



STEP BY STEP APPLICATION GUIDE

315 WATERBASED EPOXY FLAKE FLOOR SYSTEM

Description

The 315 epoxy system is an easy to use floor coating system designed to protect and decorate all concrete surfaces. Some of the features are typical of an epoxy coating including excellent adhesion, high build and exceptional durability. Typical application areas would include factory floors (especially food processing plants), garage floors, bathroom / kitchen floors and any aggressive environments such as abattoirs, laboratories and amendment blocks.

Flake Flooring Application Guide:

STEP ONE:

Preparation

Preparation is the key to getting good adhesion to the surface being coated. If the preparation is not carried out correctly the system will separate from the substrate.

Previously painted areas should be sanded, cleaned and tested for compatibility and adhesion with the tape test before application. If you are unsure of any part of the application consult your distributor and always read the product data sheets before application.

New concrete surfaces must be allowed to cure for 28 days. Holes and cracks should be filled using appropriate filler.

Hydrochloric acid etching is recommended on un painted concrete. Use one part acid and six parts water, always add the acid to the water and not the other way around. It is most important to wash all traces of the acid from the surface. If the surface still feels smooth the process must be carried out again until the surface has a rough sandpaper feel. If it is not possible to acid etch the best alternative method is grinding. Drop a small amount of water on the surface to ensure the water soaks into the concrete within 2 minutes. If it does not soak into the surface more acid washing or grinding is needed.

Cracks:



Deep cracks that are not filled before application may appear through the flake system. These areas may be patched over to hide the distinctive black line.

NOTE:

It is important to prepare all the necessary equipment before you start. Tape up any areas before applying the epoxy and remove the tape before the epoxy dries. Epoxy has a short pot life and you won't have much time to waste. Place all boxes of flake in a clean bucket and lid and gently roll to ensure all flake is mixed evenly.

Preparation check List:

- *Clean surface*
- *Tape up all areas*
- *Have a brush ready for cutting in and a roller set up ready to start*
- ***Box all flake together and ensure the colour is correct and well blended. This should be done as gently as possible to ensure minimal breakage.***

STEP TWO:

Base coat and flake / particle application

- Mix three parts of 315A epoxy with one part of 315B hardener by volume not by weight. It is important to scrape out as much of part B as possible to ensure a correct mix ratio. An incorrect mix ratio will decrease pot life dramatically or it will not cure at all. Mix well preferably using an air stirrer or high speed drill (remembering not to whip any unnecessary air into the mix). **Mix for no more than one minute.** To increase pot life pour the mix onto the floor – do not keep in the mixing container, by keeping the mix in the pot it will gel up much faster.
- Spread the base coat out using a squeegee or roll on with a 12 mm nap synthetic roller. Coverage will be approximately 3m² per litre depending on method of application and surface porosity. If the 315 Aquapoxy is spread out to thin it may dry patchy and the flake may not stick consistently.
- Remove all masking tape while the epoxy is still wet or the tape will dry into the coating. Use spiked shoes to walk on the epoxy if required.

- **Check and box all the flake to ensure an even colour.**



- Apply the 315 Aquapoxy to an appropriate area where you can easily broadcast the flake, remove gloves and broadcast the flake over the wet epoxy. Leave half a metre edge of epoxy to roll next pack on to. Do not leave a 'fat edge' as this will show through in the final coat. Broadcast flake Throw the flake high into the air so that it can float to the floor. The flake or particle must cover all areas of Epoxy in excess so you cannot see **any** of the basecoat. (see photo above).
- **DO NOT WALK ON FLAKE AFTER BROADCAST.**
- Allow to dry over night.

STEP THREE:

Final top coats

- Collect excess flake or particle. This could be carried out by using a combination of a leaf blower-vac and broom.
- With a pole sander or equivalent sand the area to remove and sharp edges or rough patches. If the surface is not smooth the final gloss level may not have a consistent sheen level.
- Vacuum over the surface again to remove any dust particles.
- Mask around the floor edges
- Mix Clear topcoat at a 3 to 1 mix and apply with a 12ml nap roller. Do not whip up or air rate when applying. Do not thin. Apply at 5 m² per litre.
- Allow overnight before applying final coat.

IMPORTANT:

After final application allow 24 hours before light foot traffic (no shoes). For cars allow 7 days minimum. This will vary depending on factors such as the time of year and how much air circulation the area has. Treat the system carefully up to six months by not dragging heavy items across the surface - the more you look after the surface the longer the system will last.

To summarize application:

- Patch floor area and remove any contamination and dust.
- Apply 315 Epoxy Base Coat and broadcast the Flake
- Allow to dry overnight
- Collect Flake
- Apply two coats of 350 Duralok allowing overnight drying between coats.

Maintenance

On a weekly basis sweep the floor with a soft broom or mop. The more dirt and grit that is apparent will damage the surface every time foot traffic occurs (dirt or grit act like sandpaper wearing away the floors surface). Prompt removal of any oils, dirt, grit and greases will slow damage and degradation of the coating.

Use soft cleaning equipment, let the detergent / cleaner break down the dirt, any harsh cleaning pads or equipment may scratch the surface.

Patching

To patch areas, sand the area to be coated until the surface looks flat and feels rough. If the area is not sanded well the patched area will have adhesion problems. Apply a light coat of the 350 Duralok and while still wet lightly sprinkle the flake until the area looks even. Allow to dry, lightly sand and top coat.

	1-10m ²	11-20m ²	21-30m ²	31-40m ²
Kits of each needed: (3.5 litre kit of 315 base + 5kg flake + 4 litre kit of 350 top)	1 of each	2 of each	3 of each	4 of each