



a.b.e.[®] Construction Chemicals

METHODOLOGY

abe.[®]cote WD 337

OLD CONCRETE

The surface has to be clean, sound, dry, free of oil and deleterious matter prior to applying the system.

See datasheet "Preparation of Surfaces".

All the repair areas are to be effected such that a smooth uniform finish is achieved; a new screed or scraper coat may be required. This finish is important in thin film applications less than 2 mm else the irregularities will reflect through the coating and is even more pronounced when gloss finishes are applied. The surface profile should not exceed 25 percent of the coating thickness if smooth finishes are required.

NEW CONCRETE

The surface has to be clean, sound, dry, free of oil and deleterious matter prior to applying the system.

See datasheet "Preparation of Surfaces".

The surface must be finished such that all the falls are correct and ready to receive the epoxy coating system. The surface profile should not exceed 25 percent of the coating thickness if smooth finishes are required. The success of any application depends on the strength of the concrete surface. A simple but effective test can be done with the use of an Elcometer adhesion tester. Adhesion failures at levels below 0,8 MPa indicates a relatively weak surface and the performance of the coating on this surface will be subject to doubt.

PREPARATION

In both cases above when the surfaces have been prepared the laitance has to be removed by one of the following methods:

1. Light grit blast, Vacuum blast or diamond grinding
2. Remove all deleterious matter and fill any holes and irregularities with **epidermix 314** or **epidermix 318**.

3. Due to flooring substrates been subjected to traffic a suitable scraper coat is to be applied if surface irregularities are present. The following is recommended:

Mix **abe.[®]cote** flooring resin with **abe.[®] sand No. 1** to form the scraper coat in the following ratio's:

2 litre of mixed resin: 4 kgs of fine sand (**abe.[®] sand No. 1** – 7319) – Yield + 3,48 litres

Thoroughly mix the material and apply the material using a steel float and finish to a smooth texture.

The surface has to sound and clean prior to application. See data "Preparation of Surfaces"

APPLICATION

Primer

Apply the primer coat **abe.[®]cote WD 337** to the surface – a single coat generally would be sufficient which is diluted with 10 to 15 % clean water. The primer is applied to a pre-dampened surface, but no free water, to prevent suction. One of the functions of the primer coat is to seal the surface and prevent air migrating through which causes "fish eyes" in the main coating; should the surface be porous an additional coat of **abe.[®]cote WD 337** may be required.

Main Coating

Apply the **abe.[®]cote WD 337** to the primed surface as per datasheet – 2 coats are required resulting in a final dry film thickness between 80 and 100 microns, or 100 to 125 microns wet film thickness per coat to obtain the required dry film thickness. Overcoating time is a minimum of 4 – 6 hours at 25°C.

Application

Mixed **abe.[®]cote WD 337** may be applied to the dampened substrate by water pre-moistened brush or roller or by airless spray using a ± 500 µm tip.

Ideally any first coat should be applied by brush. As soon as a coat is touch dry, a subsequent coat may be applied. Unless the treatment is required to provide chemical resistance, two coats are normally sufficient. Chemical resistant work or floors always requires three coats.

Drying time will depend upon temperature, humidity and ventilation. If working indoors or in confined spaces, always provide adequate ventilation. Outdoors, the film, until dry, is liable to wash off in rain or be damaged by frost.

abe.®cote WD 337 may be overcoated at any time. Ensure that the surface is clean and free of contamination and chalking. Overcoating, without intercoat adhesion problems, may be carried out with **abe.®cote WD 337** itself or solvent borne or solvent free epoxies or other compatible coatings.

Batch to batch colour variation may occur. Ensure that materials for that application are always drawn from the same batch.

In all cases for each product the intercoat application periods are to be strictly adhered to. All the datasheets are to be read for mixing, application procedures, pot life and coverage rates etc.

Pot Life

Mixed **abe.®cote WD 337** has a pot life of some 1½ hours at 20°C. While unused material may still appear workable after this time, it must under no circumstances be used.

Properties During Application

Application by:	Brush, short fibre roller or airless spray
Pot life:	@ 20°C: 90 min/5L @ 30°C: 45 min/5L
DISCARD UNUSED MATERIAL AT END OF THIS PERIOD EVEN IF STILL WORKABLE	
Volume solids (typical):	40% – varies slightly according to colour
Recommended avg. dft per coat:	40 µm
Coverage for above dft:	8 – 10 m ² /L on a smooth surface

Wet film thickness at above:	100 µm
Recommended No. of coats:	2 minimum
Drying time @ 25°C/60% RH	
Touch dry:	4 – 6 hours
Hard dry:	24 hours
Full cure:	3 days
Overcoating time	
Minimum:	4–6 hours @ 25°C
Maximum:	none
Application temperature range:	5°C to 35°C
Fire resistance of wet film:	Non-flammable

CLEANING EQUIPMENT

The use of **abe® super brush cleaner** or soap and water cleaner will remove any uncured material from the tools.

See datasheets for additional information.

IMPORTANT NOTE

This datasheet is issued as a guide to the use of the product(s) concerned. Whilst **a.b.e.® Construction Chemicals** endeavours to ensure that any advice, recommendation, specification or information is accurate and correct, the company cannot – because **a.b.e.®** has no direct or continuous control over where and how **a.b.e.®** products are applied – accept any liability either directly or indirectly arising from the use of **a.b.e.®** products, whether or not in accordance with any advice, specification, recommendation, or information given by the company.

FURTHER INFORMATION

Where other products are to be used in conjunction with this material, the relevant technical datasheets should be consulted to determine total requirements. **a.b.e.® Construction Chemicals** has a wealth of technical and practical experience built up over years in the company's pursuit of excellence in building and construction technology.

