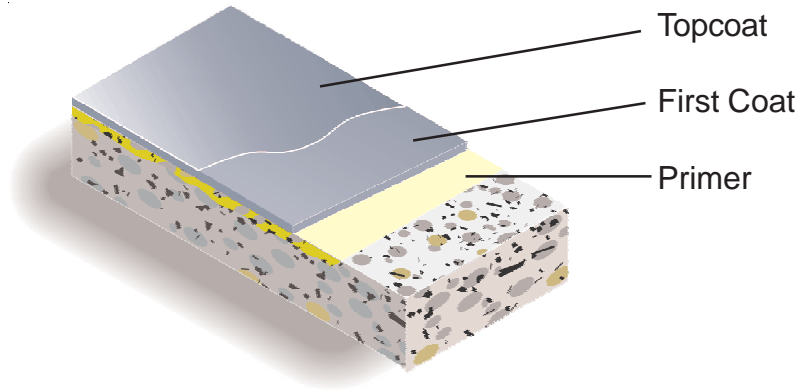




STATIC DISSIPATIVE COATING #18 SD

General Polymers STATIC DISSIPATIVE COATING SYSTEM #18 SD is comprised of a penetrating epoxy primer and aliphatic urethane topcoat. Its $10^6 - 10^9$ ohms resistance range provides protection where static control is critical.



Advantages

- $10^6 - 10^9$ ohms floor resistance range protects sensitive equipment
- Epoxy primer provides aggressive bond to substrate
- Color stability
- Superior gloss retention
- Resists certain aggressive chemicals
- Economical

Uses

- Electronics production
- Clean rooms
- Computer rooms
- Aircraft hangars

Typical Physical Properties

Color	Standard Colors Computerized custom color matching available upon request
VOC (Volatile Organic Content) EPA method 24 SCAQMD Method 304	Compliant Compliant
Static Dissipative	$10^6 - 10^9$ ohms
Abrasion Resistance ASTM D 4060, CS-17 Wheel, 1,000 cycles	0.1 grams lost
Resistance to Elevated Temperatures MIL-D-3134J	No slip or flow at required temperature of 158°F
Hardness, Sward ASTM D 2240	30
Adhesion ASTM D 4541	300 psi concrete failure
Flammability	Self-extinguishing over concrete
Gloss 60° Gloss Meter @ 73°F, 50% RH	80-100 pts
Impact Resistance MIL-D-3134J	Direct, inch pound greater than 160 passes Reverse, inch pound greater than 160 passes

Installation

The following information is to be used as a guideline for the installation of the STATIC DISSIPATIVE COATING SYSTEM #18 SD. Contact the Technical Service Department for assistance prior to application.

Surface Preparation - General

General Polymers systems can be applied to a variety of substrates, if the substrate is properly prepared. Preparation of surfaces other than concrete will depend on the type of substrate, such as wood, concrete block, quarry tile, etc. Should there be any questions regarding a specific substrate or condition, please contact the Technical Service Department prior to starting the project. Refer to Surface Preparation (Form G-1).

Surface Preparation - Concrete

Concrete surfaces shall be abrasive blasted to remove all surface contaminants and laitance. The prepared concrete shall have a minimum surface profile equal to 40-60 grit sandpaper.

After initial preparation has occurred, inspect the concrete for bug holes, voids, fins and other imperfections. Protrusions shall be ground smooth while voids shall be filled with a General Polymers system filler. For recommendations, consult the Technical Service Department.

Temperature

Throughout the application process, substrate temperature should be 50°F - 90°F. Substrate temperature must be at least 5°F above the dew point. Applications on concrete substrates should occur while temperature is falling to lessen offgassing. The material should not be applied in direct sunlight, if possible.

Application Information

Material	Mix Ratio	Theoretical Coverage Per Coat	Packaging
3524	1:1 Wait 30 minutes for induction period	250 sq. ft. / gal.	2 or 10 gals
4618E (2 coats recommended)	2:1	300 sq. ft. / gal.	3 or 15 gals

NOTE: Epoxy materials may tend to blush at the surface especially in humid environments. After surface is primed and before installation of each subsequent coat, surface must be examined for blush (a whitish greasy film and/or low gloss). The blush must be completely removed prior to recoating using warm detergent water or through solvent wipe.

Primer - Conductive Primer Mixing and Application

1. Premix 3524A (resin) and 3524B (hardener) separately, using a low speed drill and Jiffy blade. Mix for one minute and until uniform, exercising caution not to whip air into the material.

2. Add 1 part 3524A (resin) to 1 part 3524B (hardener) by volume. Mix with low speed drill and Jiffy blade for three minutes and until uniform. Wait 30 minutes for induction period, restir and apply using a short nap roller at a rate of 250 square feet per gallon (6 WFT mils). Allow to cure at least 5 hours prior to coating placement but no more than 24 hours.

3. Inspect primer coat prior to application of topcoat. Test surface resistance in accordance with NFPA 99. Resistance range should be less than 150,000 ohms. If deviation from this range occurs, consult the Technical Service Department immediately.

Seal Coat Mixing and Application

1. Premix 4618EA (resin) using a low speed drill and Jiffy blade. Mix for one minute and until uniform, exercising caution not to whip air into the material.

