

Strongcoat PA500 Method Statement (Polyaspartic aliphatic flooring system)

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 and mixing paddle</i>
<i>Application equipment</i>	:	<i>Low-pressure plural component spray machine, or airless spray machine or roller</i>

Section B : Application

1.0 Surface Preparation

- 1.1 Moisture content of new concrete or any cementations substrates should be less than 4% of relative humidity less than 80%. Normally this range of moisture content can be achieved by concrete age over 28 days.
- 1.2 All cementitious substrates must be structurally sound. Surfaces must be entirely free of oil, grease, paint, dust, curing agents, release agents or other surface contamination.
- 1.3 Loose or unsound material should be removed. Sweep and vacuum to remove all dust and debris.
- 1.4 Suitable Mechanical method such as 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 advise on a suitable method for removing the contamination.

- 1.5 All cracks and spalled concrete should be repaired before starting the application as recommended by our technical department.



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- 1.6 All blow holes and minor imperfections should be repaired with the epoxy paste using Quickmast 341.
- 1.7 Steel substrates should be prepared to a class 2 ½ near white blast finish with a surface profile of 80 microns.
- 1.8 Mask all adjacent surfaces and protect the surrounding area from overspray.
- 1.9 Do not apply unless the substrate temperature is 3°C or greater than the dew point

2.0 Priming

- 2.1 Substrates should be primed with Strongcoat PA500 Primer at a coverage rate of 5 - 10 m²/kg, depending on substrate porosity. A second coat may be needed if the first coat was fully absorbed by the substrate.
- 2.2 Strongcoat PA500 must only be applied while Strongcoat PA500 Primer is tacky in order to achieve optimum adhesion strength. Do not apply if the primer has become tack free.
- 2.3 Strongcoat PA500 Primer tackiness period depends on ambient and substrate temperature, below table should be followed for guidance in order to apply Strongcoat PA500 within the tackiness period:

Temperature	Tackiness Period
25°C	2:00 hr - 5:00 hr
40°C	40 min - 90 min

3.0 Mixing

- 3.1 Thoroughly power stir the B-side component for 6 – 7 minutes.
- 3.2 If the application requires Strongcoat PA500 to be pigmented add 10% by volume of the required pigment into the B-Side component and mix for another 2 – 3 minutes.
- 3.3 If the application is to be carried out by roller, and additional pot life is required, it is recommended to add Strongcoat PA500 Solvent to the B-side component at a rate of 10% - 20% by volume. The solvent is to be added after the addition of the colour pack and mixed thoroughly until a homogenous mix is achieved.
- 3.4 Combine the A-side and B side components and power stir again for 5 min before applying to the substrate.
- 3.5 The mixing ratio of comp. A to component B is 1:1 by volume.
- 3.6 To ensure full physical characteristics are achieved within the finished coating use graduated beakers/containers to ensure accurate 1: 1 by volume mixing of component A and component B.



4.0 Application

- 4.1 For the fastest and easiest application use low-pressure plural component spray machine-like LP-2 or LP-3.
- 4.2 Strongcoat PA500 can be applied using a standard airless spray machine or can be applied by roller, squeegee or notched trowel/rake.
- 4.3 Each independent area of application should have sufficient materials, equipment and labours.
- 4.4 The mixed materials should be used within 10 minutes @ 25°C. Additional pot life can be achieved by adding Strongcoat PA500 Solvent at a rate of 10% to 20% by volume to the B-Side component.
- 4.5 When applying two or more coats allowing each coat to dry before applying subsequent coats. The maximum overcoating time is 5 hours.
- 4.6 If the recoat window is exceeded, sand slightly to produce a profile, wipe with acetone and then apply the next coat.
- 4.7 Use an 8 – 13 mm Nap Mohair roller when rolling Strongcoat PA500. When applying Strongcoat PA500 with a squeegee or notched trowel the floor should be back rolled using a spiked roller to assist in de-airing the coating.
- 4.8 Apply first coat of Strongcoat PA500 at 0.20 – 0.25 ltr/ m².
- 4.9 Second coat (topcoat) should be applied at a right angle to the first coat, at 0.20 – 0.25 ltr/ m².
- 4.10 The second coat may be applied as soon as the first coat has initially dried.

Notes:

- *If pinholes, craters and bubbles appear after the application of the first or final coat, or for any other patch repair, the surface should be lightly sanded and material should be applied with the roller to match the existing thickness of already applied material.*
- *Avoid application under direct sun light, it is always recommended that the application is done under shadow.*

5.0 Cleaning

- 5.1 Tools and equipment can be cleaned with **Strongcoat PA500 Solvent** when it is wet, dried Strongcoat PA500 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 PA500**. 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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