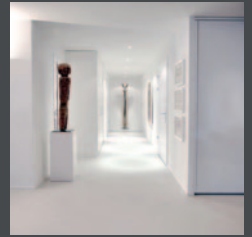
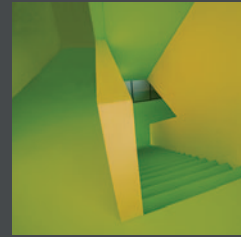


# Waterborne Epoxy Systems

selection guide





# Waterborne Epoxy S

## About us...

Incorez Ltd is a leading manufacturer of specialist resins and polymers - excelling in the development of high performance, low hazard materials, particularly waterborne and high solids systems.

Incorez is also a global leader in oxazolidine chemistry, manufacturing a diverse range of products marketed under the Incozol<sup>®</sup> umbrella.

The Incozol<sup>®</sup> range has been widely adopted in 1K and 2K polyurethane coatings, as well as 1K polyurethane sealants, where they operate as moisture scavengers, reactive diluents and latent curing agents.

In addition, the company is a global partner in waterborne, low hazard technology, manufacturing a wide range of waterborne aliphatic polyurethane dispersions and a range of waterborne epoxy curing agents. These materials, marketed under the Incorez<sup>®</sup> brand, are used extensively in high performance coatings across a broad spectrum of applications.



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# Technical Data

| Product                | Features & Benefits  | Typical Applications  |
|------------------------|--|---|
| <b>Incorez 142</b>     | Reactive, emulsified curing agent for epoxy resins, giving fast touch-dry times. Good stability and good gloss/gloss retention. Visible end of pot life and low viscosity.               | <ul style="list-style-type: none"> <li>• Clear sealers</li> <li>• Floor paints</li> <li>• Wall paints</li> <li>• High gloss coatings</li> <li>• Hygiene coatings</li> </ul> |
| <b>Incorez 148/010</b> | Waterborne reactive polyamine adduct with long pot life and low viscosity. Complete compatibility with cement and calcium salts. Particularly well suited for high temperature climates. | <ul style="list-style-type: none"> <li>• Concrete primers</li> <li>• Coatings for green concrete</li> <li>• Epoxy cement mortars</li> </ul>                                 |
| <b>Incorez 148/024</b> | Waterborne reactive polyamine adduct with low viscosity and fast cure. Excellent gloss retention and chemical resistance.  | <ul style="list-style-type: none"> <li>• Concrete primers/sealers</li> <li>• Floor paints</li> <li>• Wall paints</li> <li>• Hygiene coatings</li> </ul>                     |
| <b>Incorez 148/700</b> | Waterborne reactive polyamine adduct for liquid epoxy resins. Specifically designed for use in high build systems of 1-3mm film thickness. Low viscosity and low odour.                  | <ul style="list-style-type: none"> <li>• Self-levelling floor coatings (1-3mm)</li> <li>• Epoxy mortar systems</li> <li>• Epoxy grouts</li> </ul>                           |

### Typical Properties

| Amine Value (mg KOH/g) | AHEW | Addition Levels (phr) | Viscosity @ 20°C (mPa.s) | Density (g/cm <sup>3</sup> ) | Colour (Gardner)     | Solids (%) | Flash Point (°C) | Solvent                        |
|------------------------|------|-----------------------|--------------------------|------------------------------|----------------------|------------|------------------|--------------------------------|
| 160                    | 250  | 125                   | 10,000                   | 1.08                         | Pale Yellow Emulsion | 55 ± 1     | >100             | 1.25% Methoxy Propanol + Water |
| 200                    | 140  | 75                    | 14,000                   | 1.06                         | Max 6                | 80 ± 1     | >100             | Water                          |
| 220                    | 140  | 75                    | 40,000                   | 1.06                         | Max 6                | 80 ± 1     | >100             | Water                          |
| 230                    | 200  | 100                   | 10,000                   | 1.08                         | <2                   | 55 ± 1     | >100             | Water                          |

# Concrete Primer



One of the main uses for two pack waterborne epoxy systems has been as dust sealers for porous substrates and primers for fresh (green) concrete. Waterborne epoxies have excellent penetration and adhesion to these types of substrates.

