

100% VOLUME SOLIDS CHEMICAL RESISTANT FILM COATING STONKOTE HT4 WITH STONPRIME 639

Ref # Date

REQUIREMENTS:

Proposed 100% volume solids, chemically resistant epoxy coating system for concrete floors exposed to temperatures not exceeding 93°C continuous and 121°C intermittent, exposed to occasional splash and spillage of very low concentration of hydrochloric, sulphuric and caustic solutions.

SCOPE OF WORK (BOQ):

Inclusive of surface preparation, apply **Stonprime 639** and **Stonkote HT4** in strict accordance with the manufacturer's product data sheets.

THE STONPRIME 639 / STONKOTE HT4 SYSTEM CONSISTS OF:

Product	Kit Size	Theoretical Coverage
Stonprime 639	5 Litre kit	6.4m ² /litre
Stonprime 639	5 Litre kit	6.4m ² /litre
Stonkote HT4	2 Litre kit	4m ² /litre
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NOTE:

Please refer to the product data sheet for chemical resistance, including percentages.

TEMPERATURE:

- **Stonprime 639:** Do not attempt to install material if temperature of components and substrate are not within 16°C to 30°C.
- **Stonkote HT4:** Apply 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 such as **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's Technical Service Department.

APPLICATION – STONPRIME 639:

- Onto clean, dry, dust-free, sound surfaces, apply **Stonprime 639** utilising a medium nap roller and paint tray at 6.4m²/litre, porosity dependent.
- Allow to cure for 6 hours and apply an additional coat at the same spread rate if the substrate is porous and a uniform gloss finish has not been achieved.

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.

- NOTE: **Stonprime 639** is a high penetrating primer that will not smoothen out the surface substrate of any rough patches.

APPLICATION – 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 330 microns dry film thickness.
- Each additional coat may be applied when the surface is tack-free, approximately 4 to 5 hours.
- Ensure no pinholes are present in the first **Stonkote HT4** coating before application of subsequent coats. Should pinholes be observed, seal with **Dural 30/35NS**.

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.

Technical Approval: _____

Date: _____

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