INDUSTRIAL SPECIFICATION
Floors

STANDARD METHOD STATEMENT WATER BASED EPOXY FLOOR COATING SYTEMS

SYSTEM SHEET F4-UK Light Weight Water Based Epoxy suitable for low to medium duty concrete floors

Example of use – Warehouses, corridors, plant rooms subject to light to medium traffic

<table>
<tr><td colspan="3">Project – EXAMPLE ONLY Assessment on suitability must be made prior to use – If in doubt please consult with Tikkurila Technical Services</td></tr>
<tr><td>Environment:
ISO BC1 & 2</td><td>Notes:</td><td>Method Statement for painting internal concrete floors</td></tr>
<tr><td>Date: 2018</td><td colspan="2">Prepared By: Tim Haythornthwaite</td></tr>
<tr><td>Preparation Summary:

The performance of this system will depend on the degree and thoroughness of the surface preparation.

Mechanical Clean Preparation ISO ST3</td><td colspan="2">Surfaces to be coated must be clean, sound, dry and free from contamination.

Concrete must be sufficiently sound to accept a solvent free epoxy – Typically 25N/mm2

All accumulated contamination, salts, chlorine, dirt, grease, oil to be removed by most appropriate means. All contamination must be removed including oil and the use of alternative cleaning methods such as steam cleaning, heat guns etc may be required to aid the cleaning process. Power-cleaning equipment may be used to aid the cleaning process.

Completely remove all existing coatings back to original concrete/sound base.

Blast track or diamond grind overall or otherwise prepare in line with technical data sheet to remove all laitance and to abrade surface to present a fine granular texture/suitable ‘key’ ready for the application of an epoxy floor coating system. (See appropriate application data sheet on correct preparation requirements). Remove all debris spent abrasive and dust.

At day work joints, expansion joints, floor gullies and corner reinforcements bevel the edges of the concrete slab 30mm/70mm for the entire length of the joint. Clean holes and cracks before coating and making good with a suitable epoxy repair filler to produce a smooth surface compatible with the coating system proposed. Allow to fully cure and dry in depth.

Ensure the surfaces are perfectly clean sound and dry at the time of painting.</td></tr>
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Paint System

No of Coats	Product	Colour	DFT	Theo Spread Rate	Volume Solids	Thinner
1 or 2 x coats overall as required to satisfy porosity.	Fontefloor EP100 – Two pack water thinned epoxy floor coating. Thin with up to 30% water for first coat as appropriate to ensure good penetration into concrete	To match finish	50um	5m – 7m/litre/coat	58%	Water
*1 x Full Coat	Fontefloor EP100 – Two pack water thinned epoxy floor coating.	To match finish	100um	7m – 10m/litre/coat	58%	Water
*1 x Full Coat	Fontefloor EP100 – Two pack water thinned epoxy floor coating.	To match finish	100um	7m – 10m/litre/coat	58%	Water
		Total minimum DFT	**250um**			

***Anti-Slip Requirements** For an anti-slip surface broadcast appropriate aggregate into the 1st full coat of Fontefloor EP100 whilst still wet. When dry brush of surplus and apply final top coat. Allow for reduced spread rate on final coat.

Additional Notes:

Certain finish colours may require additional coats to ensure opacity.
Spread rates are theoretical and do not allow for wastage etc.
Ensure coatings are well ventilated during curing and sufficiently cured before overcoating.
Dry film thicknesses must be in accordance with ISO19840
Product must be applied in strict accordance with relevant technical data sheets

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MAINTENANCE RECOMMENDATIONS

To help ensure life to 1st maintenance is achieved it is good practice to carry out routine inspection and maintenance of painted floors to help prolong the life of the applied system and keep it in good condition.

1 - Regular inspection of the work is recommended.

2 - Localised repairs should be carried out as appropriate. I.e. Mechanical damage etc. This must be touched up or repainted as appropriate equivalent to the specified system. Whilst efforts should be made to obtain the maximum degree of cosmetic appearance it should be recognised that such repairs may be visible.

