

## PHYSICAL PROPERTIES

Application time at 70°F

Working time	30 minutes
Initial set	12 - 24 hours
Bond strength to 3,000 psi concrete ASTM(D 7234)	concrete failure
Compressive strength (ASTM C-579)	8,800 psi
Density (ASTM C-905)	81.8 pcf
Flexural strength (ASTM C-580)	5,200 psi
Modulus of elasticity (ASTM C-580)	4,8 x 10 <sup>5</sup> psi
Tensile strength (ASTM C-307)	2,500 psi

Physical properties were determined on specimens prepared under laboratory conditions using applicable ASTM procedures. Actual field conditions may vary and yield different results; therefore, data are subject to reasonable deviation.

FibreCrete TL 215 (TANK LININGS) is a two component, fiber reinforced, epoxy lining system that is used to protect concrete/steel tanks, ducts, scrubbers and other immersion environments from chemical attack and abrasion. FibreCrete TL 215 is specifically formulated for immersion service for tanks and scrubbers in the chemical, power, and municipal industries.

Application in direct sunlight and/or rising surface temperature may result in blistering of materials due to entrapped air, entrained air or moisture escaping from the substrate. When surface temperatures are rising, it may be necessary to delay installation or apply materials during cooler hours.

*Old Concrete* - Concrete must have the physical strength to withstand the imposed loads during normal use and operation. Mechanical methods should be utilized to remove old paints, protective coatings, and deteriorated concrete. Chemical cleaning may be necessary to remove oil, grease and other contaminants. Abrasive blast or high pressure water blast to remove laitance and obtain a firm, uniform surface texture exposing fine aggregate and resembling coarse sandpaper. All structural cracks should be repaired, and all slopes reestablished with Sauereisen RestoKrete No. 208.

## CHARACTERISTICS

- Excellent chemical resistance in high temperatures
- Available in colors: 25 beige, 50 gray, 53 gray, 63 tile red, 99 white

## Surface Preparation

*New Concrete* - The concrete must have the necessary physical strength to withstand the imposed loads during normal use and operation. Concrete should be floated free of ridges or depressions and all voids filled with Sauereisen RestoKrete No. F-208.

All prepared surfaces must be allowed to thoroughly dry prior to epoxy monolithic application. Regardless of preparation method used, all surfaces must be vacuumed to remove any loose deposits or contamination.

## AREA PREPARATION

### Temperature of Working Area

Maintain a temperature of 50 - 85°F on air, substrate and materials during mixing, application and cure. Material temperature must be maintained between 65 - 80°F for a minimum of 48 hours prior to use. Lower temperatures will require a longer cure time. Above 80°F working time decreases.

Chemical cleaning may be necessary to remove oil, grease and other contaminants that may inhibit bond of the epoxy monolithic. Abrasive blast or high pressure water blast to remove laitance and obtain a firm, uniform surface texture exposing fine aggregate resembling coarse sandpaper.

*Metal* - Metal must be structurally sound as specified by architect/engineer. Mechanical methods should be utilized to remove old paints or protective coatings. Chemical cleaning may be necessary to remove oil, grease and other contaminants. All welds must be continuous, free of flux, and have a smooth rounded radius without any sharp edges.

Abrasive blast to a nominal 2.5 mil profile employing SSPC SP-5 White Metal Blast for immersion conditions and SSPC SP-10 Near White Metal Blast for splash and spill or severe atmospheric environments.

Recommendations for less severe environments consult a Sauereisen representative.

## EXPANSION/CONTROL JOINTS

Joints are to be provided over existing expansion/control joints. Joints must also be placed around all fixed objects, peripheries of room and all points of movement in the base slab. Consult Sauereisen for recommendations.

## APPLICATION

### Mixing

*Primer-* ConoWeld 501 or 502 are recommended for concrete and other porous surfaces. ConoPrime 506 is recommended for use on metallic surfaces where flash rusting cannot be controlled.

Primers are packaged in premeasured containers consisting of Hardener and Resin which must be mixed together before use. Remix all components before combining.

Completely empty contents of Hardener Part A into Resin Part B and mix for 3 - 5 minutes with a Jiffy mixing blade affixed to a slow speed 1/2" drill motor. Primer is ready for use immediately after mixing.

**FibreCrete** - Packaging consists of premeasured unitized containers of Hardener Part A and Resin Part B components. Remix components before using.

Completely empty contents of Hardener Part A into Resin Part B container and mix for 3 - 5 minutes with a Jiffy mixing blade affixed to a 1/2" slow speed drill motor. **Mix only complete units of material - do not mix partial batches.**

## Installation

### Primer

*ConoWeld 501/502* - Apply to concrete using a short nap adhesive roller with a nondegradable core, or nylon bristle brush. For horizontal surfaces, ConoWeld 501/502 must be allowed to cure at least two hours, but not more than 24 hours prior to application of FibreCrete. For vertical or overhead surfaces, allow a cure of 8 - 24 hours to eliminate sagging of the FibreCrete material. For best results, FibreCrete should be applied when primer is slightly tacky. If recoat time exceeds 24 hours, contact Sauereisen.

