

**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.

**APPLICATIONS.**

- Garage Floors
- Industrial / Commercial Floors
- Firehouse Floors
- Basements
- Kennels
- Restrooms
- Stadiums
- Educational Campuses
- Showrooms
- Locker Rooms

**ADVANTAGES.**

- Low odor.
- Low VOC.
- 100% solids.
- High-gloss finish.
- Provides an ideal build coat over flaked flooring.
- Designed for uniform flow and leveling.
- Can be used as a standalone system or topcoat to concrete floors.
- Modular design allows for universal pigments to be mixed in as needed.
- Cures in the presence of high humidity.
- Low viscosity allows for easy application.
- Alkali resistant.
- Only sold to floor coating professionals.

**PHYSICAL PROPERTIES.**

<b>Volumetric Mix Ratio A: B</b>		2:1
<b>Volatile Organic Compound</b>		16.3 g/L
<b>Volumetric Solids</b>		98.2%
<b>Compressive Strength</b>	ASTM D 695	8,700 psi
<b>Tensile Strength</b>	ASTM C638	4,800 psi
<b>Surface hardness Shore D</b>	ASTM D2240	80
<b>Adhesion</b>	ACI 503R	350 psi / 100% Concrete Failure
<b>Flexural Strength</b>	ASTM D790	9,800 psi
<b>Pot Life, 1 Gallon Mass, 75F</b>		40 min
<b>Flammability</b>	Self-extinguishing over concrete	
<b>Elongation</b>	ASTM D 638	5.4%
<b>Dry to Touch Cure Time</b>	8-10 hours 7 days	
<b>Abrasion Resistance</b>	ASTM D4060	46.8 mg lost

**CHEMICAL RESISTANCE.**

CHEMICAL.	EFFECT.
Acetone	No Effect
Xylene	No Effect
10%HCL	No Effect
Ammonia	No Effect
Degreaser	Faint Spotting
Liquid Plummer	Faint Spotting
Vinegar	Faint Spotting
Clorox	No Effect
Windex	No Effect
Motor Oil	No Effect
Gasoline	No Effect
Skydrol	No Effect
Hot Tire	No Effect

## PACKAGING.

KIT SIZE.	COMPONENT.	PART NUMBER.
1-Gal Kit	Kit	204-1
	Part A	204-1A
	Part B	204-1B
5-Gal Kit	Kit	204-5
	Part A	204-5A
	Part B	204-5B

## COVERAGE.

	FIRST COAT.	SECOND COAT.
Flat Surface	200 – 225 sq. ft per gal	250 – 275 sq. ft per gal
Over 1/4" Flake	200 – 225 sq. ft per gal	250 – 275 sq. ft per gal

## ENVIRONMENTAL CONSIDERATIONS.

Ideal environmental conditions for ACE FLAKE SYSTEM 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.

Consult with ACE EPOXY Technical Support.

## TECHNICAL SUPPORT.

[www.aceepoxy.com/techsupport](http://www.aceepoxy.com/techsupport)

Scan for system support and videos



## 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 installation. See ACE EPOXY options for cracks and joint fillers and repairs.

Moisture reading on concrete should not exceed 5 lbs. / 1,000 sq. ft / 24 hrs. per ASTM F1869. Consult with ACE EPOXY Technical Support if moisture vapor transmission readings are above the recommended levels.

## SURFACE PREPARATION.

For direct to concrete applications, 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. For all other applications, verify that the prior coating has cured and is prepared correctly to receive the 204 ACE EPOXY.

Nonporous concrete must be mechanically prepared to a profile of CSP (Concrete Surface Profile) between 2 and 4 per ICRI ([icri.org](http://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.

**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" Weenie Roller Frame
- 4" Weenie Roller 3/8 Nap 2 Pack
- 6" Weenie Roller Frame
- 6" Weenie Roller 3/8 Nap 2 Pack
- 22" Magic Trowel
- Acetone or Xylene for cleaning tools
- Rags
- Gloves, Long Pants & Long Sleeves
- Eye Protection
- Respirator compliant with NIOSH / Face mask

**EPOXY APPLICATION.**

Apply **204 ACE EPOXY** between 150 and 250 sq. ft per gallon (6.4 - 10.66 mills wet).

1. Premix Part A and Part B within their respective buckets prior to mixing both components with a low-speed drill using a jiffy type mixer.
2. Add **500 ACE UNIVERSAL PIGMENTS** to Part A and mix.
3. Add Part B to colored Part A and mix for 2-3 minutes.
4. Scrape sides of the bucket to assure all material is mixed, then continue drilling for one 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 EPOXY** about 4"-6" thick on the floor. Begin rolling with the 18" x 3/8" roller. Target between 6-10 mils (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.
- Must be top coated with a UV Resistant Sealer to stop ambering.

**Slip Resistance OSHA and the American Disabilities Act (ADA)** have now set enforceable standards for slip-resistance on pedestrian surfaces. The current coefficient of friction required by ADA is .6 on level surfaces and .8 on ramps. **ACE EPOXY** recommends the use of angular slip-resistant aggregate in all coatings or flooring systems that may be exposed to wet, oily or greasy conditions. It is the contractor and end users' responsibility to provide a flooring system that meets current safety standards. **ACE EPOXY** will not be responsible for injury incurred in a slip and fall accident.

**ACE EPOXY** guarantees that this product is free from manufacturing defects and complies with our published specifications. In the event that the buyer proves that the goods received do not conform to these specifications or were defectively manufactured, the buyer's remedies shall be limited to either the return of the goods and repayment of the purchase price or replacement of the defective material at the option of the seller. **ACE EPOXY** (herein referred to as "seller") makes no warranty, expressed or implied, regarding the use of its products. Since use of this product is beyond the seller's control, the buyer assumes all risk of use. Seller's obligation shall be to replace material if found defective. Seller shall not be liable for any damage, injury, loss, direct or consequential, resulting from the use of its products. End user must determine if substrate is suitable for coating application before installing.