3 - Regular washing/cleaning and repairs as required are recommended. The frequency of cleaning must be appropriate to the degree and type of traffic.

4 - Two-component products such as floor coatings based on epoxy or polyurethane binder reach their final hardness generally within one week in favourable curing conditions. At lower (than recommended) temperatures curing will be retarded and the product may be sensitive to water during the first days after application. Coated surfaces must NOT be washed until the coating has reached its final hardness.

5 - Floors coated with two-component products can be cleaned with conventional, neutral or alkaline cleaning agents. Cleaning by hand: mop, floor drier, drying cloth. Mechanical cleaning: combined machine with medium coarse brush or mop (red).

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SUGGESTED REPAIR PROCEEDURES:

The Repair Procedures being suggested are for routine maintenance of coatings which have become damaged during life of the system and in the normal course of exposure/wear. These areas should receive a remedial system equivalent to the specified protective treatment. While efforts should be made to obtain the maximum degree of cosmetic appearance, it should be recognised that such repairs are likely to be visible. Consult with Tikkurila for advice.
Areas of damaged coating should be prepared as per original instructions to a firm coating edge. Sound coating edges should be feathered back and all areas to be over painted including 50mm of adjacent coating should be thoroughly abraded to form a 'key' and cleaned down as necessary (depending on overcoating characteristics of existing coating). All remedial areas should be cleaned down as required to provide a clean, dry surface for coating. Repair coats should be carefully applied and should overlap existing coats by the 50mm prepared area, ensuring that existing coating edges are sealed. Consult relevant Product Data Sheets and Health & Safety Data Sheets

Maintenance Coating Repair Summary:

	Type of Damage	Repair Procedure
A	Topcoat only damaged	Apply 1 coat of specified topcoat to 100um DFT
B	Topcoat and Intermediate coat damaged	Apply 1 or 2 coats as required Fontefloor EP100 to 100um DFT per coat, followed by 1 coat of specified topcoat to 100um DFT. (For certain finish colours, more than one coat may be required).
C	Topcoat, Intermediate and Primer coats damaged, primer intact	Patch prime with Fontefloor EP100 to 50um DFT per coat. Patch apply 2 coats of Fontefloor EP100 to 200um DFT. (For certain finish colours, more than one coat may be required).

It is important to ensure full film thicknesses are restored to those originally specified

This repair procedure is for general guidance only. If in doubt consult with relevant technical representatives before use

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STANDARD IMPORTANT NOTES:

Full risk and Health & Safety assessment must be carried out to satisfy method statement and products are suitable prior to application.

Observe all data sheet instructions.

All good painting practices apply as described in BS 6150:1982 & ISO 12944, 8504 BS 5493 and all other relevant standards.

Thorough preparation is essential.

Do not apply products during damp, wet or frosty conditions.

During application and curing Surface should dry. Relative humidity should not exceed 80%. Steel surfaces must be 3ºC above the dew point. Do not apply when rain, sleet, snow or mists are imminent.

All corrosion salts must be removed and steel chemically clean prior to painting. Testing for salts is desirable and allowances made for repeat washing made as appropriate.

All oil, grease, contamination etc. must be identified and removed prior to painting. Where cleaning has not successfully removed these deposits advice must be sought from appropriate technical services department.

Environmental conditions, temperature, humidity, ventilation must be carefully controlled and or monitored both during application and curing as required.

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Shop applied primers must be over coated as soon as possible after application taking note of maximum exposure times and over coating limits.

Regular inspection is recommended and repairs carried out as appropriate. i.e. Mechanical damage etc. This will help prevent premature deterioration.

Regular periodic washing will also help extend the life of the applied paint systems.

Application by brush may result in lower film thicknesses and additional coats may be required to achieve required film thickness.

Mastics and fillers – All defective mastics and fillers must be replaced or installed where required with appropriate mastic/filler/silicone sealant compatible with the paint system proposed

Any specification provided is our best recommendation from the information supplied and is given in good faith but without warranty or liability. We recommend a trial area is coated to ensure the product meets your requirements.

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