**Formulation:** **Clear Primer** using **Incorez 148/024**

**Features:**

- Faster drying
- Zero VOC
- High gloss
- Good hardness
- Excellent adhesion (including green concrete)

| Formulation         |                        |                |                 |
|---------------------|------------------------|----------------|-----------------|
| Part A              | Material               | Supplier       | Parts by Weight |
| 1. Polyamine Adduct | <b>Incorez 148/024</b> | <b>Incorez</b> | 27.08           |
| 2. Wetting Agent    | BYK-349                | BYK            | 0.20            |
| 3. Defoamer         | BYK-1711               | BYK            | 0.20            |
| 4. Diluent          | Water                  | Local          | 11.38           |
| Part B              | Material               | Supplier       | Parts by Weight |
| Epoxy Resin         | D.E.R 353              | Dow            | 37.72           |
| Part C              | Material               | Supplier       | Parts by Weight |
| Diluent             | Water                  | Local          | 23.42           |
| <b>TOTAL</b>        |                        |                | <b>100</b>      |

Manufacturing instructions are available on request.

| Properties                  |       |
|-----------------------------|-------|
| % Solids (w/w)              | 59.76 |
| % Solids (v/v)              | 56.90 |
| VOC (g/L)                   | 0     |
| PHR                         | 72    |
| Potlife @ 20°C (hours)      | 1½    |
| BK Surface dry time (hours) | 3     |
| BK Through dry time (hours) | 6     |
| Gloss (60°) - 7 day         | 132   |
| Hardness (Persoz)           |       |
| 1 Day                       | 118   |
| 7 Day                       | 216   |

These formulations are intended as a guide only and no guarantees are implied nor liabilities accepted. It is the responsibility of the formulator to thoroughly test the formulations to ensure suitability for intended use.

# Concrete Primer

One of the main uses for two pack waterborne epoxy systems has been as dust sealers for porous substrates and primers for fresh (green) concrete. Waterborne epoxies have excellent penetration and adhesion to these types of substrates.

**Formulation:** **Clear Primer** using **Incorez 148/010**

## Features:

- Long pot life (suited to use in high temperature climates)
- High gloss
- Excellent adhesion (including green concrete)



| Formulation         |                         |                |                 |
|---------------------|-------------------------|----------------|-----------------|
| Part A              | Material                | Supplier       | Parts by Weight |
| 1. Polyamine Adduct | <b>Incorez 148/010</b>  | <b>Incorez</b> | 11.06           |
| 2. Wetting Agent    | BYK-349                 | BYK            | 0.25            |
| 3. Defoamer         | BYK-1711                | BYK            | 0.25            |
| 4. Diluent          | Water                   | Local          | 11.06           |
| Part B              | Material                | Supplier       | Parts by Weight |
| Epoxy Resin         | Beckopox EP 384w/53WAMP | Huntsman       | 77.38           |
| <b>TOTAL</b>        |                         |                | <b>100</b>      |

Manufacturing instructions are available on request.

| Properties                  |       |
|-----------------------------|-------|
| % Solids (w/w)              | 50.35 |
| % Solids (v/v)              | 45.77 |
| VOC (g/L)                   | 50    |
| PHR                         | 14    |
| Potlife @ 20°C (hours)      | 3     |
| BK Surface dry time (hours) | 6½    |
| BK Through dry time (hours) | 10    |
| Gloss (60°) - 7 day         | 145   |
| Hardness (Persoz)           |       |
| 1 Day                       | 75    |
| 7 Day                       | 159   |

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# Concrete Sealer



Waterborne epoxy systems are ideal for use as dust sealers on concrete. Not only do they help keep the area dust free but they make cleaning much easier. In addition, they provide excellent chemical resistance and prevent staining of the concrete.

**Formulation:** **Clear Sealer** using **Incorez 142**

**Features:**

- High gloss
- Excellent hardness
- Good chemical & water resistance

| Formulation                |                    |                |                 |
|----------------------------|--------------------|----------------|-----------------|
| Part A                     | Material           | Supplier       | Parts by Weight |
| 1. Emulsified Curing Agent | <b>Incorez 142</b> | <b>Incorez</b> | 42.04           |
| 2. Wetting Agent           | BYK-349            | BYK            | 0.45            |
| 3. Defoamer                | BYK-1711           | BYK            | 0.45            |
| 4. Diluent                 | Water              | Local          | 14.32           |
| Part B                     | Material           | Supplier       | Parts by Weight |
| Epoxy Resin                | Polypox E 411      | Dow            | 33.64           |
| Part C                     | Material           | Supplier       | Parts by Weight |
| Diluent                    | Water              | Local          | 9.10            |
| <b>TOTAL</b>               |                    |                | <b>100</b>      |