2. Add 2 parts 4618EA (resin) to 1 part 4618B (hardener) by volume. Mix with low speed drill and Jiffy blade for three minutes and until uniform. Apply material via airless spray or roller at a spread rate of 300 sq. ft. per gallon to yield 5 mils WFT. **NOTE: Complete mixing of components is critical to performance, mix for a minimum of 4 minutes prior to application.**

3. Allow to cure overnight. In order to assure proper adhesion, lightly sand or abrade between coats.

4. Repeat Steps 1-3 as above for second coat.

5. Allow to cure 24 hours minimum before opening to light foot traffic.

Static Control Floors

Static control flooring can be defined as a flooring system that can drain and/or dissipate static charges by grounding personnel, equipment or other objects contacting the floor surface or that controls the generation and accumulation of static charges. The resistance to the movement of electrons across the material's surfaces defines static control floorings into the following two categories:

i) Conductive Floor has a resistance of 2.5×10^4 - 10^6 ohms per 3 ft. It can drain static charge dissipating a 5,000 - volt charge to zero in 0.05 seconds.

ii) Static Dissipative Floor has a resistance of 10^6 - 10^9 ohms per 3 ft. It adds no static electricity to the environment and drains off a 5,000 - volt charge to zero in less than 0.2 seconds.

A conductive floor has a much lower electrical resistance than a dissipative floor. It will carry the static charges to a ground quickly and efficiently as to prevent accidental discharge and ignition. If the floor is too conductive, an operator on the floor can become too effectively grounded and will suffer electrical shock. For this reason the NFPA requires all flooring surfaces to have a minimum resistance of 25,000 ohms. Frequent contact between tools and equipment, or dropping the tools on the floor, will cause spark and ignition. For those circumstances, a sparkproof conductive flooring system is highly recommended. The rapid rate of charge dissipation of conductive flooring can create a magnetic field which can present a problem for manufacturers of electronic components.

Dissipative flooring systems have greater resistance to electric current flow than conductive floorings. At a working environment dealing with high test voltages, such as facilities where electronic components are manufactured or assembled, a dissipative floor should be installed so that the static charges can be gradually transferred to ground, protecting personnel from electrical shock while at the same time protecting sensitive electronic equipment.

Conductive Flooring Measurement Guide

There are three test standards available for the evaluation of static dissipative or conductive floors and they are ANSI/ESD-S7.1, ASTM F 150 and NFPA 99 (56A). These test methods describe three types of measurements to be taken, which are summarized below:

- (1) Surface-to-surface resistance — Two 2.5 inch diameter electrodes, each weighing 5 lbs, are placed 3 ft apart on the floor. Apply the prescribed voltage (either 500VDC for conductive flooring or 100VDC for static dissipative flooring) and take the readings 5 seconds after the application of voltage or once the reading has reached equilibrium. The resistance in ohms is read on a properly calibrated Megohmmeter ("megger").
- (2) Point-to-groundable point resistance---An electrode with a 2.5 inch diameter and a weighing 5 lbs is connected to a Megohmmeter and placed on the surface being tested. The other megger lead is connected directly to a groundable point on the surface being tested.
- (3) Surface resistance — Two parallel metal electrodes of equal length and cross section are placed on the surface being tested. The distance between the electrodes should be the same as the length of the electrodes. Resistance is read on a Megohmmeter connected to the two electrodes and is expressed in ohms/square.

For quality control and lab procedures, the surface-to-surface test is most convenient. The measurements of point-to-groundable point test on smaller lab samples usually vary considerably from readings on a practical large floor. Based on these test results a facility manager can check if the flooring conforms to the specification when initially installed and track continual performance of the floor periodically.

NFPA 99 requires 5 measurements in each room and the average of the five readings is used as to determine the resistance level. ANSI/ESD standards also require 5 measurements per room and a minimum of 5 tests per 5,000 square feet for larger areas. At least 3 of the 5 readings must be conducted in areas of wear due to traffic, chemical or water exposure. The ANSI/ESD and NFPA standards require testing records to include date, temperature, humidity, testing voltage, duration of the test and the equipment used.

Maintenance of Resinous Static Control Floors

Providing floors with good maintenance is always the best solution to lasting service life for any type of floor. The standard of NFPA 99 describes appropriate maintenance for a conductive floor to maintaining conductive property through its service life. There are four maintenance guidelines for static dissipative floors.

- i) The surface of conductive or dissipative floors shall not be insulated by a film of oil or wax. Any waxes, polishes, or dressings used for maintenance of conductive floors shall not adversely affect the conductivity of the floor.
- ii) Floors that depend upon applications of water, salt solutions, or other treatment of a nonpermanent nature for their conductivity are not acceptable.
- iii) Cleaning instructions for conductive and dissipative floors shall be established, such as a daily basic cleaning, non-abrasive brush or pads being used and requirements for cleaners, then carefully followed to assure that conductivity characteristics of the floor are not adversely affected by such treatment.
- iv) The floor's resistance shall be periodically tested to ensure it still falls the range as initially specified.

Application Equipment Brush / Roller

Use 1/4" phenolic core rollers and professional quality, medium stiff natural bristle brushes.

Cleanup

Clean up mixing and application equipment immediately after use. Use toluene or xylene. Observe all fire and health precautions when handling or storing solvents.

Safety

Refer to the MSDS sheet before use. All applicable federal, state, local and particular plant safety guidelines must be followed during the handling and installation and cure of these materials.

Safe and proper disposal of excess materials shall be done in accordance with applicable federal, state, and local codes.

Material Storage

Store materials in a temperature controlled environment (50°F - 90°F) and out of direct sunlight.

Keep resins, hardeners, and solvents separated from each other and away from sources of ignition. One year shelf life is expected for products stored between 50°F - 90°F.

Maintenance

Occasional inspection of the installed material and spot repair can prolong system life. For specific information, contact the Technical Service Department.

Shipping

- Destinations East of the Rocky Mountains are shipped F.O.B. Cincinnati, Ohio.
- Destinations West of the Rocky Mountains are shipped F.O.B. Victorville, California.

For specific information relating to international shipments, contact your local sales representative.

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