STONHARD

STONKOTE HB4

PRODUCT DESCRIPTION

Stonkote HB4 is a two-component, high-solids, high-build, protective epoxy floor coating. Stonkote HB4, due to its high-build composition, has increased abrasion resistance when compared to a general service thin film coating. It also has enhanced aesthetic appeal and cleanability. Stonkote HB4 cures to a high gloss, smooth finish

USES, APPLICATIONS

Stonkote HB4 is designed for use whenever a high-build, high-solids, chemical-resistant, high-gloss, smooth epoxy coating is required on horizontal surfaces. Some applications of Stonkote HB4 are:

- In conjunction with various Stonhard flooring systems
- Substrates requiring high-build, protective coating that is easily cleaned and maintained
- Protection of concrete surfaces exposed to abrasive or corrosive environments

PHYSICAL CHARACTERISTICS

Pot Life (@ 77˚F/25˚C)	35 minutes
Suggested Number of Coats	One
Coverage @ 30 mil (DFT)	250 sq. ft./23 sq. m per unit
Cure Rate (@77˚F/25˚C)	8 hours for tack-free surface 24 hours minimum for normal operations
Fire Resistance of Dry Film	Self-extinguishing

Note: The above physical properties were measured in accordance with the referenced standards. Samples of the actual coating were used as test specimens.

PRODUCT ADVANTAGES

- High Solids
- High-build, epoxy coating
- Dense, impervious finish with good stain resistance
- Long-term abrasion and corrosion resistance
- Easily applied to horizontal surfaces
- Excellent bond strength assures good adhesion
- Bonds to many different substrates.
- Durable, high-gloss finish permits easy cleaning and maintenance.
- Factory proportioned packaging ensures consistent, high quality, simplified mixing.

PACKAGING

Stonkote HB4 is packaged in units for easy handling. Each unit consists of one carton containing:
0.5 carton containing:
2 bags of Amine
(1) 5-gallon pail of Resin

COVERAGE

Approximately 250 sq. ft./23 sq. m per 4-gallon unit at 20 to 30 mil thickness (DFT).

STORAGE CONDITIONS

Store all components of Stonkote HB4 between 60 to 85˚F/16 to 29˚C in a dry area. Avoid excessive heat and do not freeze. The shelf life is one year in the original, unopened container.

COLOR

Stonkote HB4 is available in 14 standard colors. Refer to the Stonclad color sheet. Custom colors are available upon request.

SUBSTRATE PREPARATION

Preparing Stonhard Flooring Systems

Before coating a Stonhard floor, all trowel marks and surface imperfections must be removed to produce a smooth surface.
Grind the floor using a floor grinder with medium stones and vacuum using an industrial wet/dry vacuum to remove all dust particles. The Stonhard floor is now ready to be coated with Stonkote HB4.

Preparing Concrete Substrates

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. Laitance and unbonded cement particles must be removed by mechanical methods, i.e., abrasive blasting or scarifying. Other contaminants may be removed by scrubbing with a heavy-duty industrial detergent (Stonkleen TD9) and rinsing with clean water. The surface must show open pores throughout and have a sandpaper texture. For recommendations or additional information regarding substrate preparation, contact Stonhard's Technical Service Department.

PRIMING

Primer 150 or Standard and SL Primer are required prior to application of Stonkote HB4. Please reference the appropriate Product Data sheet for installation of the primers. Once cured, the primer must be inspected for pin holes and addressed appropriately.

MIXING

Stonkote HB4 is supplied in factory proportioned quantities. To achieve thorough and proper mixing, the Stonkote HB4 must be mechanically mixed using a heavy-duty, slow-speed drill (400 to 600 rpm) with a Jiffy Mixer. Pre-mix the Resin for 45 seconds. Empty the contents of the Amine into the Resin pail and continue to mix to a uniform consistency for 1 to 2 minutes. Avoid high-speed mixing that will entrain air into the mix. Thorough mixing of the two components is required.

POT LIFE
After mixing, Stonkote HB4 has a working time of approximately 35 minutes at 77˚F/25˚C. The working time may vary depending upon ambient and surface conditions.