Manufacturing instructions are available on request.

| Properties                  |       |
|-----------------------------|-------|
| % Solids (w/w)              | 57.70 |
| % Solids (v/v)              | 54.95 |
| VOC (g/L)                   | 22    |
| PHR                         | 125   |
| Potlife @ 20°C (hours)      | 1     |
| BK Surface dry time (hours) | 6     |
| BK Through dry time (hours) | 12    |
| Gloss (60°) - 7 day         | 151   |
| Hardness (Persoz)           |       |
| 1 Day                       | 189   |
| 7 Day                       | 352   |

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# Concrete Sealer

Waterborne epoxy systems are ideal for use as dust sealers on concrete. Not only do they help keep the area dust free but they make cleaning much easier. In addition, they provide excellent chemical resistance and prevent staining of the concrete.

Formulation: **Clear Sealer** using **Incorez 148/024**

## Features:

- Zero VOC
- High gloss
- Good hardness
- Excellent chemical & water resistance



| Formulation         |                        |                |                 |
|---------------------|------------------------|----------------|-----------------|
| Part A              | Material               | Supplier       | Parts by Weight |
| 1. Polyamine Adduct | <b>Incorez 148/024</b> | <b>Incorez</b> | 31.82           |
| 2. Wetting Agent    | BYK-349                | BYK            | 0.45            |
| 3. Defoamer         | BYK-1711               | BYK            | 0.45            |
| 4. Diluent          | Water                  | Local          | 12.72           |
| Part B              | Material               | Supplier       | Parts by Weight |
| Epoxy Resin         | Polypox E 411          | Dow            | 45.45           |
| Part C              | Material               | Supplier       | Parts by Weight |
| Diluent             | Water                  | Local          | 9.11            |
| <b>TOTAL</b>        |                        |                | <b>100</b>      |

Manufacturing instructions are available on request.

| Properties                  |       |
|-----------------------------|-------|
| % Solids (w/w)              | 71.80 |
| % Solids (v/v)              | 67.74 |
| VOC (g/L)                   | 0     |
| PHR                         | 70    |
| Potlife @ 20°C (hours)      | 1     |
| BK Surface dry time (hours) | 5     |
| BK Through dry time (hours) | 9     |
| Gloss (60°) - 7 day         | 159   |
| Hardness (Persoz)           |       |
| 1 Day                       | 132   |
| 7 Day                       | 261   |

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# Floor Paint



With physical characteristics such as excellent abrasion and impact resistance, together with high chemical, water and solvent resistance, Incorez waterborne epoxy curing agents are ideally suited for use in industrial and decorative floor paints.

**Formulation: Grey Gloss** using **Incorez 142**

**Features:**

- High gloss
- Fast surface drying
- Excellent hardness
- Good chemical & water resistance
- Good abrasion resistance

| Formulation                                   |                    |                     |                 |
|---|--------------------|---------------------|-----------------|
| Part A  | Material           | Supplier            | Parts by Weight |
| 1. Emulsified Curing Agent                    | <b>Incorez 142</b> | <b>Incorez</b>      | 15.65           |
| 2. Defoamer                                   | BYK-1711           | BYK                 | 0.40            |
| 3. Wetting & Dispersing Agent                 | Disperbyk 180      | BYK                 | 1.00            |
| 4. Diluent                                    | Water              | Local               | 6.00            |
| 5. Pigment                                    | Tiona 595          | Cristal Global      | 10.30           |
| 6. Filler                                     | Mistron R 20G      | IMERYS              | 11.00           |
| 7. Black Pigment                              | Raven 500          | Columbian Chemicals | 0.10            |
| 8. Wetting & Levelling Agent                  | Envirogem AD 01    | Air Products        | 0.40            |
| 9. Co-Solvent<br>(Benzyl Alcohol Replacement) | Dowanol DPH 255    | Dow                 | 2.00            |
| 10. Diluent                                   | Water              | Local               | 6.15            |
|   |                    |                     | <b>53.00</b>    |

| Part B       | Material          | Supplier | Parts by Weight |
|--------------|-------------------|----------|-----------------|
| Epoxy Resin  | Beckopox EP 2384W | Cytec    | 47.00           |
| <b>TOTAL</b> |                   |          | <b>100</b>      |

