

PHYSICAL PROPERTIES

SOLIDS CONTENT	100%
VOLUMETRIC MIX RATIO	2A:1B
COVERAGE RATE	300 Lf / gal @ 1/4" x 1/4"
APPLICATION TEMP	50°- 90°F
POTLIFE 1 Gal mass @ 75°F	Standard: 30 Mins Fast: 15 Mins
DRY TIME @ 75°F	Standard: 8-10 Hours Fast: 5-7 Hours
RECOAT WINDOW	8-24 Hours
FULL CURE	7 Days
PACKAGING	1.5 Gal Kit 3 Gal Kit

MECHANICAL PROPERTIES

COMPRESSIVE STRENGTH ASTM D695	2,500 p.s.i
TENSILE STRENGTH ASTM D638	1,000 p.s.i
ELONGATION ASTM D638	60%
ADHESION TO CONCRETE ASTM D7234	>300 p.s.i
SHORE D HARDNESS ASTM D2240	55-60

CHEMICAL RESISTANCE

Refer to CrownTech Chemical Resistance Guideline Technical Bulletin No. 9

PRODUCT DESCRIPTION

8504 CrownFlex is a two-component, 100% solids, semi-rigid thixotropic epoxy cove base binder, orange peel coating and a sag-resistant control joint and cracks filler. It features a combination of excellent adhesion and elongation not available in general-purpose epoxy. It is formulated to provide the armoring of concrete joint edges and minimizing the deterioration of concrete joint/crack edge to impact. It is available in standard cure and fast cure. It is used on floors, joints, and cracks subjected to heavy foot traffic, forklift traffic, and chemical attack, specifically food acids. Also, it is used as an epoxy membrane for waterproofing and crack dampening under epoxy coating and flooring systems. It is VOC Compliant in all states and provinces in North America.

- "S" – Standard Cure Hardener is designed for temperatures ranging from 50°F to 80°F (10°C to 27°C).
- "F" – Fast Cure Hardener is designed for temperatures ranging from 40°F to 60°F (4°C to 16°C)

TYPICAL USES

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| • Aircraft Hangars & Maintenance Floors | • Commercial Bakeries and Kitchens | • Laboratories and Research Floors | • School & Universities |
| • Automotive Show Room and Repair Areas | • Hospital and Health Care Facility Floors | • Manufacturing and Warehouse Floors | • Pharmaceutical Floors |

BENEFITS

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| • Complies with USDA, FDA, FSMA. See Crown Polymers Technical Bulletin: 3 Food and Beverage Compliance. | • LEED requirements. See Crown Polymers Technical Bulletin: 5 LEED information | • Cures to an inert finish. See Crown Polymers Technical Bulletin: 2 VOC Compliance |
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COLORS



Clear

LIMITATIONS

- Higher temperatures will result in shortened working times and faster drying time.
- May amber with UV Exposure
- Do not thin
- Use 8303 CrownShield™ Moisture Barrier when MVT exceeds 3 lbs. or 80% RH

SHELF LIFE

1 Year from Date of Manufacture provided unopened

STORAGE

Store in a dry environment at room temperature and out of direct sunlight.

APPLICATION EQUIPMENT

Personal Protective Equipment
V-Blade
Putty Knife
Stainless Steel Trowel

SURFACE DIAGNOSTICS

Concrete must be structurally sound and free of all contaminants and bond breakers. Test concrete compressive strength using a Schmidt or Rebound Hammer to ensure substrate has compressive strength of 3500 psi or higher.

Perform a pH test using concrete pH test strips or meter to ensure substrate pH is between 9-12.
Perform Moisture Test using either Calcium Chloride per ASTM F1869 or In-Situ Relative Humidity Probe per ASTM F2170 to ensure substrate has Moisture Vapor Emission Rate of 3 psi or less and Relative Humidity of 80% or less. See CrownTech Bulletin 6: Moisture Mitigation Negative Side Moisture Barrier

If Moisture Vapor Emission Rate is above 3 psi but below 25 psi and relative humidity is above 80% but below 99% then apply 8303 Moisture Barrier Primer first at 16 mils with a coverage rate of 100 Ft²/ Gal.

SURFACE PREPARATION

Use Mohs scratch test to determine concrete hardness for proper diamond bond selection.
Concrete should be mechanically profiled and prepared to produce a Concrete Surface Profile (CSP) level between #2 & #4 per ICRI Guideline no. 310.2R. See CrownTech Bulletin 1: Concrete Surface Preparation.
All perimeter areas of coating termination shall be masked for protection. Saw cut and key-in all termination points.

