KEY #620-ESD/CONDUCTIVE EPOXY
Product Information Sheet

DESCRIPTION

KEY #620-ESD/CONDUCTIVE is a 100% solids bisphenol F and modified novolac epoxy floor coating designed to provide electrostatic control properties to various surfaces including concrete or other nonconductive substrates. KEY #620-ESD/CONDUCTIVE is ideal for chemical and solvent storage areas requiring electrostatic dissipative surfaces, provides excellent bond to concrete as well as high impact and wear. Application over a non-conductive primer or basecoat will transmit ESD readings of 1x10^6 to 1x10^9 ohms through KEY #620-ESD/CONDUCTIVE. Application over a conductive primer or basecoat will transmit conductive readings of 1x10^4 to 1x10^6 ohms through KEY #620-ESD/CONDUCTIVE.

KEY ADVANTAGES

• Excellent resistance to strong acids, alkalis and most industrial chemicals and solvents
• Meets USGBC LEED criteria for low VOC, low odor
• Gloss finish, easy to clean, good abrasion resistance
• Tests in the static dissipative range of 1x10^6 to 1x10^9 ohms conforming with ANSI/ESD S20.20 standard when applied over non-conductive primer or basecoat
• Tests in the conductive range of 1x10^4 to 1x10^6 ohms conforming with ANSI/ESD S20.20 standard when applied over conductive primer or basecoat
• Body Voltage Generation (BVG) below 100 volts conforming with ANSI/ESD S20.20 standard
• Dissipates a 5000 volt charge to zero in less than 0.1 seconds @ 72º and 12% RH

KEY CONSIDERATIONS

• Substrate temperature must be a minimum of 55-60ºF and maximum of 85ºF
• Relative Humidity should be 30-85% and substrate temperature must be 5ºF above the measured dew point
• Refer to Key Resin Technical Bulletin #1 regarding substrate requirements and surface preparation
• To achieve Conductive reading: Must be applied in a single coat at 8-10 mils, maximum thickness of 12 mils, do not exceed 12 mils or reduction of conductivity may result, requiring reapplication of primer/basecoat and KEY #620-ESD/CONDUCTIVE at correct thickness range
• To achieve ESD reading: Must be applied in a single or multiple coats at 8-12 mils per coat, maximum thickness of 16 mils/coat. Do not exceed 16 mils/coat or reduction of conductivity may result, requiring reapplication of KEY #620-ESD/CONDUCTIVE at correct thickness range
• Final conductivity testing requires 72 hours cure time to obtain final readings. KEY #620-ESD/CONDUCTIVE applied over conductive primer or basecoat will test in low ESD range prior to 48-72 hours cure at 75ºF
• Finish has a variable orange peel texture

COMPOSITION

100% solids bisphenol F epoxy and novolac epoxy resin, modified cycloaliphatic amines, and fillers.

COVERAGE

KEY #620-ESD/CONDUCTIVE will yield approximately 8-10 mils when spread at 160-200 ft^2 per gallon.

APPLICATION

SURFACE PREPARATION

Surface Preparation is the most critical portion of any successful resinous flooring system application. All substrates must be properly prepared as outlined in Key Resin Technical Bulletin #1. Work must be performed by trained or experienced contractors or maintenance personnel. The Key Resin Technical Service Department is available to answer any questions.

INSTALLATION

Installation of KEY #620-ESD/CONDUCTIVE will vary with application. Typically spread resin in a single coat at 160-200 ft^2 per gallon with a squeegee and lightly back-roll with a medium or short nap roller. IMPORTANT: 12 mils are considered the maximum total thickness for Conductive readings and 16 mils per coat (in single or multiple coats) for ESD readings. Care should be taken to minimize the entrapment of air caused by over rolling. For complete instructions, consult Key Resin Technical Service.

CLEAN UP

Clean skin with soap and water. Tools and equipment should be cleaned with xylene or lacquer thinner. Consult Safety Data Sheet (SDS) for safety and health precautions.

COLOR SELECTION

KEY #620-ESD/CONDUCTIVE is available in Key Resin Standard Colors and custom colors with lab approval, longer lead time and possible added cost. Standard colors will vary slightly from Key Resin Standard Colors due to the conductive filler content. Confirm final color selection with samples.