Manufacturing instructions are available on request.

| Properties                  |       |
|-----------------------------|-------|
| % Solids (w/w)              | 58.20 |
| % Solids (v/v)              | 46.56 |
| PVC (%)                     | 8.75  |
| VOC (g/L)                   | 10    |
| PHR                         | 33.33 |
| Potlife @ 20°C (hours)      | 1½    |
| BK Surface dry time (hours) | 2     |
| BK Through dry time (hours) | 9½    |
| Gloss (60°) - 7 day         | 90    |
| Hardness (Persoz)           |       |
| 1 Day                       | 128   |
| 7 Day                       | 273   |

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# Floor Paint

With physical characteristics such as excellent abrasion and impact resistance, together with high chemical, water and solvent resistance, Incorez waterborne epoxy curing agents are ideally suited for use in industrial and decorative floor paints.

**Formulation: Grey Matt** using **Incorez 142**

## Features:

- Matt finish
- Good chemical & water resistance
- Good hardness
- Good abrasion resistance



| Formulation                                    |                      |                     |                 |
|--|----------------------|---------------------|-----------------|
| Part A   | Material             | Supplier            | Parts by Weight |
| 1. Emulsified Curing Agent                     | <b>Incorez 142</b>   | <b>Incorez</b>      | 20.00           |
| 2. Defoamer                                    | BYK-1711             | BYK                 | 0.54            |
| 3. Wetting & Dispersing Agent                  | Disperbyk 180        | BYK                 | 1.08            |
| 4. Diluent                                     | Water                | Local               | 7.15            |
| 5. Pigment                                     | Tiona 595            | Cristal Global      | 17.00           |
| 6. Filler                                      | Mistron R 20G        | IMERYS              | 17.00           |
| 7. Black Pigment                               | Raven 500            | Columbian Chemicals | 0.15            |
| 8. Matting Agent                               | AceMATT TS 100       | Evonik              | 1.50            |
| 9. Wetting & Levelling Agent                   | Envirogem AD 01      | Air Products        | 0.50            |
| 10. Co-Solvent<br>(Benzyl Alcohol Replacement) | Dowanol DPH 255      | Dow                 | 2.67            |
| 11. Diluent                                    | Water                | Local               | 11.21           |
|  |                      |                     | <b>78.80</b>    |
| Part B   | Material             | Supplier            | Parts by Weight |
| Epoxy Resin                                    | Araldite PZ 33757/67 | Huntsman            | 21.20           |
| <b>TOTAL</b>                                   |                      |                     | <b>100</b>      |

Manufacturing instructions are available on request.

| Properties                  |  |       |
|-----------------------------|--|-------|
| % Solids (w/w)              |  | 62.76 |
| % Solids (v/v)              |  | 45.48 |
| PVC (%)                     |  | 15    |
| VOC (g/L)                   |  | 10    |
| PHR                         |  | 94    |
| Potlife @ 20°C (hours)      |  | 1½    |
| BK Surface dry time (hours) |  | 4     |
| BK Through dry time (hours) |  | 8     |
| Gloss (60°) - 7 day         |  | 4     |
| Hardness (Persoz)           |  |       |
| 1 Day                       |  | 164   |
| 7 Day                       |  | 206   |

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# Floor Paint



With physical characteristics such as excellent abrasion and impact resistance, together with high chemical, water and solvent resistance, Incorez waterborne epoxy curing agents are ideally suited for use in industrial and decorative floor paints.

**Formulation: Red Semi-Gloss** using **Incorez 148/024**

**Features:**

- Semi-gloss finish
- Zero VOC
- Good hardness
- Excellent chemical & water resistance
- Good abrasion resistance

