

KEY #644 EPOXY WALL COATING

Product Information Sheet



DESCRIPTION

KEY #644 is a specially formulated 100% solids chemical resistant epoxy coating for wall and chemical containment applications. **KEY #644** should be used in areas requiring a high build, chemical resistant protective coating, and can be reinforced with fiberglass cloth for added durability. **KEY #644** provides a high gloss finish. **KEY #644** is available with **KEY BIOCLEAN** for antimicrobial performance.

KEY ADVANTAGES

- Low odor for use in occupied areas
- Meets USGBC LEED criteria for low VOC
- Excellent chemical and stain resistance
- Optional fiberglass reinforcement increases durability
- Meets USDA requirements

KEY CONSIDERATIONS

- Substrate temperature must be a minimum of 50°F
- Substrate must be free of dirt, waxes, curing agents, and other foreign materials
- Light colors and white are prone to yellowing over time, if not acceptable apply a pigmented aliphatic urethane sealer on top

COLOR SELECTION

KEY #644 is available in **Key Resin Standard Colors** and custom colors with lab approval, longer lead time and possible added cost. Neutral requires addition of **Key Epoxy Color Pack**.

COMPOSITION

100% solids epoxy resin, aliphatic amines and fillers.

COVERAGE

KEY #644 will yield approximately 8-10 mils dry film thickness when spread at 160-200 ft² per gallon.

CURE/DRY TIME

Working Life	25-30 minutes @ 75°F
Dry to Touch	8-10 hrs @ 75°F
Recoat	8-12 hrs @ 75°F
Light Service	24 hrs @ 75°F
Full Cure & Max. Resistance	5 Days

APPLICATION

SURFACE PREPARATION

Surface Preparation is the most critical portion to 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

KEY #644 is typically applied over a properly prepared and primed wall surface, contact Key Resin for detailed instructions. Depending upon specification requirements, fiberglass cloth can be imbedded into a base coat of **KEY #644**. Successive applications of **KEY #644** are rolled onto the imbedded fiberglass to ensure a smooth surface and complete coverage of reinforcing fiberglass.

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.

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TECHNICAL DATA

Mixing Ratio	2 Parts A:1 Part B by Volume
Solids Content	100% Solids by Volume
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 per gallon, mixed
Viscosity @ 75°F	2,000-2,500 cps

AVAILABILITY

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

MAINTENANCE

After completing the application of **KEY #644**, the installer should provide the owner with maintenance instructions. **KEY #644** is easily cleaned with neutral soaps or detergents. Refer to **Key Resin Technical Bulletin #3** and **#3A** for additional recommendations.

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.

CHEMICAL RESISTANCE

REAGENT	RATING
Acetic Acid - 5%	R
Acetone	L
Ammonia Hydroxide - 38%	L
Beer	R
Bleach	L*
Brake Fluid	R
Citric Acid - 30%	R
Citric Acid - 40%	L
Crude Oil	R
Diesel Fuel	R
Ethylene Glycol	R
Fatty Acids	R
Gasoline	R
Hydrochloric Acid - 15%	R
Lactic Acid - 15%	R
Lactic Acid - 50%	L
Methyl Ethyl Ketone	L
Nitric Acid - 10%	R
Orange Juice	R
Peroxide - 35%	L
Phosphoric Acid - 85%	L
Skydrol	R
Sodium Hydroxide - 50%	R
Sulfuric Acid - 20%	R
Toluene	L
Urea	R
Vinegar	L
Xylene	L

R - Recommended for continuous splash/spill service

L - Limited recommendation, occasional spills

* - May cause slight stain or discoloration

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 UNDERTAKEN 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.