

DESCRIPTION.

204 ACE EPOXY is a 100% solids, two-component epoxy flooring resin designed to provide an intermediate or final topcoat that can be applied by trowel, squeegee or roller. This attractive, high-build epoxy is designed to provide a buildable intermediate coat over flake, quartz and other surfaces that may be exposed to severe chemical and physical environments and it can be used as a standalone topcoat on interior surfaces that do not have any exposure to UV. **204 ACE EPOXY** can be applied as a clear or pigmented solution with the **500 ACE UNIVERSAL PIGMENTS**.

SUBSTRATE CONDITIONS.

All concrete should be clean, bare, and free of any curing membranes, such as densifiers, paints, or other sealers inhibiting the adhesion directly to the concrete substrate. Concrete shall be in structurally sound and stable condition. Concrete shall be free of dust, dirt, grease, contamination, surface laitance, and other potential bond-breaking substances that could impair adhesion. All cracks, gouges, and other surface defects shall be repaired appropriately prior to System installation, see **ACE EPOXY** options for cracks and joint fillers and repairs.

Moisture reading on concrete should not exceed 5 lbs. / 1000 sq. ft / 24 hrs. per ASTM F1869 for **204 ACE 100% SOLIDS EPOXY**. Consult with **ACE EPOXY** Technical Support if moisture vapor transmission readings are above the recommended levels.

ENVIRONMENTAL CONSIDERATIONS.

Ideal environmental conditions for **204 ACE 100% SOLIDS EPOXY** are between 50-85°F and relative humidity of 65%.

- Hot and humid climate will shorten the pot life and curing time, which can have an adverse effect on the final appearance of the floor.
- Cold and dry climate will increase the pot life and prolong the curing time, making the floor susceptible for contamination and longer shutdown times.
- Applying the product during descending temperature will help reduce concrete out-gassing from occurring.

Storing the material before the application in areas where the temperature is within the recommended range for at least a day is strongly recommended. Other methods accommodate for temperature and moisture outside the range:

- Ice the buckets several hours before the application in case of hot and humid weather. Use pail warmer in case of cold weather.
- Applying the material during the night, morning or afternoon will improve application conditions for hot weather. Applying during the day will help with colder conditions.

SURFACE PREPARATION.

Pour water onto the concrete surface. Inspect area to see if water penetrates concrete (concrete will darken). If water beads up during the penetration test, then the following additional preparation will be needed.

Nonporous concrete must be mechanically prepared to a profile of CSP (Concrete Surface Profile) between 2 and 4 per ICRI (icri.org). The method used to mechanically achieve the recommended CSP can range from grinding, shotblasting, sanding, light scarification, or any method recommended by ICRI. Non-acid biodegradable etchers might also be used. Consult with **ACE EPOXY** Technical Support.

COVERAGE.

	FIRST COAT.	SECOND COAT.
Over Concrete or Sealed Surface	200 sq. ft per gal	250 sq. ft per gal

RECOMMENDED APPLICATION TOOLS.

- 18" x 3/8" Lint free Rollers
- 18" roller assembly
- Epoxy / Paint Mixer
- Spike Shoes
- Bent Floor 24" Scraper + Handle
- Rigid 18" Floor Scraper + Handle
- 4-Inch Weenie Roller Frame
- 4-Inch Weenie Roller 3/8 Nap 2 Pack
- 6-Inch Weenie Roller Frame
- 6-Inch Weenie Roller 3/8 Nap 2 Pack
- 22" Magic Trowel
- Acetone or Xylene for cleaning
- Rags
- Gloves, Long Pants & Long Sleeves
- Eye Protection
- Respirator compliant with NIOSH / Face mask

EPOXY APPLICATION.

1. Premix Part A and Part B in their respective buckets with a low-speed drill using a jiffy type mixer.
2. Add **500** UNIVERSAL PIGMENTS to Part A and mix.
3. Add Part B to pigmented Part A at ratios listed on labels and mix for 2-3 minutes.
4. Scrape sides of the bucket to assure all of the material is incorporated. Continue mixing for 1 minute.
5. Optional: add accelerators (consider environmental conditions, pot life will be reduced).
6. Apply enough product on the floor to work edges with 3"-4" brush or 6" weenie roller. Work fast enough to keep wet edge.
7. Pour an even line of **204** ACE 100% SOLIDS EPOXY about 4" to 6" thick on the floor. Begin rolling with the 18" x 3/8" nap roller. Target between 6-10 mills (150-250 sq. ft/gal). Wear spike shoes as needed.

LIMITATIONS.

- Will not bridge cracking.
- Yellows under direct UV exposure and wavelength lighting including Fluorescent.

ADDITIONAL CAUTIONS AND RECOMENDATIONS.

- Have all personnel who come in contact with liquids read The ACE EPOXY, URETHANE, AND POLYASPARTIC 2K SAFETY GUIDE and Material Safety Data Sheets before commencing work.

TECHNICAL SUPPORT.

Visit www.aceepoxy.com/techsupport or scan the QR code below for system support and videos.