| Formulation                                   |                        |                    |                 |
|---|------------------------|--------------------|-----------------|
| Part A  | Material               | Supplier           | Parts by Weight |
| 1. Polyamine Adduct                           | <b>Incorez 148/024</b> | <b>Incorez</b>     | 21.13           |
| 2. Defoamer                                   | BYK-1711               | BYK                | 0.54            |
| 3. Wetting & Dispersing Agent                 | Disperbyk 180          | BYK                | 1.33            |
| 4. Diluent                                    | Water                  | Local              | 7.00            |
| 5. Pigment Red Oxide                          | Kroma RO 5097          | Elementis Pigments | 10.00           |
| 6. Filler                                     | Mistron R 20G          | IMERYS             | 12.00           |
| 7. Wetting & Levelling Agent                  | Envirogem AD 01        | Air Products       | 0.50            |
| 8. Co-Solvent<br>(Benzyl Alcohol Replacement) | Dowanol DPH 255        | Dow                | 2.67            |
| 9. Diluent                                    | Water                  | Local              | 4.83            |
|   |                        |                    | <b>60.00</b>    |

| Part B       | Material             | Supplier | Parts by Weight |
|--------------|----------------------|----------|-----------------|
| Epoxy Resin  | Araldite PZ 33757/67 | Huntsman | 40.00           |
| <b>TOTAL</b> |                      |          | <b>100</b>      |

Manufacturing instructions are available on request

| Properties                  |       |
|-----------------------------|-------|
| % Solids (w/w)              | 67.80 |
| % Solids (v/v)              | 53.80 |
| PVC (%)                     | 8     |
| VOC (g/L)                   | 0     |
| PHR                         | 53    |
| Potlife @ 20°C (hours)      | 1½    |
| BK Surface dry time (hours) | 4     |
| BK Through dry time (hours) | 9     |
| Gloss (60°) - 7 day         | 70    |
| Hardness (Persoz)           |       |
| 1 Day                       | 140   |
| 7 Day                       | 230   |

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# Wall Paint

Incorez waterborne epoxy curing agents are ideally suited for the formulation of high performance coatings. Their excellent adhesion to a wide variety of substrates makes them particularly suited for use in hygiene coatings and for application in areas such as food factories, abattoirs, dairies, etc.

**Formulation: White Gloss** using **Incorez 142** & **Incorez 148/024**

## Features:

- Gloss finish
- Excellent hardness
- Easy to clean
- Can be formulated into a hygiene coating
- Excellent chemical & water resistance



| Formulation                                   |                        |                |                 |
|---|------------------------|----------------|-----------------|
| Part A  | Material               | Supplier       | Parts by Weight |
| 1. Emulsified Curing Agent                    | <b>Incorez 142</b>     | <b>Incorez</b> | 21.76           |
| 2. Polyamine Adduct                           | <b>Incorez 148/024</b> | <b>Incorez</b> | 5.44            |
| 3. Defoamer                                   | BYK-1711               | BYK            | 0.54            |
| 4. Wetting & Dispersing Agent                 | Disperbyk 180          | BYK            | 1.08            |
| 5. Diluent                                    | Water                  | Local          | 7.00            |
| 6. Pigment                                    | Tiona 595              | Cristal Global | 10.50           |
| 7. Filler                                     | Mistron R 20G          | IMERYS         | 12.00           |
| 8. Wetting & Levelling Agent                  | Envirogem AD 01        | Air Products   | 0.40            |
| 9. Co-Solvent<br>(Benzyl Alcohol Replacement) | Dowanol DPH 255        | Dow            | 2.67            |
| 10. Diluent                                   | Water                  | Local          | 5.28            |
|   |                        |                | <b>66.67</b>    |

| Part B       | Material             | Supplier | Parts by Weight |
|--------------|----------------------|----------|-----------------|
| Epoxy Resin  | Araldite PZ 33757/67 | Huntsman | 33.33           |
| <b>TOTAL</b> |                      |          | <b>100</b>      |

Manufacturing instructions are available on request.

| Properties                  |       |
|-----------------------------|-------|
| % Solids (w/w)              | 66.60 |
| % Solids (v/v)              | 52.54 |
| PVC (%)                     | 9     |
| VOC (g/L)                   | 12.85 |
| PHR                         | 82    |
| Potlife @ 20°C (hours)      | 2     |
| BK Surface dry time (hours) | 4½    |
| BK Through dry time (hours) | 10    |
| Gloss (60°) - 7 day         | 80    |
| Hardness (Persoz)           |       |
| 1 Day                       | 140   |
| 7 Day                       | 255   |

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# Self-Levelling Floor Coating



Incorez 148/700 has been designed to cure liquid epoxy resins in thick films, making it particularly suited for formulation into high-build self-levelling floor coatings. These coatings can be applied over damp and/or green concrete with minimal shrinkage and fast hardness and strength development. The high coefficient of water vapour permeability results in breathable flooring, eliminating the problems of blistering and debonding.