CURE/DRY TIME

<table>
<thead>
<tr>
<th></th>
<th>Working Life</th>
<th>Reccoat, for ESD only</th>
<th>Light Foot Traffic</th>
<th>Full Cure &amp; Max. Resistance</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>20-25 min. @ 75°F</td>
<td>8-12 hrs @ 75°F</td>
<td>24 hrs @ 75°F</td>
<td>7 Days</td>
</tr>
</tbody>
</table>

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TECHNICAL DATA

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mixing Ratio</td>
<td>3 Parts A:1 Part B by Volume</td>
</tr>
<tr>
<td>Solids Content</td>
<td>100% Solids by Volume</td>
</tr>
<tr>
<td>Volatile Organic Content (VOC)</td>
<td>0 g/L, compliant to low VOC Rule 1113 in all 50 states</td>
</tr>
<tr>
<td>Weight/gal</td>
<td>11.0 - 11.5 lbs/gal, Mixed</td>
</tr>
<tr>
<td>Viscosity @ 75°F</td>
<td>1,000 - 1,500 cps</td>
</tr>
<tr>
<td>Shelf Life</td>
<td>3 months</td>
</tr>
</tbody>
</table>

CHEMICAL RESISTANCE
Contact Key Resin Technical Service.

PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Abrasion Resistance</td>
<td>ASTM D4060 CS-17 Wheel, 1000 cycles</td>
<td>75-100 mgs</td>
</tr>
<tr>
<td>Adhesion to Concrete</td>
<td>ASTM D7294</td>
<td>300-400+ psi (Concrete Failure, varies by concrete strength)</td>
</tr>
<tr>
<td>Flammability</td>
<td>ASTM D635</td>
<td>Self Extinguishing</td>
</tr>
<tr>
<td>Hardness, Shore D</td>
<td>ASTM D2240</td>
<td>70-80</td>
</tr>
<tr>
<td>Impact Resistance</td>
<td>ASTM D2794</td>
<td>100 in-lbs. direct</td>
</tr>
<tr>
<td>Conductivity Resistance</td>
<td>ANSI/ESD-S7.1</td>
<td>Conductive: 1x10⁴ to 1x10⁶ ohms ESD: 1x10⁶ to 1x10⁹ ohms</td>
</tr>
<tr>
<td>Static Charge Decay</td>
<td>MIL-B-81705B</td>
<td>Dissipates a 5,000 volt charge to zero in &lt;0.1 seconds</td>
</tr>
</tbody>
</table>

AVAILABILITY
Key Resin materials are available throughout the United States, Canada, and a number of other countries. Contact the Key Resin Representative in your area for details.

TECHNICAL SERVICE
Key Resin Company provides services and consultations on material selection, specification, troubleshooting, and other information on the proper repair and protection of concrete surfaces. Key Resin Sales/Technical Representatives are available to assist you. Telephone 888.943.4532 or visit www.keyresin.com.

MAINTENANCE
After completing the application of KEY #620-ESD/CONDUCTIVE, the installer should provide the owner with maintenance instructions. KEY #620-ESD/CONDUCTIVE is easily cleaned with neutral soaps or detergents. Refer to Key Resin Technical Bulletin #3 and #3A for additional recommendations.

WARRANTY
Key Resin Company ("Key") warrants for a period of one (1) year that its products will be free of manufacturing defects and will be in conformity with published specifications when handled, stored, mixed, and applied in accordance with recommendations of Key. If any product fails to meet this warranty, the liability of Key will be limited to replacement of any non-conforming material if notice of such non-conformity is given to Key within (1) one year of delivery of materials. Key may in its discretion refund the price received by Key in lieu of replacing the material. No customer, distributor, or representative of Key is authorized to change or modify the published specifications of this warranty in any way. No one is authorized to make oral warranties on behalf of Key. In order to obtain replacement or refund the customer must provide written notice containing full details of the non-conformity. Key reserves the right to inspect the non-conforming material prior to replacement. EXCEPT FOR THE EXPRESSED WARRANTY STATED ABOVE, THERE ARE NO OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING WITHOUT LIMITATION, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE. KEY'S OBLIGATION SHALL NOT EXTEND BEYOND THE OBLIGATIONS EXPRESSLY UTTERED ABOVE AND KEY SHALL HAVE NO LIABILITY OR RESPONSIBILITY TO THE PURCHASER OR ANY THIRD PARTY FOR ANY LOSS, COST, EXPENSE, DAMAGE OR LIABILITY, WHETHER DIRECT OR INDIRECT, OR FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES.

VOLATILE ORGANIC CONTENT (VOC) (EPA Method 24) 0 g/L, compliant to low VOC Rule 1113 in all 50 states

WEIGHT/gal 11.0 - 11.5 lbs/gal, Mixed

SHelf Life 3 months