KANSAI PLASCON

SPECIFICATION SHEET NO: **NW382**

NEW WORK/REPAINT: NEW WORK - INTERIOR –
Urban and Industrial Atmospheres
Good Chemical Resistance. Production areas with high humidity – flooring – high traffic areas

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SUBSTRATE: Concrete

PAINT FINISH: Plascon Plascotuff 4000 HB Floor Coating PRODUCT CODE: **FHB 4000**
(High gloss, high build solvent-free epoxy floor coating offering good chemical resistance & durability)

500µm Coating System

COLOUR: Standard colours as per colour card.

ENVIRONMENT: **The Maintenance Cycle is a guide but can vary due to micro-climate changes identified on the site which will affect the longevity of the coating system**

As per ISO 12944: Maintenance Cycle (Years)

C3 4

Plascon Coating System	Application Method	Spreading Rate m²/ℓ	WFT/DFT µm (min & max)	Reducer/ Cleaner	Overcoating time h @ 23 °C	Technical Data Sheet No	TVOC g/ℓ
1st Coat: Plascon Plascoguard Gehopon 7 Sealer (GW 7) **Mixing Ratio: 5:1 by mass**	B, R or S	@ 18 µm Theo – 11.7 Prac – 5.7	DFT: 15–20 WFT: 71-95	GP Epoxy Reducer (EPT 1)	12	GW 7	
Scraper Coat Plascon Plascotuff 4000 HB Floor Coating (FHB 4000) **Mixing Ratio: 3:1 by volume**	Trowel,	Apply @ 4 m²/ℓ and Draw off to zero (Spread rate depends on profile)	DFT: 100 WFT: 100	GP Epoxy Reducer (EPT 1)	8-18	FHB 4000	
2nd Coat: Plascon Plascotuff 4000 HB Floor Coating (FHB 4000) **Mixing Ratio: 3:1 by volume**	Trowel , Notched Rake and Spiked Roller Or Mohair roller	@ 400 µm Prac – 2.5	DFT: 400 WFT: 400	GP Epoxy Reducer (EPT 1)	8-18	FHB 4000	

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SURFACE PREPARATION:

- Surfaces must be clean, sound and dry before coating.
- Concrete must cure for a minimum of 28 days.
  - **Floor strength**: Check strength of floor using a Schmidt hammer or equivalent. Floor strengths vary between 25-40 MPa. Hollow sections and laitance need to be identified and rectified.
  - **Oil contamination**: Remove by applying Plascon Aquasolv Degreaser (GR 1) with a bristle brush or broom to affected areas. Allow to react for 20 minutes. Scrub off thoroughly with tap water and brush/broom to remove all traces of oil and 'Plascon Aquasolv Degreaser (GR 1). Test surface to be water-break free. If not, repeat the cleaning process.
  - **Heavy oil contamination**: Use Aqua Fortris Clean and Capture System to remove oils.
    NB: Drill a core in heavily contaminated floor areas to measure depth of oil penetration. Take appropriate action to remove the problem.
- Vacuum shot blast surface to remove laitance. Ensure surface is clean, dry and sound. Moisture levels must not exceed 5 % when using a Doser Hygrometer B 4 scale (or equivalent) before painting.

  OR
- High speed diamond grind surface to remove laitance. Vacuum entire area. Ensure surface is clean, dry and sound.
- Moisture levels must not exceed 5 % when using a Doser Hygrometer B 4 scale (or equivalent) before painting.
- <u>Masterplate Floors</u>
  - Remove surface contaminants using Plascon Metalcare Aquasolv Degreaser (GR 1) in conjunction with bristle scrubbing brushes or brooms, alternatively Scotch Brite pads. Rinse thoroughly with tap water using brooms, brushes or hydroblast to remove all traces of Plascon Metalcare Aquasolv Degreaser (GR 1) and achieve a water break-free surface. Allow to dry.
  - High speed diamond grind floor to create a key and ensure it is rust free. Vacuum to remove all dust. Moisture level must not exceed 5 % when measured with a Doser Hygrometer B 4 scale (or equivalent) before painting.
  - NOTE: WHEN PRIMING MASTERPLATE FLOORS USE PLASCON EPIWASH STRONTIUM CHROMATE PRIMER (AW 255) IN PLACE OF PLASCON PLASCOGUARD GEHOPON IMPREGNATION SEALER (GW 7).
- <u>Expansion Joints</u>
  - Expansion joints need to be cut and filled or raked out and filled with Sika Pro (3WF) flexible polyurethane sealant.

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APPLICATION: SEALER AND FINAL COATS

Sealer coat:
Mix base and hardener thoroughly together in a 5:1 ratio before use.

- Apply one coat of Plascon Gehopon Impregnation Sealer (GW 7) by Mohair roller at a rate of not more than 7 m²/ℓ to achieve a continuous filter. Allow twelve (12) hours to dry. Any gloss patches should be sanded to a matt finish.

Finishing coats:
Mix base and hardener thoroughly together in a 3:1 ratio before use.

- Apply two coats of Plascon Plascotuff FHB 4000 Series, first coat by trowel at a spread rate of 4 m²/ℓ, drawn down to zero, allowing overnight drying between coats.
- Apply the second coat at a spread rate of 2.5 m²/ℓ (400 µm) as specified with a notched rake to achieve a total dry film thickness of approximately 500 µm or by mohair roller. Finish off by using a spiked roller whilst still wet to ensure a uniform finish is obtained and that the coating is de-aerated.
- The full cure will require 7 days before heavy traffic permitted.

Note: Do not leave for longer than 24 hrs between coats.
Epoxy Coatings require 7 days to reach full chemical cure prior to being subjected to any chemical spillage.
Please ensure that the complete order quantity is ordered in one batch to ensure batch colour consistency is maintained.
All coating activities must be carried out in accordance with our product data sheets.
If there is no damp course, rising damp and or moisture ingression can cause a system failure.

TABLE REFERENCES:

- Technical Data Sheet (TDS): User must always ensure that latest issue is used.
- B = Brush (ready for use), R = Roller (synthetic, min. 10mm pile) (ready for use), S = Airless spray (ready for use).
- Theoretical spreading rate quoted is for smooth non-porous substrates and does not include allowance for surface profile, porosity, wastage and uneven film application. Suitable allowance should be made according to type of work, method and skill of applicator. Practical spreading rate quoted is an average guide only - actual must be determined by user.
- Overcoating times are at 23 °C and 75 % relative humidity. Longer times must be allowed under cooler and moist conditions. DO NOT paint during inclement weather and when temperature is below 10 °C.
- Fading and chalking will occur to a greater or lesser degree depending on pigmentation and generic binder type.
- NB: Life expectancy may vary, depending on environmental conditions and stresses, within the macro/micro climate of the project.