

Strongcoat HB400 Method Statement

(Solvent free high build epoxy floor coating for 200 to 400 microns thickness)

Section A : General Comments

High temperature working

The following measures should be adopted if the ambient temperatures exceeding 30°C:

- (i) Unmixed materials and the equipment should be stored in a cool place and out of direct sunlight.
- (ii) Plan for enough material, tools and labours to avoid any stoppage during the application process.
- (iii) Avoid application through peak temperatures of the day.

Equipment

It is suggested that the following list of equipment is adopted as a minimum requirement:

<i>Protective clothing</i>	:	<i>Gloves, goggles, face mask and protective overalls</i>
<i>Mixing equipment</i>	:	<i>Slow speed mixing drill, mixing bucket (25 litre) and mixing paddle</i>
<i>Application equipment</i>	:	<i>Lambs wool roller and painting brush</i>

Section B : Application

1.0 Surface Preparation

- 1.1 Moisture content of new concrete, or any cementations substrates should be less than 4% or relative humidity less than 75%. Normally this range of moisture content can be achieved by concrete age over 28 days.
- 1.2 The substrate should be dry, clean and free from any laitance, wax, grease, dirt and oil or any materials could affect the bond.
- 1.3 Suitable Mechanical method such grinding, light sand/grit blasting, acid etching or any equivalent method should be used to remove any existing old coating or surface treatments like the curing compound, oil, etc.

Note: If the surface is contaminated by oil or grease, it is recommended to consult our technical department to advice for the suitable method for removing the contamination.

- 1.4 All cracks and spalled concrete should be repaired before starting the application as recommended by our technical department.
- 1.5 All blow holes and minor imperfection should be repaired with epoxy paste using Quickmast 341.

2.0 Mixing

- 2.1 Stir the individual components of the coloured base and hardener.
- 2.2 Add the entire contents of the hardener container to the base container and mix thoroughly using a slow speed drill mixer fitted with helix type paddle for 3 minutes until a uniform colour is achieved.
- 2.3 Make sure that the bottom and sides of the hardener part are thoroughly scraped. Partial mixing is not allowed.

3.0 Application

- 3.1 Priming: Strongcoat HB400 is designed to be used without primer, if the substrate is highly porous apply epoxy primer coat using Strongcoat Primer S.
- 3.2 Each independent area of application should have sufficient materials, equipments and labours.
- 3.3 The mixed materials should be used within 60 minutes @ 25°C and 30 minutes @35°C.
- 3.4 Use brush or lambs wool roller to apply the mixed Strongcoat HB400 onto the prepared surfaces.
- 3.5 Apply first coat of Strongcoat HB400 at 0.3 kg/m² per coat to achieve 200 microns thickness and allow to dry.
- 3.6 Next day, if high thickness is required, apply second coat of Strongcoat HB400 at 0.3 kg/m² per coat; it should be applied at a right angle to the first coat.
- 3.7 Adequate ventilation must be provided to ensure that necessary drying and curing of the material is achieved.
- 3.8 Allow 4 days after applying the final coat for full curing before vehicle traffic and 7 days if there is chemical spillage.

Note: Strongcoat HB400 can be applied at a thickness of 200 - 400 microns per coat.

4.0 Cleaning

- 4.1 Tools and equipment can be cleaned with DCP solvent when it is wet, dried Strongcoat HB400 may be removed mechanically.

Section C : Approval and variations

This method statement is offered by DCP as a 'standard proposal' for the application of **Strongcoat HB400**. It remains the responsibility of the Engineer to determine the correct method for any given application. Where alternative methods are to be used, these must be submitted to DCP for approval, in writing, prior to commencement of any work. DCP will not accept responsibility or liability for variations to the above method statement under any other condition.



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