

# XS-327



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## Hybrid Water Based Polyurethane

### Technical Data

#### PACKAGING

XS 327 "A" - short filled quart can

XS 327 "B" - pint can

#### MIXING RATIO

3 parts "A" to 2 parts "B"  
*(water maybe added see ratios below)*

#### COVERAGE

Approximately 100 sq. ft. /QT/ coat  
Recommended dry film thickness =  
3—5 mils  
Recommended wet film thickness =  
2—4 mils  
Do not exceed 4 mil wet thickness  
per coat

#### DESCRIPTION

**SureCrete's XS-327** is a specially formulated, minimal color enhancement, matte finish, hybrid water based polyurethane coating. **XS-327** is a low VOC (25 g/l), and delivers commercial grade abrasion resistance for concrete and cementitious surfaces. **XS-327** is a two component concrete sealer, 64% solids by weight, and may be reduced with water.

Although specifically designed for PreCast Concrete pieces, **XS-327** can be used anywhere that requires high performance durability against: scratching, abrasion, chemical and household staining, UV damage, and damage from heat up to (to 300°F). **XS-327** surpasses the performance of most solvent systems, while providing the safety of a non-flammable, low VOC water based concrete sealer. **XS-327** meets the most stringent of VOC regulations at just 25 g/L. **XS-327** becomes food safe upon curing.

#### SURFACE PREPARATION

Surface must be dry and clean of dust, dirt, oils, and other surface contaminants. Depending upon surface density or porosity, clean surface with **SCR** in a dilution rate of between 2—4 parts water and 1 part **SCR** (2:1, 4:1).

**NOTE:** Xtreme Series products must hydrate for a minimum of 48 to 72 hours out of the mold. Pre-existing coatings should be scuff sanded and a test patch applied and adhesion checked to insure compatibility. Any sanding or dust created in prep work must be removed via compressed air or a fast-evaporating solvent, such as denatured alcohol, using a lint free rag. DO NOT use mineral spirits for this process. Be certain that substrate is completely dry before coating. A slab on grade that has moisture appear under a square of plastic that has been duct taped to the surface may need additional prep work.

#### APPLICATION

**XS-327** is a moisture cure sealer and must have humidity levels above 50%, temperature of room be above 60°F, and the surface temperature of the concrete between 60°F and 90°F and will stay within that range until product cures. **XS-327** is no good if the product freezes during delivery or in your shop. Multiple opening and closing of **XS-327** will allow air to get in, take care to close lid immediately after pouring material out, for optimal performance and longevity of remaining sealer left in the manufacturer's container.

#### PreCast Concrete - Concrete Countertops - GFRC

**Note:** Best results have been seen by applying a prime coat of **XS-327** to edge profiles first, then to the open surfaces. After a minimum of 4 hours or until the surface is no longer tacky a 2nd and 3rd coat of **XS-327** can be applied to create desired mil thickness for stain protection, abrasion resistance, and compression resistance.

**PRIME COAT** - Typical prime coats are 4:1 up to 7:1 dilution rates. (ex. 7 parts water to 1 part catalyzed product)

1. **Mechanically mix** thoroughly 3 parts **XS-327"A"** with 2 parts **XS-327"B"** for at least 3 minutes.
2. Let thoroughly mixed **XS-327** sit for 5-7 minutes.
3. Add desired water ratio to the catalyzed **XS-327** and mechanically mix again for 1-2 minutes. (Let it sit for 1-2 minutes or until all foam or bubbles are no longer present)
4. Using a "High Density Foam Roller" begin applying diluted **XS-327** to all edge profiles.

5. Now flood the surface with the diluted XS-327 rolling sealer around. Keep surface saturated, allowing the concrete to absorb as much sealer as possible. This process can take up to 15 minutes.

**Note:** In most cases bubbling and foaming will develop. This is from the roller expelling excess material and air into the material being applied. Ring out excess material from the roller or push excess material off the cast piece.

6. Once surface has reached maximum absorption, push off excess XS-327 and continue to back roll prime coat using light pressure on the roller, until desired finish is achieved. This process could take 3-5 minutes.

**Note:** DO NOT let foam or bubbles dry into finish. There should be NO visible roller marks at this stage, surface should be free of blemishes.