SURFACE REPAIR

All depressions, divots and cracks should be profiled and free of dust and contaminants. Repair surface imperfections to reduce the ability to see the defect through the coating.
Honor all dynamic (moving) joints, static joints may be filled, use dynamic joints as initiation and termination points during application process where needed.

TEMPERATURE EVALUATION

Ambient and substrate temps should be above 50°F and a minimum of 5°F above Dew Point.
Product temps should be between 70-80°F.
Relative Humidity should not exceed 80%. See CrownTech Bulletin 7: Temperature & Relative Humidity

ALL SOURCES OF IGNITION SHOULD BE TURNED OFF AND ENVIRONMENT SHOULD HAVE PROPER AND ADEQUATE VENTILATION DURING APPLICATION AND CURING PROCESS

MIXING AREA SHOULD BE PLACED ON OR IN CLOSE PROXIMITY TO PROJECT. AREA SHOULD BE SECURELY COVERED WITH PLASTIC, CARDBOARD OR TARP. STAGE MATERIALS, TOOLS AND CLEANING SUPPLIES IN MIXING AREA PRIOR TO APPLICATION PROCESS.

DO NOT MIX MORE MATERIAL THAN CAN BE APPLIED IN 10 MINUTES

MIXING PROCEDURE

1 Scoop 2 parts A-Component and 1 part B-Component using a putty knife

BE SURE NOT TO CROSS CONTAMINATE PUTTY KNIVES WHILE SCOOPING

2 Mix, fold, and blend components with a putty knife until homogenous mixture is achieved

COVERAGE RATE

300 Lf / Gal @ 1/4" x 1/4"

COVERAGE RATE WILL VARY DEPENDING ON SUBSTRATE CONDITION AND APPLICATION

WORKING TIME

15-20 Minutes @ 75°F (Standard)

FAST VERSION AND WARMER AMBIENT, PRODUCT AND SURFACE TEMPERATURES WILL SHORTEN POTLIFE AND WORKING TIME.

APPLICATION PROCEDURE

1 Use putty knife or stainless steel trowel to press mixed material into clean and prepared static joint, crack, divot or spall.

BE SURE TO SLIGHTLY OVERFILL REPAIR AREA WITH MIXED MATERIAL

✓ Allow repair material to dry 5-10 hrs prior to grinding flush with surface

SLIP RESISTANCE

Skid-Resistance – Field (in situ) Wet Dynamic Coefficient of Friction (DCOF), ANSI A326.3. See Crown Polymers Technical Bulletin: 4 Coefficient of Friction.

CLEAN-UP

Clean-up mixing station, tools, and equipment as required. Use acetone, a VOC exempt solvent, for cleaning up. Observe all legal, and health, and safety precautions when handling or storing solvents and materials, particularly in confined spaces. Make sure the working areas are well ventilated at all times during placement and curing time.

DISPOSAL

Dispose of empty packaging and other waste in accordance with federal, state, provinces and local regulations.

MAINTENANCE

Inspect the installed floor by spot cleaning and spot repairing the damaged or cracked areas. To prolong life of the flooring system, a daily maintenance program is highly recommended to ensure the floor is safe for its intended purposes. See Crown Polymers Technical Bulletin: 8 Care and Maintenance.

TECHNICAL SUPPORT

For questions, contact a Crown Polymers Representative. Additional Support Documents are available from Crown Polymers, including brochures, application guidelines, videos and more. Visit Crownpolymers.com or contact Crown for additional resources

DISCLAIMER

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SCAN QR CODE FOR FULL DISCLAIMER AND LIMITED WARRANTY INFORMATION

**REFER TO SAFETY DATA SHEETS (SDS)
FOR SAFETY PRECAUTIONS.**

**SAFETY PRECAUTIONS MUST BE FOLLOWED
DURING STORAGE, HANDLING AND USE.**

**PERSONAL PROTECTIVE EQUIPMENT
(PPE)**

**SHALL BE WORN AT ALL TIMES INCLUDING
BUT NOT LIMITED TO LONG SLEEVE SHIRTS OR
DISPOSABLE ARM SLEEVES, SAFETY GLASSES,
DISPOSABLE NITRILE GLOVES, AND PROPERLY
FITTED NIOSH RESPIRATORS**