

## 100% VOLUME SOLIDS CHEMICAL RESISTANT FILM COATING STONKOTE HT4 WITH SL PRIMER

Ref #      Date

### REQUIREMENTS:

Proposed 100% volume solids, chemically resistant epoxy coating for concrete surfaces where a 1 to 3mm abrasion resistant, easily cleanable coating system is required. The coating will be applied in wet conditions not exceeding 93°C continuous and 121°C intermittent and will be exposed to occasional splash and spillage of very low concentrations of hydrochloric, sulphuric and caustic solutions.

### SCOPE OF WORK (BOQ):

Inclusive of surface preparation, apply **SL Primer** with **Stonkote HT4** in strict accordance with the manufacturer's product data sheets.

### THE SL PRIMER / STONKOTE HT4 SYSTEM CONSISTS OF:

	Product	Kit Size	Theoretical Coverage
Primer	<b>SL Primer</b>	20 Litre kit	3 to 3.5m <sup>2</sup> /litre
Topcoat	<b>Stonkote HT4</b>	2 Litre kit	4m <sup>2</sup> /litre
Topcoat	<b>Stonkote HT4</b>	2 Litre kit	4m <sup>2</sup> /litre

### NOTE:

Please refer to the attached chemical resistance guide, including percentages.

### TEMPERATURE:

Do not attempt to install **SL Primer** if temperature of components and substrate are not within 16°C to 30°C. Apply **Stonkote HT4** only in temperatures ranging between 18°C to 30°C. Do not apply in direct sunlight.

### SUBSTRATE PREPARATION:

Proper preparation is critical to ensure an adequate bond. The substrate must be dry and free of all wax, grease, oils, fats, soil, loose or foreign materials and laitance. Contaminants may be removed by scrubbing with a heavy-duty industrial detergent (**Carboclean 250** or **Carboclean 252**) and rinsing with clean water. Laitance and unbonded cement particles must be removed and surfaces should be roughened by mechanical methods, i.e. abrasive blasting or grinding. The surface must show open pores throughout and have a 80-grit sandpaper texture. For recommendations or additional information regarding substrate preparation, contact StonCor Africa Technical Service Department.

### APPLICATION:

#### **SL Primer:**

- **SL Primer** must be used in conjunction with **Stonprime 786OPR** if moisture barriers are required.
- 2 Coats of **SL Primer** is squeegee applied only, utilising the wet-on-wet method.
- Pour a bead of primer out onto the substrate and squeegee out, being careful not to leave squeegee lines. **DO NOT BACKROLL.**

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.

- Once you have applied approximately 10 minutes' worth of **SL Primer**, walk back out onto the primer wearing spiked shoes and apply the second coat of the wet-on-wet coats.
- Again, use a squeegee only. In large areas you will need to have enough men to apply the first coat of **SL Primer** and the second coat at the same time.
- One 20 litre kit of **SL Primer** will cover between 60 to 70m<sup>2</sup> on relatively smooth substrates following this 2-coat wet-on-wet application method.
- Once cured, ensure that there are no pinholes present in the primer.
- Sand smooth all squeegee lines, ridges and any imperfections on the surface that might reflect through the topcoat.

#### **Stonkote HT4:**

- **Stonkote HT4** is applied with a rubber squeegee and backrolled with a medium nap roller.
- The roller is used to remove squeegee lines and smooth out the surface, leaving a slightly textured, mild, non-slip finish. A brush may be used where necessary.
- **Stonkote HT4** may be applied at a variable thickness ranging from 100 to 300 microns dry film thickness.
- Each additional coat may be applied when the surface is tack-free, approximately 4 to 5 hours.

#### **REFERENCE SAMPLE:**

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

**Technical Approval:** \_\_\_\_\_

**Date:** \_\_\_\_\_

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.

StonCor Africa (Pty) Ltd  
Co. Reg. No.: 1996/01848/07  
Tel No: +27 11 254 5500  
Website: [www.stoncor.co.za](http://www.stoncor.co.za)  
E-mail: [stoncorsa@stoncor.com](mailto:stoncorsa@stoncor.com)