



# HI BUILD EPOXY

- *For bare concrete, fiberglass, plaster, gunite and previously painted epoxy*
- *Self-priming, satin finish*
- *Easy to use 1:1 mix ratio*
- *VOC compliant in US and Canada*

## AVAILABLE IN THESE COLORS



**BLACK**  
321  
Accent Color Only



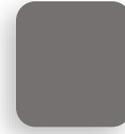
**DAWN BLUE**  
328



**WHITE**  
311



**BEACH BEIGE**  
355



**EDGEWATER GRAY**  
377

**Note:** Color differences may occur between actual color chips shown.

## SUPERIOR LONG LASTING EPOXY COATING

Ramuc Hi Build Epoxy™ provides unsurpassed stain, chemical and abrasion resistance. This superior high-build epoxy coating is formulated to provide the longest lasting finish of any pool paint. Packaged in an easy to use 1:1 mix ratio, Hi Build Epoxy rolls easily and builds up to 8 mils dry per coat, rendering "smoothing" qualities on rough surfaces. Two coats offer up to 8 years of service life.

## TECHNICAL INFORMATION

**VEHICLE TYPE:** Epoxy Polyamide

**FINISH:** Satin

**COMPONENTS:** 2

**MIX RATIO:** 1:1 by volume A:B

**CURING MECHANISM:** Chemical Cure

**POT LIFE:** 3 hours

**SOLIDS BY VOLUME:** 66% ± 2% mixed

**SOLIDS BY WEIGHT:** 80% ± 2% mixed

**COVERAGE:** 150-200 sq. ft./mixed 2 gallon kit on bare surface. 300-350 sq./ft mixed 2 gallon kit on previously coated and bare fiberglass/gelcoat surfaces.

**VOC:** 280 g/l max (as supplied)

**FLASH POINT:** 78° F (SETA)

**APPLICATION METHOD:** Brush, no thicker than 3/8" Mohair or Lambskin Roller, Airless or Conventional Spray  
**DRY FILM THICKNESS PER COAT:** Min 5 mils (7.5 mils wet), Max 8 mils (12.5 mils wet)

**NUMBER OF COATS:** 2 (product is self-priming)

**APPLICATION TEMP:** 50°F min/90°F max

**RECOAT TIME:** 16-72 hours. After 72 hours, must sand before applying 2<sup>nd</sup> coat.

**DRY TIME:** Outdoor Pool: 5-7 days before filling. Indoor Pool: 10-14 days before filling. Use adequate ventilation.



*This superior high build epoxy is formulated to provide the longest lasting finish of any pool paint.*

**COMPATIBILITY:** For compatibility purposes, the existing paint on previously painted surfaces of a pool should be determined before painting. **Use dark colors for accent painting only. Dark colors can prematurely fade or blister, especially in chemically treated water.**

**SURFACE REPAIRS AND JOINT/CRACK FILLER:** Plaster or concrete surfaces should be tested for integrity and soundness. Aged plaster should be checked for integrity. Check for hollow or weak/crumbling plaster by using a ball-peen hammer or any other comparable method. Perform repairs before painting. Power wash to remove loose paint and dirt. Any minor repairs, such as patching with hydraulic cement or filling of cracks, should be done and allowed to cure prior to surface prep. We suggest using Vulkem polyurethane sealant. Vulkem must be top-coated before being submersed in chemically treated water.

**SURFACE PREPARATION:** Coating performance, in general, is proportional to the degree of surface preparation. Follow recommendations carefully, avoiding shortcuts. Inadequate preparation of surfaces will virtually assure inadequate coating performance. We recommend using Ramuc Clean & Prep Solution™. Ramuc Clean & Prep Solution degreases and dissolves mineral deposits and increases porosity to create maximum adhesion. Unlike all other acid-based materials, Ramuc Clean & Prep Solution neutralizes via water and is safe to use near plants and grass. If surface is exceptionally hard, we recommend sanding with an #80 grit sandpaper to create surface profile prior to applying the first coat of Hi Build Epoxy. Follow package directions carefully. New concrete and plaster surfaces must be cured for 28 days prior to painting.

**CONDENSATION TEST:** After all cleaning is complete, allow the surface to dry. Average time varies according to climate and porosity of the substrate. 1) Tape 2' x 2' pieces of transparent plastic to areas in the deep end wall, floor and several of the other areas of the pool. 2) Wait about 4 hours to determine if condensation has formed underneath the plastic. 3) If condensation is evident, the surface is not dry enough to paint. 4) Remove the plastic and wait 24 hours to perform the test again and continue until no condensation forms. This ensures that the surface is dry enough to apply paint.

**APPLICATION:** Use no thicker than a 3/8" nap roller used for solvent based paints. DO NOT use rollers with cardboard cores. Apply at the recommended coverage rate. Ideal air temperatures for application are between 50° and 90° F. Surface temperature should be at least 50° F, no more than 90°F. Overnight curing temperatures must be at least 50°F or the paint will not cure properly causing an "oily" feel to the top of the paint. Do not paint when rain is imminent. New concrete and plaster surfaces must be cured a minimum of 28 days prior to painting.

**MIXING THE PAINT:** Hi Build Epoxy is self-priming; no other type of primer is recommended or should be used. Hi Build Epoxy has a 3 hour pot life (use life) once mixed. Using empty 5 gallon pails, mechanically mix Part A for approximately 5 minutes. Mechanically mix Part B for approximately 5 minutes. Mechanically mix both part A and Part B together for approximately 15 minutes. Mixing with a stir stick is not recommended. Once mixed, allow the material to stand for 45 minutes in temperatures between 50° F to 65° F, or 20 minutes in temperatures 65° F and above to ensure chemical reaction. If material is used too soon after mixing, or if the pool is filled too soon after application, yellowing or loss of gloss can occur. If more than one kit is used at a time box (intermix) several gallons together. (Use a 5 gallon pail)

**SPRAY INFORMATION:** Airless: 2000-2300 P.S.I. **TIP SIZE:** 0.15 – 0.19

**POT LIFE:** 3 hours @70°F and 50% relative humidity

**CLEAN UP:** Ramuc Thinner

#### PERFORMANCE CHARACTERISTICS:

##### Cyclic Prohesion

Method: ASTM D5894, 2300 hours  
Result: 10 ASTM D714 for blistering

##### Impact Resistance (direct)

Method: ASTM D2794  
Result: 160 in. lbs.

##### Alkali Resistance

Method: ASTM D1308  
Result: No effect

##### Pencil Hardness

Method: ASTM D3363  
Result: B (7 days), 4H (30 days)

##### Taber Abrasion

Method ASTM D4060, CS-17 wheels, 500gram load, 1000 cycles  
Result: 125 mg loss

##### Gloss

Method: ASTM D4587  
Result: 70% Maximum

##### Conical Flexibility

Method: ASTM D522

Result: >32%