SAUEREISEN

FAST-TRAK GLAZE SERIES

PHYSICAL PROPERTIES

Fast-Trak NovolaK Glaze No. 229		Fast-Trak VE Glaze No. 473
30 minutes	Working time at 70ºF	30 minutes
Concrete failure	Bond strength to concrete (ASTM D-4541)	Concrete failure
2	Components	2
180ºF (82ºC)	Maximum service temperature	250ºF (121ºC)
10 mils, 100% solids	Thickness (WFT)	10 mils, 70% solids

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.

The Sauereisen Fast-Trak Glaze Series is a coating system specifically designed to protect concrete, steel or masonry surfaces in the pulp & paper industry. Fast-Trak has the chemical resistance to withstand bleaches, liquors and other corrosive substances that attack unprotected trenches, sumps and chests in paper mills. Depending on the chemical and temperature environment, Fast-Trak is available in either vinyl ester or novolak epoxy formulations which are used with an appropriate Sauereisen Primer.

A monolithic coating applied by airless spray, the Fast-Trak system may be used to restore deteriorated tile linings that would otherwise require extensive demolition, repointing and replacement. Downtime of the Fast-Trak installation is minimized by the ability to coat existing tile structures with a uniform thickness of corrosion-resistant material. Since spray installations proceed at a much quicker rate than repointing or construction by the tile setter's method, pulp & paper infrastructure can return to service in a fraction of the time and provide a seamless lining.

Fast-Trak is also ideal for new construction because it eliminates the possibility of disbonded tile falling into liquors and subsequently damaging plant equipment.

CHARACTERISTICS

- ☐ An installation-friendly alternative to tile linings.
- ☐ Available in vinyl ester or novolak epoxy formulations.
- ☐ Fast chemical set - less down time.
- ☐ Low porosity.
- ☐ An economical coating to be used independently or as a glossy topcoat for the Fast-Trak fiber-filled linings.

AREA PREPARATION

Temperature of Working Area

Maintain a temperature of 60º-85ºF on air, substrate, Hardener and Liquid components during mixing, application and cure. The monolithic components and substrate should be maintained at 65ºF to 80ºF for 48 hours prior to beginning work.

At temperatures below 60ºF, the application becomes more difficult and curing is retarded. Above 85ºF, the working time decreases.

It is recommended that the components be stored in a cooler area prior to mixing. Shading the substrate and using ice water to cool mixing equipment is not uncommon. In extreme temperatures it may be necessary to postpone the application or to apply during cooler hours.

Surface Preparation

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

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

New Concrete - Abrasive blast, high-pressure water blast, or acid etch concrete to remove laitance and obtain uniform surface texture. Voids should be filled with an appropriate Sauereisen substrate repair material.

Old Concrete - Concrete must be dry, firm and structurally sound as specified by the architect/engineer. All structural cracks should be repaired using FastPatch No. 149 and all voids repaired using Sauereisen Underlayment No. F-120, Epoxy Filler Compound No. 209, or Vinyl Ester Mortar No. 400 depending on service conditions.

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

If abrasive or high pressure water blasting is used as the method of surface preparation, all sand and/or debris must be removed by thoroughly vacuuming the area with an industrial vacuum cleaner. If surface does not have desired characteristics, repeat surface preparation procedure.

Existing Tile - Removal of all loose tile is recommended prior to the lining application. In cases where damaged tile may be refurbished, contact Sauereisen regarding back-filling procedures with epoxy grout.

Abrasive blast to provide a profile and to remove deteriorated concrete and loose mortar. Thoroughly vacuum all blast media.

In applications subject to service temperatures less than 180ºF, re-point mortar joints flush with the tile surfaces using Epoxy Filler Compound No. 209. For higher temperature applications, joint repair may be accomplished with Vinyl Ester Mortar No. 400. Large voids resulting from disbonded tile may be filled with Underlayment No. F-120 Trowelable.

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 or be ground flat without any sharp edges or protrusions.

APPLICATION

There are four bond-enhancing primers recommended for use when Fast-Trak Glaze is applied directly to concrete, metal or tile substrates. ConoWeld No. 501 is an epoxy primer to be used with Fast-Trak NovolaK Glaze. Two primers used with Sauereisen Fast-Trak VE Glaze include Hi-Temp Primer No. 560, a single component moisture-cured urethane, and VEPrime No. 550, a general vinyl ester primer.

SparkPrime No. 562 is specified over concrete and tile for projects in which spark testing is utilized. See the section entitled "Holiday Detection" within this bulletin for details.

Mixing

Components of the Fast-Trak Glazes and two-part primers are packaged in pre-measured containers consisting of Hardener Part A and Resin Part B which must be mixed together before use. Individual components should be remixed before combining. The following procedures are applicable to the mixing of the multi-component Linings and Primers:

Completely empty contents of Hardener Part A into Resin Part B container. Using a slow-speed drill motor with a "Jiffy" type blade, mix for a minimum of 3 minutes until thoroughly blended.

Mix only complete batches. Material which has begun to set must be discarded. Do not try to retemper the material.

Installation

Primer - Apply primer to a thickness of 5 to 10 mils using specified airless spray equipment or a short nap roller with a non-degradable core. The Fast-Trak Glaze should be applied while the 501 and 550 primers are tacky. If Sauereisen Hi-Temp Primer No. 560 is used, apply at 5-6 mils on concrete or tile and 3-5 mils on steel. Allow No. 560 to fully cure before topcoating. For more information on Sauereisen primers, consult the specific product data sheet.

