



FEATURES

: PENETRATING SEALER is a high solid epoxy 2-pack chemically cured. It is designed as excellent adhesion and penetrat on concrete, green concrete, floor hardener, ceramic tile, excellent adhesion, toughness, hardness, water resistance film coating.

: As a primer for concrete, green concrete, floor hardener, fiberglass, wood and ceramic tile

TECHNICAL INFORMATION

Type	: Epoxy / Polyamide Primer
Color	: Clear Red
Film appearance	: Semi-Gloss
Specific gravity	: 1.06 ± 0.05
Solid by volume	: 100 %
Flash point	: 42 °C

		Minimum	Maximum	Recommended
Dry film thickness	(Microns)	50	100	50
Wet film thickness	(Microns)	50	100	50
Theoretical coverage.	m ² / Liter	20.0	10.0	20.0
	m ² / Gallon	75.7	37.9	75.7
Practical coverage.	m ² / Liter	13.0	6.5	13.0
	m ² / Gallon	49.0	24.6	49.0

Remark : Actual Surface coverage will depend on surface irregularities, Mixing, Application Condition method and technique; as well as the structure and dimensions of the object to be coated.

		25 °C	30 °C	35 °C
Touch dry	Surface dry	4.5 hrs.	4 hrs.	3.5 hrs.
	Hard dry	6.5 hrs.	6 hrs.	5.5 hrs.
Full cure	Minimum	10 hrs.	9 hrs	8 hrs.
	Maximum	-	-	-
Potlife		2 hrs.	2 hrs.	1.5 hrs.

Remark : Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly.

FILM PERFORMANCE

Properties	Test Method	Criteria	Results
Adhesion	ASTM D 3359	5B	Passed
Flexibility	ASTM D 522 (Method B)	3 mm	Passed
Impact Test	ASTM D 2794	60 inch-pounds	Passed
Abrasion Resistance	ASTM D 4060	200 mg (Loss)	Passed
	<small>CS-17 Wheels, 1000 g load, 1000 cycles</small>		
Chemical Resistance	ASTM D 1308	24 hrs.	Passed

APPLICATION

Mixing Ratio	Part A	Part B
By Volume	2.2	1
By Weight	70	30



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Application Method	Airless Spray	Air Spray	Brush / Roller
Diluted by TOA Thinner 31	-	15-20	10-15
Applicator	-	Coventional Spray (Iwata)	Short Hair Stiff Nylon Roller (Stanley) Stiff Nylon Brush
Pressure	-	3-4 kg/cm ²	-

Mix Part A and Part B, strictly follow mix ratio recommendations before dilute by Thinner mixing and stir for 2-3 minutes until the mixture is homogeneous after leave 5 minutes before application.

APPLICATION SYSTEM

Surface Preparation

Wall & Floor

: For New concrete - The concrete prior to laying plastic sheets to block moisture from underground. Then it should be left for curing concrete to solid and dry for about 3-4 weeks. Then, clean the surface free from dust, dirt, grease and most importantly, the surface is completely dry.

(Check moisture content must be less than 10%)

: For Old concrete - To remove the old paint film which loosely adhesion to as much as possible by Scraping with a shovel or Grinding machine to enhance adhesion. Then, clean the surface free from grease and oil with suitable solvent. Before primer coating should clean all surfaces free from dust, dirt, grease and most importantly, the surface is completely dry. (Check moisture content must be less than 10%).

: For Floor Hardener or Surface glossy finish :

: Concrete surface preparation by using dust free captive blasting units, grinding equipment, sand blasting for increase adhesion of coating.

: Inspect the concrete for bug holes void, fin and other imperfections. Protrusions shall be ground smooth while voids shall be filled with Floorguard Putty or other suitable filler and polishing of surface with moltoprene disk.

: After cleaning, repair surface defects and remove deteriorated previous coatings. (Check moisture content must be less than 10%).

Before Recoat by Topcoat

: Remover all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP1, Solvent Cleaning before coating.

: If over 7 days gives cleaning surface by sand paper no. 320-400 and cleaning surface per SSPC-SP1, Solvent Cleaning before coating.

: Surface repaire (cracks, pores, holes) done with TOA Epoxy putty (for Wal) or Floorguard Putty (for Floor)and polishing of surface with moltoprene disk.

Paint System (Dry Film Thickness)

Concrete protective Coating
For Wall

: Primer	Penetrating Sealer	50 microns x 1 coat
: Topcoat	Epoguard Enamel (for inside area) or Topguard (for outside area)	50 microns x 2 coats

