

KEY #615 CHEMICAL RESISTANT EPOXY

Product Data Sheet



DESCRIPTION

KEY #615 is a high performance, chemical resistant, two component clear epoxy resin. The modified Bisphenol F and novolac chemistry of **KEY #615** is recommended wherever a high build, acid and alkali resistant, protective industrial maintenance floor finish is required. It is essentially odorless and can be used in occupied areas. **KEY #615** is used as a binder resin for various **KEY RESISTANT SYSTEMS** and a topcoat for various **KEY RESIN SYSTEMS** with a “-HP” (High Performance) designation.

KEY ADVANTAGES

- Good troweling properties for use with **KEY RESISTANT MORTAR SYSTEMS**
- Superior chemical and stain resistance
- Low odor for use in occupied areas
- Meets VOC criteria for industrial maintenance coating
- Meets USDA requirements
- Suitable for wet process flooring applications
- Clear formulation

KEY CONSIDERATIONS

- Substrate temperature must be a minimum of 50°F (Contact **Key Resin** for Low Temperature Cure)
- Substrate must be free of curing agents and any foreign materials
- Concrete must be properly prepared

COLOR SELECTION

KEY #615 is available in Clear Gloss. May be tinted with **Key Universal UNVCP Color Packs** available in **Key Resin Standard Colors**.

COMPOSITION

100% solids epoxy resin, aliphatic amines and fillers.

COVERAGE

KEY #615 will yield approximately 10 mils when spread at 160 ft² per gallon. Coverage varies by type of system.

CURE/DRY TIME

Working Life	25-30 min. @ 75°F
Dry to Touch	8-12 hrs @ 75°F
Recoat	16 hrs @ 75°F
Light Foot Traffic 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. Contact the **Key Resin Technical Service Department** with questions.

INSTALLATION

KEY #615 will vary with type of system and application method. For complete installation instructions, contact **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.

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TECHNICAL DATA

Mixing Ratio	2 Parts A:1 Part B by Volume
Solids Content	98% Solids by Volume
Volatile Organic Content (VOC) (EPA Method 24)	<100 g/L, compliant to Industrial Maintenance Coating VOC Rule 1113
Weight/gal	8.97 lbs/gal, Mixed
Viscosity @ 75°F	700-900 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.

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 #615**, the installer should provide the owner with maintenance instructions. **KEY #615** 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 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.

CHEMICAL RESISTANCE

REAGENT	RATING
Acetic Acid - 10%	R
Acetone	L
Ammonia Hydroxide - 38%	L
Beer	R
Bleach - 10%	L*
Brake Fluid	L
Citric Acid - 30%	R
Citric Acid - 40%	L
Crude Oil	R
Diesel Fuel	R
Ethylene Glycol	R
Fatty Acids	L
Gasoline	R
Hydrochloric Acid - 37%	L
Lactic Acid - 50%	L
Lactic Acid - 80%	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 - 50%	L
Toluene	L
Urea	R
Vinegar	L
Xylene	L

R - Recommended for continuous splash/spill service.

L - Limited recommendation for 8 hours or less exposure time, requires more frequent cleanup, occasional spills only.

*May cause slight stain or discoloration.

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