



ES6321 Epoxy Coating

DESCRIPTION

WYN-STIK ES6321 is a reddish-brown, two component, chemical resistant epoxy protective coating for concrete, clay pipe and other structures. ES6321 is a solventless, 100% solids coating that is fluid enough to be applied by brush or roller. The cured film has very good resistance to water and chemicals. It is also very resistant to attack by corrosive fumes and sewer gases. This makes it ideal for use in waste treatment areas, sewage lines, and manholes and vaults.

TYPICAL APPLICATIONS

ES6321 has been used extensively for coating manholes, sewer lines and catch basins, vaults and enclosures, and other concrete surfaces and structures. ES6321 is approved and specified by the Bureau of Engineering, City of Los Angeles for use in these areas.

PRODUCT SPECIFICATIONS

	ES6321 A	ES6321 B	ASTM Method
Color	Reddish Brown	Amber	Visual
Viscosity, centipoise	36,000 cps	100 cps	D2392
Specific Gravity, gms./cc	1.43	1.01	D1475
Mix Ratio	100 : 8 By Weight 100 : 11 or, 9 to 1 By Volume		PTM&W
Pot Life, 4 fl. Oz. Mass @ 77°F	30 - 45 minutes		D2471

DIRECTIONS FOR USE

PREPARATION: All surfaces to be patched or bonded must be free of dirt, oil and grease. Refer to “WYN-STIK Surface Preparation Guidelines” bulletin for specific recommendations for various surfaces.

MIXING: Mix A and B components at the proper ratio until uniform in color and consistency. Mix for 1 to 2 minutes, scraping the sides and bottom of container to avoid leaving unmixed material that will cause soft spots in the cured product. After mixing, ES6321 must be used within 30 minutes.

APPLICATION and CURING: ES6321 is usually applied with conventional paint roller equipment. This is the most efficient method. ES6321 is not designed to be sprayed. It can be applied by brushing, however, and this is sometimes preferred when the area to be coated is small. The dry film thickness that is typically specified for optimum coating performance is 30 mils. Two to four coats of ES6321 will provide a 30 mil cured film, depending upon surface orientation, condition and porosity. The coverage for ES6321 will vary, depending upon surface condition. Generally, at a 30 mil cured film thickness on a smooth non-porous surface, the coverage is 50 - 60 square feet per gallon. It is better to apply several thin coats rather than thick coats. Thicker coats tend to sag and run, requiring more labor to repair than would be required to apply the thinner coats in the first place. Recoat time between coats is 4 - 6 hours at 75°F ambient temperature. ES6321 will cure to 90% of ultimate properties in 24 hours at 75°F. Full cure is achieved in 7 days at room temperature.

TYPICAL MECHANICAL PROPERTIES

	ES6321 A/B	ASTM Method
Mix Ratio	100 : 8 By Weight 100 : 11 or, 9 to 1 By Volume	PTM&W
Pot Life, @ 77°F	30 - 45 minutes	D2471
Color	Reddish Brown	Visual
Mixed Viscosity, @ 77°F, centipoise	11,000 cps	D2393
Cured Hardness, Shore D	90 Shore D	D2240
Specific Gravity, grams, cc	1.38	D1475
Density, lb./cu. Inch lb./gallon	.0498 lb./cu.inch 11.5 lb./Gallon	D792
Specific Volume, cu. in./lb.	19.9 cu.in./lb.	D792
Tensile Strength, cast bar, psi	9,500 psi	D638
Tensile Elongation	4 %	
Water Absorption	< 0.05 %	D570
Aluminum to Aluminum Tensile Lap Shear Strength	900 psi	D1002
Dielectric Strength	950 volts / mil	D149

PACKAGING WEIGHTS

	Gallon Kit	Pail Kit	Drum Kit
ES6321 Part A	10 lb.	50 lb.	500 lb.
ES6321 Part B	.8 lb.	4 lb.	40 lb.
Kit	10.8 lb.	54 lb.	540 lb.

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