#### Features:

- Zero VOC
- Low odour
- Good adhesion
- Good physical properties
- Good compatibility with epoxy and polyurethane topcoats

| Formulation          |                         |                |                 |
|----------------------|-------------------------|----------------|-----------------|
| Part A               | Material                | Supplier       | Parts by Weight |
| 1. Polyamine Adduct  | <b>Incorez 148/700</b>  | <b>Incorez</b> | 10.00           |
| 2. Defoamer          | BYK-1615                | BYK            | 0.80            |
| 3. Diluent           | Water                   | Local          | 3.00            |
| 4. Pigment           | Tiona 595               | Cristal Global | 3.80            |
| 5. Filler            | EWO                     | Sachtleben     | 13.00           |
| 6. Filler            | Quartz Powder M6        | Sibelco        | 27.00           |
| 7. Filler            | Quartz Sand (0.1-0.3)   | Local          | 35.00           |
| 8. Thixotropic Agent | Deuteron VT 819 (3% aq) | Deuteron       | 0.40            |
| 9. Diluent           | Water                   | Local          | 7.00            |
| <b>Total</b>         |                         |                | <b>100</b>      |

| Part B      | Material  | Supplier | Parts by Weight |
|-------------|-----------|----------|-----------------|
| Epoxy Resin | D.E.R 358 | Dow      | 9.00            |

Manufacturing instructions are available on request.

| Properties                      |         |   |              |
|---------------------------------|---------|---|--------------|
| <b>Mixing Ratio</b>             |         | <b>Surface Finish</b>                         | <b>Matt</b>  |
| Weight                          | 100:9   | PVC (%)                                       | 68           |
| Volume                          | 6.0:1.0 | Binder Content (%)                            | 13.30        |
|                                 |         | Working Time (minutes)                        | 30           |
| <b>Density</b>                  |         | <b>Chemical Resistance 24 hour, Spot test</b> |              |
| Part A                          | 2.09    | 3% Acetic Acid                                | No Effect    |
| Part B                          | 1.12    | 10% NaOH                                      | No Effect    |
| Mix                             | 1.95    | Ethanol                                       | No Effect    |
| <b>Solid Content (Weight %)</b> |         | Xylene  | No Effect    |
|                                 |         | Water   | No Effect    |
| Part A                          | 85      | <b>Stain Resistance 24 hour, Spot test</b>    |              |
| Part B                          | 100     |   |              |
| Mix                             | 86      |   | Red Wine     |
| <b>Hardness (Shore D)</b>       |         | Tea   | No Effect    |
| 1 Day (20°C)                    | 60      | Coffee  | No Effect    |
| 7 Day (20°C)                    | 70      | Cola  | No Effect    |
| 1 Day (10°C)                    | 60      | Mustard                                       | Slight Stain |
| 7 Day (10°C)                    | 70      | Ketchup                                       | Slight Stain |

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# Comparison Charts

Curing agent selection chart

|                |                       | Incorez 142 | Incorez 148/010 | Incorez 148/024 | Incorez 148/700 |
|----------------|-----------------------|-------------|-----------------|-----------------|-----------------|
| Primer/ Sealer | Concrete Primer       |             | ●               | ●               |                 |
|                | Concrete Sealer       | ●           |                 | ●               |                 |
| Thin Film      | Industrial Flooring   | ●           |                 | ●               |                 |
|                | Decorative Flooring   | ●           |                 | ●               |                 |
|                | Walls                 | ●           |                 | ●               |                 |
| Thick Film     | Self-Levelling        |             |                 |                 | ●               |
|                | Epoxy Modified Cement |             | ●               |                 |                 |

● Recommended ● Suitable

Curing agent properties chart

| Property          | Incorez 142 | Incorez 148/010 | Incorez 148/024 | Incorez 148/700 |
|-------------------|-------------|-----------------|-----------------|-----------------|
| High Gloss        | ●           |                 | ●               |                 |
| Fast Cure         | ●           |                 | ●               | ●               |
| Long Pot Life     |             | ●               | ●               |                 |
| Low Viscosity     | ●           | ●               |                 | ●               |
| Ultimate Hardness | ●           |                 | ●               |                 |

● Recommended ● Suitable



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