

315 WATERBASED EPOXY FLAKE FLOOR SYSTEM STEP BY STEP APPLICATION GUIDE

Description

The 315 epoxy system is an easy to use low yellowing, floor coating 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, tank linings and any aggressive environments such as marine, abattoirs, laboratories and amendment blocks.

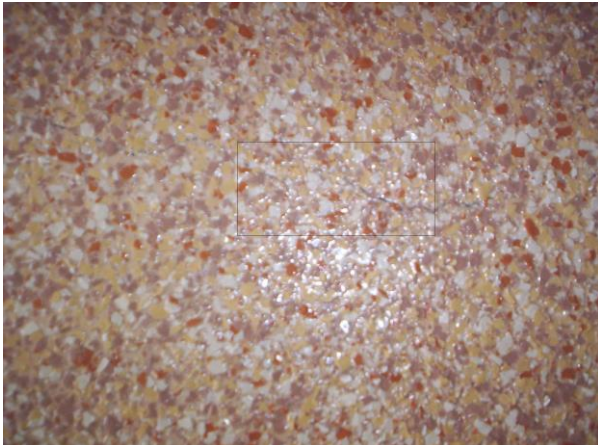
Flake Flooring Application Guide:

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

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

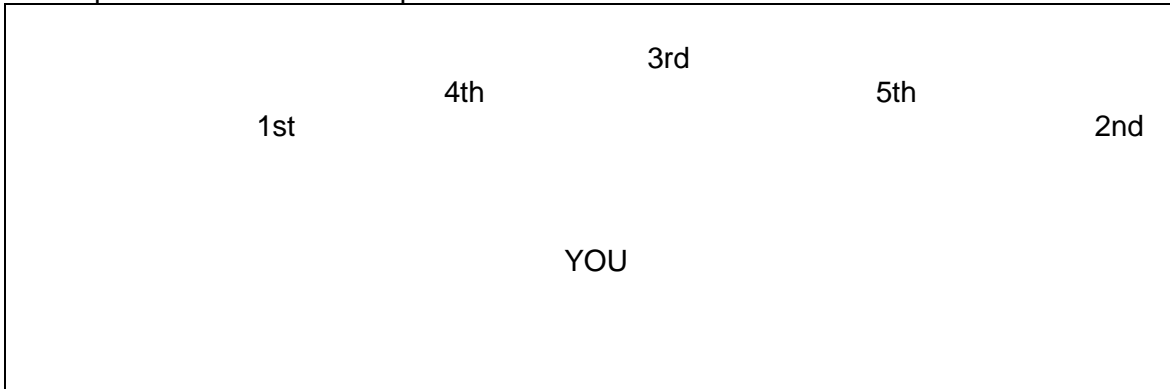
- Mix three parts of 315A epoxy with one part of 315B hardener by volume not by weight. It is important to scrape out as much of part B as possible to ensure a correct mix ratio. An incorrect mix ratio will decrease pot life dramatically or it will not cure at all. Mix well preferably using an air stirrer 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 8 to 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 too 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.
- **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 randomly – see photo (1a) below for an example of an uneven broadcast. 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.

Example of broadcast technique:



Example of Uneven Broadcast:



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 followed by a vacuum cleaner to remove any fine dust.
- 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 14ml nap roller. Do not whip up or air rate when applying. Remember the more you thin the less build will result.
- Allow overnight before applying final coat.

IMPORTANT:

After final application allow 24 hours before light foot traffic (no shoes) and 48 hours for heavier traffic. For heavy traffic like cars allow 7 days minimum. This will vary depending on varying factors such as the time of year. 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 3 hours dry time between coats.

Maintenance

On a daily basis sweep the floor with a soft broom. 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.

Once a week give the floor a good mop.

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	10-20m ²	20-30m ²	30-40m ²
Kits of each needed: (315 base + flake + 350 top)	1 of each	2 of each	3 of each	4 of each

Disclaimer

Industry standards recommend accurate recording of times, dates, batch numbers, consumption rates, environmental conditions including substrate and ambient temperatures, humidity levels and dew point readings during both the application and curing processes. Full material warranties cannot be provided unless all the relevant data has been recorded accurately.

Any applicator using this product shall be knowledgeable in the proper installation and application of two component products.