Fast-Trak Glaze - The monolithic coating is recommended to be applied by spray to allow for a more easily regulated thickness and to speed the installation process.

Spray installation should be done in coats of 10 mils thick. A single coat of the Fast-Trak Glaze is suitable for most applications. When applying multiple coats, allow four hours between coats at 70ºF.

If 24 hours elapse between the application of a coat, sand the surface, solvent wipe and remove any debris prior to recoating. Application should be done with a 50% overlap in a "cross hatch" pattern to reduce the possibility of pinholes and to assure complete coverage. After Fast-Trak has sufficiently cured, a holiday detector should be used to ensure a continuous, pin-hole free lining.

The following equipment is typically used for spray application.:

Mastic pump - Fast-Trak Glaze may be sprayed with a minimum 45:1 piston-primed, airless pump such as the model formerly manufactured by Graco. The current specifications for new equipment is the Graco 56:1 King Piston Primed Airless, Model 236-477. Remove filter from surge tank. Remove cage above lower ball valve located near "foot" (lower end) of pump. Other pumps may be suitable, depending on job site requirements.

Gun - Graco Pistol-Grip Flo Gun, Model 224-991.

Gun tip - Graco Reverse-a-Clean™ housing part No. 222-674 with 0.039" orifice, Model GHD-539. The diffuser should be removed prior to use.

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 ft^3 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 No. 501

200 ft^2 per gallon at 8 mils.

VEPrime No. 550

267 ft^2 per gallon at 6 mils wet film thickness, resulting in a dry thickness of approximately 3 mils.

Hi-Temp Primer No. 560
320 ft^2 per gallon at 5 mils wet film thickness resulting in a dry thickness of approximately 3 mils.

SparkPrime No. 562
320 ft^2 per gallon at 5 mils wet film thickness, resulting in a dry thickness of approximately 3 mils.

Fast-Trak VE Glaze No. 473
160 ft^2 per gallon at 10 mils wet film thickness, resulting in a dry thickness of approximately 7 mils.

Fast-Trak NovolaK Glaze No. 229
160 ft^2 per gallon at 10 mils.

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

HOLIDAY DETECTION

Spark testing is recommended to assure the quality of an application. A holiday detector will confirm complete coverage of the coating system and identify any pinholes that must be repaired.

Sauereisen offers SparkPrime No. 562 for projects that include spark testing as a control measure. The conductive primer will replace ConoWeld No. 501, VEPrime No. 550 or Hi-Temp Primer No. 560 in these cases.

SparkPrime is a single-component, moisture-cured urethane resistant to 400ºF. It promotes excellent bond strength for epoxy and vinyl ester materials over concrete and tile. The SparkPrime contains carbon black that provides conductivity beneath the coating system which is necessary for holiday detection. Grounding strips should be placed 16 feet apart within the conductive primer.

Conductive Primer Application
Sauereisen SparkPrime No. 562 may be applied by roller or spray. No mixing is required, simply shake the single component container prior to opening. Appropriate ventilation and/or respiratory equipment is recommended.

A dry film thickness in the range of 3-5 mils should be attained. Excess thickness will adversely effect the cure. To attain the proper dry thickness, application of five mils wet is suggested. Apply the primer using specified airless spray equipment or a short nap roller with a non-degradable core. If material within the container forms a skin, cut out the residue, stir and transfer Primer into a clean pail.

SparkPrime No. 562 will dry to the touch in approximately 45 minutes to one hour at 70ºF. Recoating should occur no sooner than two hours after application, but within six hours.

SYSTEM SETTING & CURING

By properly maintaining air and substrate temperatures, the Fast-Trak Glazes can be cured to meet production scheduling. Contact Sauereisen regarding specific curing parameters.

PACKAGING

ConoWeld No. 501

Unit Size	Part A	Part B
1 gallon	1/2 gal. can	1 gal. can
3 gallon	2 gal. pail	3.5 gal. pail

VEPrime No. 550

Unit Size	Part A	Part B
1 gallon	1 - 2 oz. bottle	1 gal.can

Hi-Temp Primer No. 560
Unit Size
1 gallon, approximately 8.5 lbs.

SparkPrime No. 562
Unit Size
1 gallon, single component, approximately 8.5 pounds per can.

Fast-Trak VE Glaze No. 473

Unit Size	Part A	Part B
1 gallon	1 - 2 oz. bottle	1 pail
3 gallon	1 - 4 oz. bottle	1 pail

Fast-Trak NovolaK Glaze No. 229

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	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 by scrubbing with a stiff brush and MEK or MCT (Monochlorotoluene) at the end of each working period or when build-up becomes pronounced.

SHELF LIFE

Sauereisen Fast-Trak VE Glaze, VEPrime, Hi-Temp Primer, and SparkPrime have a shelf life of three months when stored in unopened, tightly sealed containers in a dry location at 70ºF. Under the same conditions, Fast-Trak NovolaK Glaze and ConoWeld Primer have a shelf life of one year.

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.**

SAUEREISEN ... since 1899

160 Gamma Drive
Pittsburgh, PA 15238-2989 USA
Phone 412/963-0303 Fax 412/963-7620
www.sauereisen.com