

MANUFACTURER OF HIGH PERFORMACE POLYMERS

800-307-9218

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 ³

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 Garvity 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

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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 $60^{\circ}F - 90^{\circ}F$.

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.

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