**Additional Coats** - Typical subsequent coats are 1:1 up to 4:1 dilution rates. (ex. 4 parts water to 1 part catalyzed product)

1. **Mechanically mix** thoroughly 3 parts **XS-327“A”** with 2 parts **XS-327“B”** for at least 3 minutes.
2. Let thoroughly mixed **XS-327** sit for 5-7 minutes.
3. Add desired water ratio to the catalyzed **XS-327** and mix again for 1-2 minutes. (Let it sit for 1-2 minutes or until all foam or bubbles are no longer present)
4. Using a “High Density Foam Roller” begin applying diluted **XS-327** to all edge profiles first and then apply to the remaining surfaces.
5. Finish rolling the surface so that is free of blemishes and roller marks.

**Note:** Drying time between coats varies widely due to numerous factors: temperature, humidity, surface texture, and percentage of water reduction. A six hour time frame or longer may be required before first coat dries sufficiently for second coat. If 2nd coat is applied after 48 hours following 1st coat, scuff surface for proper bonding. Full cure is achieved between 5 - 7 days at 75°F.

### **XS-327      Creating A Gloss Finish**

XS 327 is naturally a minimal color enhancement, matte finish sealant. It can be buffed or polished into a semi gloss/gloss finish. Care needs to be taken to ensure there is enough millage as to not buff through the finish. Minimum recommended finish coat is a 3/1 with water.

#### **Tools needed:**

- Variable speed grinder
  - Wool buffing pad used in the automotive industry. ( they make a 7 inch hook and loop version)
  - Medium buffing compound.
  - Fine buffing compound.
1. Allow XS 327 to dry a minimum of 24 hours.
  2. Using small amounts of medium buffing compound begin buffing the cured sealer. This process helps remove fine dust and other contaminants in the sealer. Once the entire surface has been buffed it can be left in this state for a semi gloss finish or can be taken to the fine buffing compound and brought up to a gloss finish.
  3. Follow the same steps taken using the “medium” buffing compound, for the “fine” buffing compound.
  4. Ready for install.

### **XS-327      Slab on Grade & Concrete Overlays**

A mohair shed resistant roller with phenolic core may be utilized. Mask off areas to be protected. Do not allow puddling. Thin coats are critical, never more than 4 mil thickness wet. Back roll excess sealer from low spots, especially pattern textures or grout lines. Apply when surface temperatures are between 60°F and 90°F and will stay within that range until product cures. Apply 2nd coat when dry to the touch, usually a 6 hour time frame (depending on temperature and humidity). If 2nd coat is applied after 48 hours following 1st coat, scuff surface for proper bonding. Full cure is achieved between 5 - 7 days at 75°F.

**Cleanup:** Before **SureCrete XS-327** dries; spills, over-spray, and tools can be cleaned up with soap and water.

## WARRANTY

Warranty of this product, when used according to the directions, is limited to refund of purchase price, or replacement of product (if defective), at manufacturer's/seller's option. SureCrete Design Products shall not be liable for cost of labor or direct and/or incidental consequential damages.

## CAUTIONS

**DO NOT LET XS-327 FREEZE. KEEP OUT OF REACH OF CHILDREN.** Keep areas ventilated to prevent the accumulation of vapors. **Inhalation:** Avoid prolonged breathing of vapors. Use NIOSH approved respirator for organic vapors if threshold limit values are unsafe. **Skin Contact:** Skin contact may cause irritation. Remove contaminated clothing and wash affected skin with soap and water. Launder clothing before reuse. If symptoms persist, seek medical attention. **Eyes:** Wear safety eye protection when applying. Contact with eyes may cause irritation. Flush eyes with water for 15 minutes. If symptoms persist, seek medical attention.

## TEST DATA

### Standard Testing & Data

Liquid Properties	General
Appearance (cured)	Matte
Water Resistance	Excellent, beads water
Mechanical Stability	Excellent
Light Stability	Excellent
Solids (by weight)	64%
Storage Stability	1 yr.
Appearance (wet)	Milky liquid
Odor	Sweet acrylic
Application Temperature	60°F – 90°F
VOC content	25 g/L

### Chemical Resistance (24 hr. spot)

MEK (methyl ethyl ketone)	blisters
Xylene -	softens
Ethanol -	softens
5% sodium hydroxide -	no effect
5% Ammonia -	no effect
Mineral Spirits -	no effect
5% sulfuric acid -	no effect
5% hydrochloric acid -	no effect
5% nitric acid -	no effect
1,1-trichlorethane -	no effect

Application Temperature	60°F – 90°F
VOC content	25 g/L
Set to Touch	6–10 hours.
Pot life	approx. 60 min's.

### Transportation Fluids & Fuels Resistance (24 hr. spot)

Brake Fluid	soften, discolor
Skydrol	dulls
Gasoline	no effect
Diesel Fuel	no effect
Kerosene	no effect