*ConoPrime 506-* Apply to steel with a short nap adhesive roller with a nondegradable core, nylon bristle brush, or suitable airless spray equipment. Allow ConoPrime to cure approximately 8-24 hours prior to FibreCrete application. For best results, FibreCrete should be applied when ConoPrime is tack-free.

### FibreCrete

*Trowel Application* - Material should be delivered to finishers and spread into a continuous bead immediately after mixing. Do not let mixed material remain in the mixing vessel. Spread the material with a steel finishing trowel to the desired thickness. To improve surface texture and appearance of FibreCrete, lightly backroll the trowled surface with an adhesive roller lightly dampened with lacquer thinner. All troweling and backrolling must be completed within 30 minutes from mixing.

*Spray Application* - If spray application is chosen, contact Sauereisen for complete details on equipment requirements. The following equipment is typically used for spray application:

*Mastic Pump* - Graco King 56:1 (or higher) or equivalent. Remove filter from surge tank. Remove cage above lower ball valve located near "foot" (lower end) of pump.  
*Spray Gun* - Graco Extrusion Flo Gun No. 207-945.

Remove existing extrusion style tip and valve seat. Replace valve seat with Valve Seat No. 235-006.

*Spray Tip* - Heavy Duty Reverse-A-Clean Housing Part No. 222-674 with 0.035" orifice tip, Part No. GHD-535. If spray tip has a diffuser (small rod located behind the orifice), it should be removed prior to use.

*Material Hose* - 6 Foot whip end 3/8" i.d., 5,000 psi working pressure, 16,000 psi burst pressure.

0-25 Foot overall, 1/2" i.d., 4,000 psi work-ing pressure, 16,000 psi burst pressure.

25-75 Foot overall, 3/4" i.d., 4,000 psi working pressure, 16,000 psi burst pressure.

*Air Compressor* - Minimum 100 cubic foot per minute at 100 psi.

*Air Hose* - 3/4" - 1" i.d.; 100 foot maximum length to mastic pump. To prevent sagging on vertical surfaces, the required coverage should be applied in two equal coats. Application should be done with a 50% overlap in a "cross hatch" pattern to reduce the possibility of pinholes and to assure complete coverage. If recoat time exceeds 24 hours, contact Sauereisen.

## COVERAGE

ConoWeld - 200 ft<sup>2</sup> per gallon at 8 mils.  
ConoPrime - 400 ft<sup>2</sup> per gallon at 4 mils.  
FibreCrete - 40 ft<sup>2</sup> per gallon at 40 mils.

**All coverage rates are theoretical and will vary depending upon surface conditions, porosity, application techniques and specific project conditions.**

## SETTING/CURING

Do not allow water, chemicals or traffic on the FibreCrete for a minimum of 24 hours at 70°F. For harsh chemical or physical environments, allow a minimum of 72 hour cure at 70°F prior to exposure.

## TOPCOATS

FibreCrete systems do not normally require a topcoat; however, for specific service conditions, a topcoat may be desirable.

Contact Sauereisen for a recommendation on an appropriate ConoGlaze topcoat for your application.

## PACKAGING

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Unit Size	Part A	Part B
1 Gallon	1 gal. can	1gal. can
2.5 Gallon	1 gal can	3.5gal.pail
5 Gallon	2gal pail	6 gal pail

*Containers are filled by weight, not volume. Container size does not indicate volume of contents.*

## CLEAN-UP

All equipment should be cleaned with acetone, xylene or MEK before ConoWeld, ConoPrime or FibreCrete material cures.

## SHELF LIFE

Sauereisen FibreCrete TL No. 215 (Tank Lining) has a shelf life of one year when stored in unopened, tightly sealed containers in a dry location at 70°F. Avoid freezing. If there is a doubt as to the quality of the materials, consult a Sauereisen representative.

## CAUTION

Consult Material Safety Data Sheets and container label Caution Statements for hazards in handling these materials.

## WARRANTY

We warrant that our goods will conform to the description contained in the order, and that we have good title to all goods sold. WE GIVE NO WARRANTY, WHETHER OF MERCHANTABILITY, FITNESS FOR PURPOSE OR OTHERWISE, EXPRESS OR IMPLIED, OTHER THAN AS EXPRESSLY SET FORTH HEREIN. We are glad to offer suggestions or to refer you to customers using Sauereisen cements and compounds for a similar application. Users shall determine the suitability of the product for intended application before using, and users assume all risk and liability whatsoever in connection therewith regardless of any suggestions as to application or construction. In no event shall we be liable hereunder or otherwise for incidental or consequential damages. Our liability and your exclusive remedy hereunder or otherwise, in law or in equity, shall be expressly limited to our replacement of nonconforming goods at our factory or, at our sole option, to repayment of the purchase price of nonconforming goods.

- o **Distributors and agents in major cities throughout the world. Consult manufacturer for locations.**
- o **Information concerning government safety regulations available upon request.**
- o **Sauereisen also produces inorganic compounds for assembling, sealing, electrically insulating and grouting.**

## LEGAL NOTICE

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**SAUEREISEN** ...since 1899  
160 Gamma Drive  
Pittsburgh, PA 15238-2989 USA  
Phone 412.963.0303 Fax 412.963.7620  
www.sauereisen.com