



PRODUCT PROFILE

GENERIC DESCRIPTION Inorganic Hybrid Water-Based Epoxy

COMMON USAGE An advanced generation, low odor, low VOC, high solids, water-based epoxy coating for filling surface voids in porous concrete and masonry block in interior and exterior environments. Provides high bond strength, fast curing, and rapid overcoating capabilities and can be topcoated with a variety of water- and solvent-based coatings.

COLORS 1202 Off White

FINISH Flat

SPECIAL QUALIFICATIONS Series 1254 is protected under U.S. Patent No. 7,435,449 B2

COATING SYSTEM

TOPCOATS Series 6, 30, L69, L69F, N69, N69F, V69, V69F, 84, 113, 114, 115, 156, 157, 158, 180, 181, 201, 273, 280, 287, 290, 297, 1028, 1029, 1080, 1081

SURFACE PREPARATION

NEW CONCRETE & CMU Allow mortar to cure for 28 days. Prepare in accordance with SSPC-SP13/NACE 6 to level protrusions and mortar spatter and remove other contaminants.

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 100% (mixed)

CURING TIME

Temperature	To Touch	To Recoat
75°F (24°C)	30 minutes	4 hours

Curing time varies with surface temperature, air movement, humidity and film thickness. Substrates containing integral water repellents can prolong cure times.

VOLATILE ORGANIC COMPOUNDS 0.01 lbs/gallon (1 grams/litre)

HAPS 0.01 lbs/gal solids

THEORETICAL COVERAGE 1,604 sq ft/gal (39.4 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Two: Part A and Part B

MIXING RATIO By volume: Two (Part A) to one (Part B)

PACKAGING KIT CONSISTS OF:

	PART A (Partially Filled)	PART B (Partially Filled)	Yield (mixed)
Large Kit	3.5 gal pail	6 gal pail	5 gallons
Small Kit	2 gal pail	3 gal pail	2 gallons

NET WEIGHT PER GALLON 14.81 ± 0.25 lbs (6.72 ± .11 kg)

STORAGE TEMPERATURE Minimum 35°F (2°C) Maximum 110°F (43°C)
Protect from freezing.

TEMPERATURE RESISTANCE (Dry) Continuous 180°F (82°C) Intermittent 250°F (121°C)

SHelf LIFE 6 months at recommended storage temperature.

FLASH POINT - SETA Part A: 145°F (63°C) Part B: 105°F (41°C)

HEALTH & SAFETY Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

EPOXOBLOCK WB® | SERIES 1254

APPLICATION

COVERAGE RATES **Dense Substrate (Concrete and Masonry):** From 100 to 150 sq ft (9.3 to 14.0 m²) per gallon.
Porous Substrate (Lightweight Block and CMU): From 75 to 100 sq ft (7.0 to 9.3 m²) per gallon.
 Allow for surface irregularities. There is no method for accurately measuring the applied film thickness of block fillers. Application of coating below minimum or above maximum spreading rate recommended may adversely affect coating performance.

MIXING Power mix contents of each container, making sure no pigment remains on the bottom. Add the contents of the can marked Part A to Part B while under mechanical agitation. During mixing, scrape the container wall to aid in complete blending of the two components. Continue agitation until the two components are thoroughly mixed. Thin by volume and thoroughly mix. Do not use mixed material beyond pot life limits. **Note:** Both components should be above 50°F (10°C) prior to mixing.

THINNING Use cool, clean tap water. For airless spray, roller or brush applications, thin 10% to 15% or 3/4 pint to 1-1/4 pints (380 to 570 mL) per gallon. **Caution: Thinning with high temperature water will significantly reduce the pot life. For best results, water temperature should not exceed 80°F (27°C).**

POT LIFE 2 hours at 70°F (21°C) 1 hour at 85°F (29°C)

APPLICATION EQUIPMENT

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.019"-0.023" (483-584 microns)	3000-4500 psi (207-310 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions. **Note:** Backroll material immediately after spray application to force material into voids and hairline cracks.

Roller: Use a synthetic woven nap cover. For smooth surfaces use 3/8" to 1/2" (9.5 mm to 12.7 mm). To obtain proper penetration for rough or porous surfaces, use a longer nap cover. Force material into voids and hairline cracks with a brush or squeegee. Smooth out build-up at laps.

Brush: Use a stiff nylon brush. Work material into voids and avoid brushing out too thin.

SURFACE TEMPERATURE Minimum 40°F (4°C), optimum 65°F to 80°F (18°C to 27°C), maximum of 120°F (49°C). The substrate temperature should be at least 5°F (3°C) above the dew point. Coating will not cure below minimum surface temperature.

MATERIAL TEMPERATURE For optimum application and handling, the material temperature during application should be between 70°F and 85°F (21°C and 29°C). Temperature will affect the workability. Cool temperatures increase viscosity and decrease workability. Warm temperatures will decrease viscosity and shorten pot life.

CLEANUP Flush out and clean all equipment immediately after use with water, followed by a final flush with MEK or Methyl Acetate.

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