

## VFI®-4385 82 D FORM COATING EPOXY

VFI-4385 Form Coating Epoxy is an 82 D coating with high rigidity and enough flexibility for casting concrete or other cementitious products over EPS, wood, and steel surfaces. An epoxy coating is an alternative to the VFI-2100 urethane molding rubber series or urethane form coatings like VFI-2538 70 D EPS Form Hard Coat. A low viscosity allows for easy mixing and application in 20 mil passes using a roller or brush. The coating will self-level, providing a uniform casting surface that can also be sanded to a desired finish.

- Flexible and will not crack or deform
- Hard enough to be sanded for a uniform surface
- Extended pot life allows for easy application with a roller
- Not moisture sensitive and can go over damp surfaces
- Adheres to EPS, wood, and steel

PHYSICAL PROPERTIES	TEST METHOD	TEST RESULTS
Hardness Shore D	ASTM D 2240	82 ± 2
Tensile Strength	ASTM D 412	6,200 psi
Elongation	ASTM D 412	12%
Specific Volume	N/A	67.25 lb/ft <sup>3</sup>
LIQUID PROPERTIES	TEST METHOD	TEST RESULTS
Solids by Weight	ASTM D 1644	100%
Solids by Volume	ASTM D 2697	100%
Liquid Density A Side	ASTM D 2939	9.36
Liquid Density B Side	ASTM D 2939	8.25
Mixed Liquid Density	ASTM D 2939	9.00
Specific Gravity A Side	N/A	1.12
Specific Gravity B Side	N/A	0.99
Specific Gravity Mixed	N/A	1.08
Ratio by Volume (A:B)	N/A	2A:1B
Ratio by Weight (A:B)	N/A	100A:44B
Viscosity A Side	ASTM D 2196	1300 cps
Viscosity B Side	ASTM D 2196	380 cps
Mixed Viscosity	ASTM D 2196	700 cps
Pot Life	N/A	28 min
Gel Time	N/A	32 min
Cure Time	N/A	6 hours
Place into Service	N/A	16 hours
Recoat Window	N/A	24 hours
Full Cure	N/A	4-5 days
VOC	N/A	0 g/L

**MANUFACTURER OF HIGH PERFORMANCE POLYMERS**

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## THICKNESS REQUIREMENTS

The coating can be applied in a minimum of 20 mil passes with a maximum thickness of about a quarter inch.

## STORAGE/SHELF LIFE

The product has a shelf life of 6 months from the date of manufacture. It should be stored in a dry, temperature-controlled space between 60°F - 90°F.

## SURFACE PREPARATION

For ensured adhesion, all surfaces must be clean and free of contaminants, including dirt, dust, and debris. Oil and grease must be removed by scrubbing with a cleaning detergent and rinsing with water.

- EPS - Ensure that EPS foam has been aged for at least 30 days. Foam between 1 and 3 PCF is acceptable, but for optimal cost-to-quality ratio, we recommend 2 PCF foam. Once clean and dry, VFI-4385 can be applied directly to the surface.
- Wood - The surface should be clean, relatively dry, and sanded for good mechanical adhesion.
- Steel - The surface must be cleaned by roughly sanding or sandblasting to SP6 to remove all rust, mill scale, dirt, and other contaminants.

## MIXING

Before combining the A and B sides, premix the Hardener (B side) until a uniform mix is achieved. The Epoxy (A side) does not need to be premixed.

Pour the measured B side into the measured A side and mix them until uniform. Transfer the mixture to a new container and mix again before use.

## APPLICATION GUIDELINES

VFI-4385 can be applied by brush or roller to EPS, wood, and steel surfaces. For additional recoats, a good surface profile is required, so the cured coating must be sanded between each application. Also, ensure the surface is clean, free of concrete dust, and dry.

## PRECAUTIONS

The material is toxic when inhaled, swallowed, or in contact with skin. If you are experiencing any symptoms, call a poison center or doctor immediately. Wear all necessary PPE to avoid prolonged exposure, including adequate full-face respiratory equipment. Avoid breathing in vapors or repeated skin contact. Do not add foreign material to the product. See Safety Data Sheet for complete safety data.