APPLYING
Stonkote HB4 can be applied at ambient temperatures of 60 to 85˚F/16 to 29˚C and humidity below 80%. The HB4 must be applied immediately after mixing the two components. Debris will be noticeable in this Stonkote HB4, therefore the floor must be as clean as possible prior to application, by wiping and vacuuming. Stonkote HB4 is applied with a flat push squeegee, a 30-mil notched rubber squeegee, a nap roller and a metal tined roller. Once a bead of material is poured, use the push squeegee to apply a tight coat to the floor. When the bead becomes small, remove it from the floor. This step helps clean any excess debris that was not captured during the cleaning step. Close behind this application, another bead is poured, and the material should be squeegeed using the 30 mil notched squeegee. A nap roller is used to remove squeegee lines, and this should be immediately followed by a metal tined roller to help with air release and leveling. If two applications of Stonkote HB4 are necessary, the second application should begin within 24 hours of the original coating. If the original coating has been allowed to cure for more than 24 hours, the coated surface must be re-prepared. To prepare the surface of the Stonkote HB4 for a second coat, utilize a rotary sander with 80 grit sandpaper to roughen the surface, then ensure that all dust is thoroughly removed from the surface. Any questions regarding the application of Stonkote HB4 should be directed to Stonhard's Technical Service Department.

CURING
The surface of Stonkote HB4 will be tack-free in 8 hours at 77˚F/25˚C. The coated area may be put back into service in 24 hours. Ultimate physical characteristics will be achieved in 7 days.

Note: If Stonkote HB4 is to be coated with another product such as a urethane sealer, proper preparation is required for proper adhesion and application of the coating or sealer. Contact Technical Service for proper recommendations on preparation and installation techniques.

RECOMMENDATIONS
- Apply only on a clean, sound and properly prepared substrate.
- Minimum ambient and surface temperatures are 60˚F/16˚C at the time of application.
- Do not use water or steam in the vicinity of the application. Moisture can seriously affect the working time and properties of the material.
- Application and curing times are dependent upon ambient and surface conditions.

PRECAUTIONS
- Toluene and Xylene solvents are recommended for clean-up of the unreacted Stonkote HB4 material. Use these materials only in strict accordance with the manufacturer's recommended safety procedures. Dispose of waste materials in accordance with government regulations. The reacted material will require mechanical means of removal.
- Avoid contact with the liquids as they may cause skin and/or eye irritation. In the case of eye contact, immediately flush the area with copious amounts of clean water for at least 15 minutes and seek medical attention. Workmen should cover hands with impervious gloves & wear safety glasses. Wash hands thoroughly with soap and water after use and before eating, smoking, etc. A N95 NIOSH approved dust mask must be worn during substrate preparation. Use only with adequate ventilation.

NOTES
- For environments not referenced in the Chemical Resistance Guide, consult Stonhard's Technical Service Department for recommendations.
- Safety Data Sheets for Stonkote HB4 are available online at www.stonhard.com under Products or upon request.
- A staff of technical service engineers is available to assist with product application or to answer questions related to Stonhard products.
- Requests for technical literature or service can be made through local sales representatives or corporate offices located worldwide.
- The appearance of all floor, wall and lining systems will change over time due to normal wear, abrasion, traffic and cleaning. Generally, high-gloss coatings are subject to a reduction in gloss, while matte-finish coatings can increase in gloss level under normal operating conditions.
- Surface texture of resinous flooring surfaces can change over time as a result of wear and surface contaminants. Surfaces should be cleaned regularly and deep cleaned periodically to ensure no contaminant buildup occurs. Surfaces should be periodically inspected to ensure they are performing as expected and may require traction-enhancing maintenance to ensure they continue to meet expectations for the particular area and conditions of use.

STONHARD EST. 1922

USA HQ (800) 257 7953
Canada (800) 263 3112
Mexico +(52) 55 9140 4500
Argentina +(54) 11 5032 3113
Belgium +(32) 67 49 37 10
Dubai, UAE +(971) 4 3470460
South Africa +(27) 11 254 5500
India +(91) 22 28500321
Australia +(61) 3 9587 7433