

Floropoxy 4860 & 4865 Thixotropic Grout/Finish Coat

Product Description: Floropoxy 4860 is a *high body* clear, 100% solids, color stable, thixotropic orange peel finish epoxy system.

Floropoxy 4865 is a *low viscosity*, clear, 100% solids, color stable, thixotropic orange peel finish epoxy system.

Typical Uses, Applications: Ideally suited for use as a single-pass grout coat over the troweled FloroBuild system or as a stipple orange peel finish over various basecoats. Install Floropoxy 4860 or 4865 clear or with the addition of Florock 100% solids colorants as a thixotropic finish. For enhanced properties, Floropoxy 4860 or 4865 may be top coated with Florothane products.

Product Advantages:

- Single application grout coat over FloroBuild
- Stippled orange peel finish over smooth coatings
- A variety of colors can be achieved with the addition of Florock 100% Solids Colorants

Packaging:

4 Gallon OverPack
20 Pail Set (4865 Only)

Storage: All containers should be stored at 40° F to 95° F and be kept tightly sealed and out of direct sunlight.

Coverage:

For use as a single-pass grout coat over FloroBuild, apply at 80 SF/gallon. For use as a stipple orange peel finish over a smooth coating, apply at 160 SF/gallon.

Cured Physical Properties		
Property	Test Method	Results
Compressive Strength	ASTM C579	11,200 PSI
Tensile Strength	ASTM C2370	6,000 PSI
Flexural Strength	ASTM D790	12,500 PSI
Indentation	MIL-D-3134F	No Indentation
Shore Hardness	ASTM D2240	Shore A - 100
		Shore D - 77
Water Absorption	ASTM C413	0.2%
Bond Strength,	ASTM D454	>400 PSI
Abrasion Resistance, Taber Abrader CS 17 Wheel, 1000 gm load, 1000 cycles	ASTM D4060	100 MG
Water Resistance, Fed. Test Std. #141 Method 6011	ASTM D1308	No Effect
Salt Water Resistance Fed. Test Std. #141 Method 6061	ASTM B117	No Effect
Boiling Water Resistance (1 hour continuous exposure)	ASTM D2571	No Effect
Impact Resistance	ASTM D3134	>160 in/lb

Application:

Note: Floropoxy should not be applied when floor temperature is above 90° F or below 55° F, or when within 5° F of the dew point.

1. Apply Floropoxy 4860 or 4865 within 24 hours of the application of the previous coat. If more time has elapsed, contact your Florock representative.

2. While mixing Component A with a mechanical mixer, add Component B and continue mixing for 3 - 5 minutes while scraping down the sides with a paint stick. Scrape the material onto the floor.

Note: Mix Ratio is 3:1 to produce a 4 gallon batch. To field tint: Add 1 or 2 quarts of Florock 100% Colorant to the 4 gallon batch.

3. Spread using a flat or 1/8" notched squeegee. Coverage will be approximately 80 SF/gallon for single pass grout coat and 160 SF/gallon for stipple orange peel finish. Wearing spiked shoes, backroll the coating using a medium nap roller.

Warning: It is important to follow the spread rates to prevent the epoxy from curing with a cloudy finish.

Chemical Resistance	
Reagent	24 Hour Spot Test Results
Water	1
Isopropyl Alcohol	5
Acetone	5
Ammonia	1
Sulfuric Acid 10%	1
Sulfuric Acid 25%	1
Nitric Acid 10%	1
Hydrochloric Acid 10%	1
Phosphoric Acid 50%	4
Citric Acid 10%	1
Brake Fluid	4
Sodium Chloride 20%	1
Acetic Acid 10%	1
Sugar Solution 10%	1
MEK	5
JP 4 Jet Fuel	2
1-1-1 Trichloroethane	1
Methylene Chloride	5
Xylene	5
Toluene	5
Mineral Spirits	1
MIBK	5
Skydrol	5
Tincture of Iodine	1,S
Lactic Acid 10%	1

Rating Scale: Spot Test, ASTM D1380
Pencil Hardness Test, ASTM D3363

- 1- Excellent. No change in pencil hardness
- 2- Good. 1-2 units change in pencil hardness
- 3- Fair. 3 units change in pencil hardness
- 4- Poor. 4 or more units change in pencil hardness
- 5- Stains

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Blended Component Properties 4860 & 4865	
Blended Ratio	3:1 by volume
Blended Solids	100%
Pot Life (15 lb. mass)*	30-40 minutes
Curing Time, 70° F @ 50% RH	
Set to Touch	8 hours
Minimum Recoat	10 - 12 hours
Maximum Recoat	48 hours
Foot Traffic	12 hours
Floor & Air Temp. Limitation**	55° F - 90° F
Blended Viscosity, High Body ASTM D2196 - 4860	35,000-40,000 cps
Blended Viscosity, Low Viscosity ASTM D2196 - 4865	7,000-8,000 cps
Recommended Clean Up Solvent	S 41Florobase Thinner
VOC, ASTM D3960	0

*Pot Life will be less with warmer slab and material temperatures. Pot life is based on 1 1/2 gals of material in a tray. (Larger masses will have a shorter life) **Cooler Temperatures require longer dry time.

4860 High Body Liquid Physical Properties			
Property	Test Method	M1-071 Component A	U0-161 Component B
Viscosity	ASTM D2196	130,000 cps	45 cps
Flash Point	ASTM D3278	>200 F	>200 F
Wt./Gal	ASTM D1475	9.1 lbs	7.9 lbs
N.V.W.	ASTM D2369	100%	100%
N.V.V.	ASTM D1259	100%	100%

4865 Low Viscosity Liquid Physical Properties			
Property	Test Method	M1-082 Component A	U0-161 Component B
Viscosity	ASTM D2196	33,000 cps	45 cps
Flash Point	ASTM D3278	>200 F	>200 F
Wt./Gal	ASTM D1475	9.1 lbs	7.9 lbs
N.V.W.	ASTM D2369	100%	100%
N.V.V.	ASTM D1259	100%	100%

Please read material safety data before using product.

DISCLAIMER:

All preceding statements and recommendations are based on experience we believe to be reliable. The use or the application of these products being beyond the control of the Seller or Manufacturer, neither Seller nor Manufacturer make any warranty, expressed or implied, as to results or hazard from its use. The suitability, risk and liability whatsoever of a product for an intended use