etch the 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 - Primer is packaged in premeasured containers consisting of Hardener Part A and Resin Part B which must be mixed together before use. Remix the Part A and Part B before combining.

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 3 - 5 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

ConoWeld™ No. 501

Apply primer to concrete or steel using a short nap adhesive roller with a non-degradable core or a nylon bristle brush. Consult Sauereisen for spray recommendations. At 70°F, primer must be allowed to cure at least eight hours, but no longer than 24 hours, prior to application of ConoGlaze. If recoat time exceeds 24 hours, consult Sauereisen.

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

ConoGlaze™ No. 202

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 non-degradable core. For vertical application, material shall be lightly backrolled to desired thickness. All finishing and back-rolling 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 70°F.

After ConoGlaze™ has sufficiently cured, a holiday detector may 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 hoses -

- ◆ 6' whip end, 3/8" i.d.; working pressure 5,000 psi, 16,000 psi burst.
- ◆ 0-25' overall, 1/2" i.d.; working pressure 4,000 psi, 16,000 psi burst.
- ◆ 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.

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

COVERAGE

ConoWeld™ 200 ft² per gallon at 8 mils
ConoGlaze™ 160 ft² per gallon 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 gal. can	1 gal. can
3 gallon	1 gal. can	3.5 gal. can
5 gallon	2 gal. pail	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 a specific recommendation.