

# KEY #540 INDUSTRIAL COATING

## Product Data Sheet



## DESCRIPTION

**KEY #540** is a 100% solid epoxy coating for use as an industrial coating and chemical resistant liner for interiors of waste-water treatment tanks, structures, lift stations, pipes, manholes and secondary containment of dilute, acids and alkalis. **KEY #540** protects concrete and steel from chemicals and wastewater in immersion, splash and spillage conditions. **KEY #540** is specifically designed for lining manholes, large diameter sewer pipe, lift stations and other structure. When applied over prepared concrete, **KEY #540** produces a seamless, monolithic liner.

## KEY ADVANTAGES

- Meets criteria for low VOC in all 50 states
- No offensive odors
- Chemical and stain resistant
- Easy application
- Bonds well to cool, damp substrates
- Suitable for immersion and wet process flooring applications

## KEY LIMITATIONS

- Do not apply in temperatures less than 50°F or greater than 95°F
- Store materials in dry conditions at 55°F - 75°F
- Slabs on grade require heavy duty vapor barrier directly under slab
- Must have a properly prepared substrate
- Substrate temperature must be 5°F above the dew point
- Confirm product performance in specific chemical environment prior to use

## COLOR SELECTION & ORDERING

**KEY #540** is available in Gray or White. Minimum order quantity of 300 gallons per color is required.

## COVERAGE

**KEY #540** can be applied between 50-100 ft<sup>2</sup>/gallon to achieve 16-32 mils DFT

## CURE/DRY TIME

Working Life	80-90 minutes @ 77°F
Tack Free	8 hours @ 77°F 3-4 hours @ 90°F
Recoat	12-24 hours @ 77°F 6 hours @ 90°F
Full Cure	7 days @ 77°F

## 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 questions.

Surface profile shall be CSP-3 to CSP-5 for coating concrete; produce a profile equal to 60 grit sandpaper or coarser. Moisture vapor transmission readings should be 3 lbs. or less per 1000 ft<sup>2</sup> per 24 hours per ASTM F1869 or less than 80% RH as taken per ASTM F2170. All surface irregularities, cracks, control joints and expansion joints must be properly addressed prior to application. Concrete outgassing must be avoided and substrate primed (twice if necessary) with a recommended primer such as **KEY #502**, **KEY #532**, or **KEY EPOCOAT**.

### MIXING INSTRUCTIONS

1. Priming is usually not required. If needed, use **KEY #502**, **KEY #635-MVT Plus**, or **KEY EPOCOAT** for concrete outgassing. Consult with **Key Resin Technical Service** for recommendations.
2. Mix components A & B separately until consistent. Combine Part A & Part B in 2:1 ratio by volume and mix thoroughly using a Jiffy-type mixer until uniform. Scrape all sides and bottom of container during mixing. Do not thin.
3. Apply by brush, roller, or spray. Material should be tack free within 8 hours @ 77°F. Multiple coats can be applied between 12-24 hours. If spraying, use a 45:1 Airless Spray with a reverse-a-clean tip with an opening of .020-.025 inch. Be aware of pot life when using spray equipment.

### CLEAN UP

Clean skin with soap and water. Tools and equipment should be cleaned with warm soapy water, 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%
Volatile Organic Content (VOC) (EPA Method 24)	<100 g/L, compliant to low VOC Rule 1113 in all 50 states
Weight	9.5-10 lbs per gallon, mixed
Viscosity	8,000-9,000 cps

## MAINTENANCE

Finished systems used in conjunction with **KEY #540** should be accompanied with proper maintenance guidelines.

## 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](http://www.keyresin.com).

## 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.

## CHEMICAL RESISTANCE

**KEY #540** is chemical resistant to dilute acids and alkalis. For detailed chemical resistance contact **Key Resin Technical Service**.

## PHYSICAL PROPERTIES

Adhesion to Concrete	ASTM D7240	300-400+ psi (Concrete Failure, varies by concrete strength)
Compressive Strength	ASTM D695	8,700-9,000 psi
Hardness, Shore D	ASTM D2240	78
Tensile Strength	ASTM D638	4,200-4,300 psi

## 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.

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