**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 50º F and a maximum of 90º 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, 73ºF 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.