Product Data Sheet (PDS):

GacoFloor 100EX
Revised:03/2025

GACOFLOOR 100EX
100% SOLIDS PENETRATING EPOXY PRIMER

A. PRODUCT DESCRIPTION:

GacoFloor 100EX is a 100 % solids, moisture tolerant, penetrating epoxy primer used to prime concrete and steel surfaces for high performance applications. Commonly utilized as part of a complete epoxy flooring system, GacoFloor 100EX is also suited for use with epoxy novolac and elastomeric polyurethane lining systems. Additionally, is used with our American Safety anti-slip coatings.

Low viscosity formulation penetrates and seals concrete pores. Provides superior adhesion to concrete and higher tensile and flexural strengths when compared to conventional polyamide primers. Cures at ambient temperatures down to 50 ºF (10 ºC). Resistant to amine blush, even when cured at low temperatures and high humidity. Requires zero induction time.

B. RECOMMENDED USE:

- Concrete primer, for epoxy and epoxy novolac systems
- Steel primer, as part of a complete elastomeric polyurethane lining system
- Primer for wood, tile and other porous substrates
- Enclosed and occupied spaces
- SCAQMD and OTC compliant

C. LIMITATIONS:

- Holcim does not recommend that grit be broadcast or otherwise introduced into GacoFloor 100EX Primer.
- Floors should be sloped to drain to prevent standing water or chemicals. As with any surface, all spills should be removed as soon as possible to prevent a slipping hazard.
- Do not thin with solvents.

D. PACKAGED PRODUCT DATA*:

PROPERTY	*OBSERVED VALUE / DESCRIPTION*
COLOR	Amber
MIX RATIO	2R:1H
PRIMER	6 – 8 mils – thin film epoxies 3 – 4 mils – anti-slip
COVERAGE	THIN FILM EPOXIES @ 6-8 MILS: 150 – 250 ft² / 1 gal *OR* 100 – 180 ft² / .75 gal (14 – 23 m² / 3.8 L *OR* 9 – 16 m² / 2.8 L) ANTI-SLIP @ 3-4 MILS: 350 – 400 ft² / gal *OR* 260 – 300 ft² / .75 gal (32 – 37 m² / 3.8 L *OR* 24 – 28 m² / 2.8 L) NOTE: May vary depending on concrete, or substrate porosity
V.O.C.	< 25 g / L Mixed components
% SOLIDS (VOL)	100 %
PACKAGING	0.75 gal (2.8 L)

	3 gal (11.4 L)
STORAGE	Dry area, 65 – 80 ºF (18 – 27 ºC)
SHELF LIFE	One (1) year

E. APPLIED PRODUCT DATA*:

PROPERTY	*OBSERVED VALUE / DESCRIPTION*
BOND STRENGTH (ASTM D - 4541)	Concrete failure; >350 psi (> 2.4 Mpa)
APPLICATION TEMPERATURE, AMBIENT	50 – 95 ºF (10 – 35 ºC)
APPLICATION TEMPERATURE, SUBSTRATE	Minimum 5 ºF (-15 °C) above dew point
POT LIFE, @ 77ºF	Sixty (60) minutes
SET TIME, @ 77ºF	Four (4) – six (6) hours
SURFACE TEMPERATURE	60 °F (16 °C) / 70 °F (21 °C) / 90 °F (32 °C) RECOAT (MIN) Six (6) hours / Four (4) hours / Three (3) hours RECOAT (MAX) Seventy-two (72) hours / Sixty (60) hours / Twenty-four (24) hours

F. PRODUCT INSTALLATION:

STEP	*INSTRUCTIONS*
SUBSTRATE PREPARATION	CONCRETE: Apply only to clean, dry and sound concrete substrates that are free of all coatings, sealers, curing compounds, oils, greases or any other contaminants. New concrete should be cured a minimum of twenty-eight (28) days. Concrete that has been contaminated with chemicals or other foreign matter must be neutralized or removed. Remove any laitance or weak surface layers. Concrete should have a minimum surface tensile strength of at least 300 PSI (2 Mpa) per ASTM D-4541. Surface profile shall be CSP-3 to CSP-5 meeting ICRI (International Concrete Repair Institute) standard guideline #03732 for coating concrete, producing a profile equal to 60-grit sandpaper or coarser. Prepare surface by mechanical means to achieve this desired profile. Moisture vapor transmission should be 3 lb (1.4 kg) or less per 1,000 ft² (92.9 m²) over a twenty-four (24) hour time period, as confirmed through a calcium chloride test, as per ASTM E-1907. Quantitative relative humidity (RH) testing, ASTM F-2170, should confirm concrete RH results <75 %. All surface irregularities, cracks, expansion joints and control joints should be properly addressed prior to application. Outgassing may occur due to the porosity of some concrete surfaces. To reduce the effect of outgassing, the primer and coating should be applied when the temperature of the concrete substrate is dropping. This usually occurs in the evening; however, the concrete substrate temperature should be measured with a surface thermometer for verification. Double priming will greatly reduce the effects of outgassing by additionally filling the pores in the concrete.

	METAL: GacoFloor 100EX can be applied to clean, dry metal surfaces. All rust, mill scale, paint, dirt, grease, oil, etc. must be completely removed. WOOD FLOORS: Remove any weathered wood to expose a clean solid substrate. Smooth wood must be sanded to ensure proper mechanical bonding. TILE AND FIBERGLASS: Glazed or ceramic tile and fiberglass must be sanded to completely remove all glazing to ensure a good mechanical bond. Remove any residual sanding dust by air blowing or wiping with alcohol.
APPLICATION	INSTALLATION STEPS 1. Component A Resin should be premixed prior to using due to possible additive separation. 2. Pour Component B Hardener into the Component A Resin pail and mix for a minimum of two minutes, using a mechanical jiffy-type mixer operated at low speed. Scrape the side of the pail to ensure the entire product has been properly mixed; any unmixed material left on the side of the pail will not cure. 3. Apply resin/hardener mixture by roller or squeegee. Move quickly and empty contents of pail onto surface as soon as possible to provide maximum working time. Material left in the pail will generate heat and have a reduced pot life. NOTE: Do not turn the pail upside down and allow to drain onto substrate. 4. Follow squeegee application with a back-roll using a short nap roller. 5. OPTIONAL STEP: Once primer has become tacky to the touch, a second primer coat may be applied. NOTE: Double priming will greatly reduce the effects of outgassing by additionally filling the pores in the concrete. NOTE: Broadcasting grit into GacoFloor 100EX Primer is not recommended. 6. Once primer has become tacky to the touch, proceed to installation of a GacoFloor flooring or lining system; refer to technical data sheet for installation instructions. NOTE: Primed surfaces should be recoated within forty-eight (48) hours. For longer waiting periods, wipe with xylene until surface becomes tacky. If surface remains hard, abrasive sanding is required. NOTE: Prior to installing an overcoat and/or lining system, closely inspect the surface of the GacoFloor 100EX to ensure that no contaminants have settled there. The longer the time between the primer application and the overcoat, the greater the chance of contamination. If any contamination occurs, it should be removed from the surface to be coated in accordance with SSPC-SP1.

** For specific Safety and Health information please refer to the appropriate Safety Data Sheet that is associated with this product.*