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# ARMORGARD 541FST

## THIXOTROPIC FOAM MOLD COATING

**SOLVENT FREE-ZERO VOC  
SINGLE COAT APPLICATION  
LOW HEAT ON CURE**

**EXTREMELY TOUGH, NON BRITTLE SURFACE  
SEALS HOTWIRE CUT FOAM PATTERNS  
DOES NOT DISTORT MOLD SHAPE**

### PRODUCT GENERAL INFORMATION

Armorgard 541FST is a 100% solids, thixotropic, primerless, odorless epoxy coating for foam patterns and molds used in precast concrete applications. Armorgard 541FST is formulated to provide a hard, tough coating for EPS foam and Styrofoam without the use of hazardous – foam damaging solvents. Use of Armorgard 541FST transforms a “rough” foam structure into a hard, sandable surface, creating an “architectural” quality cast.

Armorgard 541FST provides a convenient work life. Armorgard 541FST was designed from conception to be the ideal foam coating. The product is colored for an easy visual check of thickness.

Armorgard 541FST can be easily applied with a roller or brush. Normal application thickness is 15-30 mil (0.38-0.76 mm). Application varies depending on the porosity and roughness of the surface. A single build may be applied to horizontal surfaces up to 1/8" thick (125 mil or 0.3 cm). Armorgard 541FST is conveniently packaged in pre-measured 4 gallon kits with bulk kit sizes available upon request. Armorgard 541FST is dyed light blue to provide an easy visual check for application thickness as well as to serve as a wear indicator.

### HANDLING PROPERTIES @ 77 °F (25 °C)

COMPONENTS	Resin, Hardener	
WEIGHT PER GALLON (MIXED)	8.30	
DENSITY (MIXED) kg/l	0.99	
MIX RATIO, pbv	5/1	
COLOR	Lt. Blue	
MIXED VISCOSITY, cP or mPa.s	6,400	ASTM D 2196
WORKING TIME, min	6	
GEL TIME, min	11	
TACK-FREE TIME, h	3-4	
INITIAL CURE, h	7-10	
APPLICATION TEMPERATURE, °F (°C)		
Ideal	70-80 (21-27)	
Acceptable	55-90 (13-32)	
COVERAGE* @ 15 mil or 0.38 mm, ft <sup>2</sup> /gal (m <sup>2</sup> /l)	107 (2.6)	
HARDNESS, Shore D	79	ASTM D 2240
MAXIMUM SERVICE TEMPERATURE, °F (°C)	215 (102)	

\*Varies with porosity of surface

## **SURFACE PREPARATION**

To achieve excellent adhesion, the substrate should be free of all loose and foreign material and should be clean. If present, any oils, greases, or other contaminants must be removed prior to coating. Armorgard 541FST will not bond to a contaminated surface.

## **AMBIENT CONDITIONS**

Relative humidity and dew point must be determined before application to avoid adhesion failures. The dew point is used to predict the substrate temperature at which air begins to condense, in the form of water, on the substrate. Never apply a coating unless the form surface temperature is 5 °F (2.5 °C) above the dew point. This temperature difference must be observed until the epoxy coating is cured to a tack-free state. A dew point calculation chart is available from a Copps Technical Representative.

Armorgard 541FST will soften when exposed to extreme precast temperatures. A service temperature of no greater than 110 °F (43 °C) is recommended when removing forms coated with Armorgard 541FST.

## **MIXING**

Mix 5 parts A (resin) to 1 part B (hardener) for 3 minutes using a Jiffy Mixer and a slow speed drill. Mix at slow speed (less than 500 rpm) to avoid air entrainment. DO NOT mix more material than can be used within the stated working time. REMEMBER - you will have less working time at higher temperatures.

## **APPLICATION**

Armorgard 541FST can be applied with a squeegee, brush, non-shedding roller or a grooved fiberglass roller. Re-coating a used foam piece may require a light sanding to remove any residue from previous casts.

## **CLEAN-UP**

Armorgard 541FST, before it is fully cured (hard), may be removed from tools with Copps Enviro Kleen solvent or warm soapy water.

## **SAFETY PRECAUTIONS**

Avoid breathing of vapors. Forced local exhaust is recommended to effectively minimize exposure. NIOSH approved, organic vapor respirators and forced exhaust are recommended in confined areas, or when conditions (such as heated polymer, sanding) may cause high vapor concentrations. Do not weld on, burn or torch Armorgard 541FST or any epoxy material. Hazardous vapor is released when an epoxy is burned.

Avoid skin or eye contact. Wash skin with soap and water if contact occurs. If eye contact occurs flush with water for 15 minutes and obtain medical attention.

Read and understand all cautions on can labels and material safety data sheets before using this material.

## **WARRANTY AND DISCLAIMER**

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