

# The Strong Company, Inc.

## Strong-Seal® Epoxy

**INTENT:** To provide the maximum corrosion protection, in conjunction with Strong-Seal® Profile Mix, to manholes, wet wells, lift stations and other concrete and masonry structures in sewage collection and treatment systems.

Strong-Seal® Epoxy is a 100% solids, zero-VOC coating system designed to protect against corrosion when microbiologically induced corrosion is expected to produce pH levels of 1.0 or below.

- A. Compressive strength  
ASTM D695  
> 8000 psi
- B. Tensile strength  
ASTM D638  
> 7700 psi
- C. Flexural strength  
ASTM D790  
> 12,400 psi
- D. Pull-off strength.  
ASTM D4541  
>350 psi
- E. Volatile organic compounds  
ASTM D2584  
0%
- F. Durometer hardness Type D  
ASTM D2240  
Shore D-70
- G. Moisture absorption  
ASTM C413  
>0.03%

### **PACKAGING**

900 ml dual cartridge kits  
15 gallon kits

### **THEORETICAL COVERAGE**

40 sq. ft. @ 40 mils thickness

### **APPLICATION METHODS**

Plural-component airless spray  
Strong-Seal cartridge hydraulic gun  
Single-pump "hot pot" system

### **SURFACE PREPARATION**

Strong-Seal® Epoxy is formulated for application over Strong-Seal® Profile Mix. Profile Mix should be allowed to cure for a minimum of 48 hours before Epoxy application. Surface should be inspected and any accumulated oil, grease, dirt or other contaminants should be removed prior to Epoxy application. Refer to mixing, application and curing instructions for Strong-Seal® Profile Mix.

### **APPLICATION**

Application temperatures, air, surface and material, should be a minimum of 50° F and a maximum of 90° F. No application shall be made if freezing is expected within 24 hours after application. Application equipment shall be Xtreme Model 185, Model HSS or equivalent equipment as approved by Strong-Seal® Systems. Epoxy will be applied in light coats to a minimum dry mil thickness of 40 mils. A Strong-Seal® approved thickness gauge can be used to confirm film thickness. Use Xylene or R2K4 for clean-up.

### **CURE TIMES**

Drying schedule at 40 mils wet film thickness, 73°F and 60% RH: to touch: 8 hours; to recoat: minimum of 10 hours, maximum of 36 hours. If recoat time exceeds 36 hours, surface shall be abraded before recoating. Complete cure: 7 days.

### **PRODUCT TESTING**

The Strong-Seal® Epoxy applicator shall label two retained plaques with pertinent and unique identification for each project and spray one side for submission of the sample to the owner and one sample to Strong-Seal® Systems.

### **TESTING AND INSPECTION**

Measurement of bond strength of the protective coating to the substrate can be measured in accordance with ASTM D4541. If required, and after Strong-Seal® Epoxy has set hard to the touch, it shall be inspected with high voltage holiday detection equipment. The spark tester shall be initially set at 100 volts per 1 mil (25 microns) of film thickness applied but may be adjusted as necessary to detect any induced holiday. Repairs due to testing shall be made by applicator in strict accordance with Strong-Seal® recommendations.



(800) 982-8009 • FAX (870) 850-6933  
4505 Emmett Sanders Road, Pine Bluff, AR 71601  
[www.strongseal.com](http://www.strongseal.com) Email: [info@strongseal.com](mailto:info@strongseal.com)