

500µm HIGH BUILD EPOXY FLOORING SYSTEM STONKOTE HB4

Ref # Date

REQUIREMENTS:

Proposed flooring system for concrete floors, where a 500µm semi self-levelling high build epoxy flooring system is required and where the system will be exposed to foot traffic, trolley-jack traffic, vehicle traffic, cleaning chemicals and oils at ambient temperatures at (project name and location).

SCOPE OF WORK (BOQ):

Apply **Stonkote HB4** as a 500µm self-smoothing, high build epoxy flooring system. Inclusive of surface preparation, apply all products in accordance with the manufacturer's product data sheets.

THE STONKOTE HB4 SYSTEM CONSISTS OF:

	Product	Kit Size	Theoretical Coverage
Primer	Stonprime 739	20 Litre Kit	3.3m ² /litre
Topcoat	Stonkote HB4	20 Litre kit	2.0m ² /litre
Non-slip Sealer	Stonseal 722 (Optional)	5 Litre	10m ² /litre

*Please refer to primer option for porous substrates

TEMPERATURE:

Apply **Stonkote HB4** only in temperatures ranging between 16°C and 30°C.

SUBSTRATE PREPARATION:

Remove all oils, grease and other contaminants by scrubbing with **Carboclean 252** and rinsing with clean running potable water to obtain a water break-free surface. Allow to dry. Remove thin coatings, reduce or smooth the profiles, it will not give a surface pattern suitable for coatings unless followed by etching/grinding or vacublasting. The roughened surface should have a texture similar to 80-grit sandpaper, minimum tensile strength of 2 MPa and moisture content of 5% maximum. Refer to the product data sheet for additional surface preparation requirements.

PRIMING ON POROUS SUBSTRATES:

- Prime the prepared substrate with **Stonprime 639** at a theoretical coverage of 6.0m²/litre. Allow to cure for a minimum of 6 hours at 25°C (maximum 24 hours at 25°C) and apply a second coat at the same spread rate to yield the same dry film thickness and achieve a uniform gloss finish.
- For self-levelling flooring systems on a rough surface, prime the substrate with **Stonprime 739** at a theoretical coverage of 3.3m²/litre to ensure a dry film thickness of 300 microns. Allow to cure for a minimum of 6 hours at 25°C (maximum 24 hours at 25°C).

APPLICATION PROCEDURE FOR STONKOTE HB4:

- Drive steel nails into existing joints to demarcate all concrete joints.

The Applicator contracts with the Client to apply the coating system strictly in accordance with the specification, and is therefore required to monitor the quality of his own workmanship. Any deviations from the specification are for agreement between the Applicator and the Client. StonCor Africa acts in an advisory capacity only, to provide technical assistance to other parties, and does not inspect nor approve the quality of application and workmanship.

REFER TO THE LATEST PRODUCT DATA SHEETS BEFORE PRICING OR COMMENCING APPLICATION, FOR ADDITIONAL INFORMATION AND CAUTIONS CONCERNING PRODUCT USAGE.

- Apply a scraper coat of **Stonkote HB4** at a theoretical coverage of 5m²/litre to the primed area using the edge of a steel finishing trowel, and allow to cure for a minimum of 8 hours at 25°C (maximum 24 hours at 25°C).
- Inspect the scraper coated area for any signs of fish eyeing, blowholes, omegas, etc. and repair with **Dural 30/35NS**. Allow to cure and abrade to smooth surface.
- Using a 1.0mm notched rake, evenly apply **Stonkote HB4** at a theoretical coverage of 2.0m²/litre. Wearing spiked shoes, spike the material with spiked rollers for a period not exceeding 20 minutes to increase the flow, level the material and de-aerate the product. Allow to cure for 16 hours at 25°C.
- Remove the nails and snap a chalk line down the length of the joints in the **Stonkote HB4** for non-moving joints. Using a purpose-made joint cutting machine, saw cut through the **Stonkote HB4** to a minimum depth of 25mm x 6mm wide. All joint edges or cracks should be squared and dust-free prior to application. (All movement joints should be treated as per the engineer's joint design detail).
- Mask either side of the saw cut and prime with **Stonprime 639**, allow to cure for 6 hours at 25°C (maximum 24 hours at 25°C).
- Fill the depth of the joint with **Tammsflex 748** non-moving joint sealant. Allow to cure for a minimum of 24 hours at 25°C before placing into service.

REFERENCE SAMPLE:

A trial reference sample should be installed by the applicator prior to start of the contract to verify correct coverages, workmanship, appearance, colour and texture.

SEALING (OPTIONAL) – NON-SLIP FINISH:

Apply 2 coats of **Stonseal 722** at 10m²/litre, allowing 8 to 12 hours drying time between coats.

ARCHITECT DETAIL:

- Coving
- Joints

Technical Approval: _____

Date: _____

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