DURACOAT
(96S Series – Bulk)

User Guide



FORREST Technical Coatings

FIRMfoot® DuraCoat (96S Series) is a water-reducible epoxy ester coating designed to provide a durable, smooth protective finish for surfaces exposed to foot traffic.

DuraCoat delivers similar performance to Smooth Shield, but with:

- **Water-based clean-up**
- **Lower VOC (<200 g/L)**
- **More user-friendly application for indoor or sensitive environments**

Suitable for properly prepared substrates including steel, concrete, wood, fiberglass, and aluminum.

3 Basic Steps for Best Results

1 **Prepare the Surface**

2 **Mix & Apply the Coating**

3 **Allow Proper Dry & Cure Time**

Following these steps in sequence will help ensure proper adhesion, a smooth finish, and long-term durability.

1 Surface Preparation (CRITICAL STEP)

Proper surface preparation ensures adhesion and long-term durability.



General Requirements

- Surface must be clean, dry, and free of contaminants
- Remove all:
  - » Dirt, dust, grease, oil
  - » Rust or failing coatings

Recommended Prep by Substrate

- **Steel (Ferrous Metals):** Clean thoroughly; primer recommended for corrosion resistance
- **Aluminum / Non-Ferrous:** Acid etch for adhesion
- **Fiberglass:** Light sanding or acetone wipe
- **Concrete:** Clean with TSP and allow to fully dry
- **Wood:** Clean and dry (no primer required)

Best Practices

To achieve the best finish and performance, follow these additional guidelines.

- Ensure surface is completely dry before application (especially important for water-based systems)
- Avoid residue-leaving cleaners

If prep is done incorrectly:

- Coating may peel, blister, or fail prematurely

2 Mixing & Thinning

Once the surface is properly prepared and completely dry, the next step is to mix the coating thoroughly to ensure a consistent, smooth finish during application.

Mixing

- Stir thoroughly before use
- Continue mixing occasionally during application

Thinning (If Needed)

After thoroughly mixing the product, determine if thinning is necessary based on your application method and conditions.

- Product is **ready-to-use**
- May be thinned up to **10% maximum with water**

CAUTION: Do NOT over-thin

- Reduces film build and durability
- May affect finish quality



3 Application Instructions

Once the coating is properly mixed (and adjusted if needed), proceed with application.

Application Methods

Brush	Roll	Spray

Environmental Conditions

Before beginning application, confirm that environmental conditions are within the recommended range.

- Temperature: 40°F – 85°F
- Humidity: < 70%
- Surface temperature must be ≥5°F above dew point



How to Apply

After selecting your application method and confirming conditions, apply the coating as follows.

- Apply in 2 coats for best performance
  - » First coat: thin / tack coat
  - » Second coat: full coverage coat

Film Thickness Targets

Apply the coating within the following thickness ranges to ensure proper coverage and finish quality.

Wet Film Thickness: **6–8 mils**	Dry Film Thickness: **2–3 mils**

Recoat Window

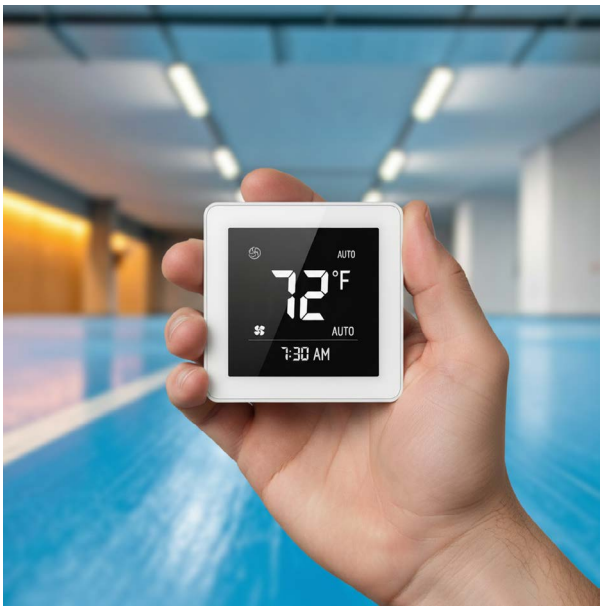
To ensure proper adhesion between coats, follow the recommended recoat timing.

- Recoat within 1–2 hours

4 Dry & Cure Time

After application is complete, allow the coating to properly dry and cure before placing into service. Environmental conditions will directly affect drying performance.

- Dry to handle: 45 minutes – 1 hour
- Full cure depends on:
  - » Temperature
  - » Humidity
  - » Airflow



Use the following information for planning, cleanup, and proper storage

Coverage

- Approx. **481–625 sq ft per gallon @ 1 mil**

Clean-Up

- Clean tools and equipment with water

Storage

- Store in a cool, dry, well-ventilated area
- Keep containers tightly sealed
- **DO NOT FREEZE**
- Shelf life: ~12 months (unopened)

Safety Information

Although this is a lower-VOC product, proper safety practices should always be followed.

- Use in well-ventilated areas
- Wear appropriate PPE
- Review SDS before use

Troubleshooting

If issues occur during or after application, refer to the guide below to identify common causes and corrective actions.

Poor Adhesion / Peeling

- Cause: Improper surface prep or moisture on surface
- Fix: Clean thoroughly, ensure surface is dry, reapply

Slow Dry Time

- Cause: High humidity or thick application
- Fix: Apply thinner coats and improve airflow

Uneven Finish

- Cause: Inconsistent application or film thickness
- Fix: Apply even coats and maintain recommended thickness

Soft Film / Poor Durability

- Cause: Over-thinning or insufficient cure time
- Fix: Allow full cure and avoid over-thinning

Pro Tips

For best results, especially in indoor or finish-sensitive applications, consider the following tips.

- This is the **most user-friendly system**—great for indoor and low-VOC environments
- Ideal where:
  - » Solvent smell is a concern
  - » Clean-up simplicity matters
- Always ensure surface is **fully dry before applying** (this matters more than with solvent systems)
- Maintain consistent film build for best durability

