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K - Q TSE-ISO-EN 9000

Technical Data Sheet

BAYCOFLOOR-EP3355

Universal Industrial Self Levelling Coating

CE
2163 - CPR - 0250
TS EN 1504-2

Description:

BAYCOFLOOR-EP3355 is a two component epoxy resin for universal industrial self-levelling floor coating.

Areas of application:

BAYCOFLOOR-EP3355 is used as a heavy duty industrial floor coating

- on cement-based surfaces such as concrete and screed
- in production areas and warehouses
- on floors in the food industry and commercial kitchens, workshops, laundries, on loading ramps, roadways etc.
- as a priming coat for the production of decorative finishes together with BAYCO-DecorChips.

Properties/Advantages:

- solvent free
- pigmented
- highly resistant to mechanical and chemical loading
- high compressive and flexural strength
- resistant to many acids and alkalis as well as conventional cleaning agents at application concentrations
- economical
- resistant to weathering, tends to discolour under UV light
- suitable for contact with water and foodstuff

Technical Data:

Basis: 2-comp. epoxy resin
Standard colour: approx. RAL 7032
Viscosity: approx. 1200 mPas ± 15% at+20°C
Density: approx. 1,41 g/cm^3 at +23°C
Mixing ratio: 100:24 parts by weight
Pot life: approx. 45 mins. at +10°C
approx. 30 mins. at +20° C
approx. 10 mins. at +30° C
Application/Substrate temperature: min. approx. +10° C,
max. approx. +35° C
Min cure temperature: +8° C
Fully cured: after approx. 7 days at +23°C
Traffic after: approx. 12 hours at +23°C

Overcoat after: approx. 12 hours to max. 24 hours at +23° C
Compressive strength: approx. 68 N/mm^2
Flexural strength: approx. 45 N/mm^2
Adhesion strength: 2,5 N/mm^2 (ASTM D 4541:02)
Abrasion resistance: 125mg (ASTM D 4060:01)
*Full chemical resistance testing results available upon request.

Surface preparation:

The area to be treated must be:

- dry, firm, sound and have a good grip
- free from separating and adhesion inhibiting substances such as dust, laitance, grease, oil, rubber marks, paint residues and similar
- protected from moisture ingress from the rear.

Use suitable means to prepare the substrate dependent on its condition such as e.g. shot blasting, scabbling, grit blasting, brushing, sweeping, vacuuming.
In addition the following minimum substrate requirements for cementitious substrates are to be fulfilled.

- Concrete quality: min. C20/25
- Screed quality: min. EN 13813 CT-C25-F4
- Tensile adhesion strength: > 1,5 N/mm^2
- Render quality: P IIIa/P IIIb
- Tensile adhesion strength: approx. 0,8 N/mm^2

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Product preparation:

Components A (resin) and B (hardener) are delivered in a predetermined mixing ratio. Tip component B into component A. Ensure that the hardener drains completely from its container. Mixing of the components is to be carried out with a suitable mixer at approx. 300 rpm (e.g. drill with paddle). It is important to also stir from the sides and the bottom to ensure that the hardener is evenly dispersed. Stir until the mix is homogenous (free from striations); mixing time approx. 3 minutes. The minimum temperature during mixing should be +15° C. Do not use mixed material directly from the packaging. Decant the material intoa clean container and mix through thoroughly once again.

Production of levelling/scratch coat:

BAYCOFLOOR-EP1260:	1,0 part by weight
Quartzsand:	1,0 part by weight (grain size: 0,1 – 0,6 or 0.2 – 0.7 mm diameter)
BAYCO-FibreFiller:	approx. 1,5 to 2,0% by weight

The quartz sand is mixed into the previously homogenously prepared BAYCOFLOOR-EP1260. Ensure that the liquid and solid components are evenly mixed.
Before application to vertical or sloping surfaces it is recommended that INDU-FibreFiller is added to the levelling/scratch coat. The addition rate is between 3 and 5% by weight dependent on the degree of slope.

Production of a flowing mortar:
The flowing mortar consists of:

BAYCOFLOOR-EP3355:	1,0 part by weight
Quartz sand:	0,5 – 0,8 parts by weight (grain size 0,2 – 0,7 mm)

The quartz sand is mixed into the previously homogenously prepared and decanted resin and hardener components. Ensure that the liquid and solid components are evenly mixed. When mixing aggregate (e.g. quartz sand) ensure that the aggregate is dry and also at a temperature of +15° C. For roller or trowel applied coatings on vertical or sloping surfaces it is recommended that BAYCO-FibreFiller is added.

The addition rate is approx. 2% by weight for roller application and between 3 – 5 % for trowel application dependent on the degree of slope.
Advice: It is advantageous to premix the BAYCO-FibreFiller into the resin component followed by addition of the hardener component.

Method of application/consumption:

BAYCOFLOOR-IB3355 is either roller or trowel applied. Before applying BAYCOFLOOR-EP3355 prepare the substrate as described above and prime with BAYCOFLOOR-EP1260. When intermediate broadcasting, sprinkle with 0.2 – 0.7 mm quartz sand. With excessive unevenness use a smoothing coat dependent on the depth of dips (see valid technical data sheet for BAYCOFLOOR-EP1260 universal primer).

Thin coating (smooth surface) thickness:
approx. 1,0 mm:
After application of the primer trowel apply BAYCOFLOOR-EP3355 in one application.
Consumption: approx. 1,0 – 1,5 kg/m^2.

Thin coating (slip resistant surface) thickness:
approx. 1,5 – 2,0 mm:
After application and sanding of the primer apply BAYCOFLOOR-EP3355 with a rubber squeegee in one application and spread evenly with a short nap wool roller. Consumption: approx. 1,0 – 1,5 kg/m^2.

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Dependent on the degree of slip resistance required, broadcast the wet coating with quartz sand (0,2 – 0,7 or 0,5 – 1,0 mm). Consumption of broadcast sand: approx. 2 – 3 kg/m^2. Once hardened thoroughly remove all unbonded quartz sand before the finish coating is applied.
Finish coat: Apply BAYCOFLOOR-EP3355 with a rubber squeegee in one application and spread evenly with a short nap wool roller.
Spiked roller should be applied before finishing the application.
Consumption: approx. 600 – 800 g/m^2.

High build coating (smooth surface):
Fill BAYCOFLOOR-EP3355 with up to 50 – 80% quartz sand (0,2 – 0,7mm) and trowel apply in one application.
Consumption: approx. 0,9 – 1,0 kg/m^2/mm thickness.

Consumption (finished mix): approx. 1,6 kg/m^2/mm thickness.
To de-aerate the applied flow coating it is imperative that a spiked roller is used to prevent the formation of bubbles.

High build coating (slip resistant surface):
Fill BAYCOFLOOR-EP3355 with up 50% quartz sand (0,2– 0,7mm) and trowel apply in one application.
Consumption: approx. 0.9 – 1.0 kg/m^2/mm thickness.
Consumption (finished mix): approx. 1.6 kg/m^2/mm thickness.

To de-aerate the applied flow coating it is imperative that a spiked roller is used crossways to prevent the formation of bubbles. Dependent on the degree of slip

resistance required, broadcast the wet coating with quartz sand e.g. grain size 0,5 – 1,0 mm or 0,7 – 1,2 mm. Consumption of broadcast sand:
approx. 3 – 6 kg/m^2 dependent on thickness.
Once hardened thoroughly remove all unbonded quartz sand before the finish coating is applied.
Finish coat: Apply BAYCOFLOOR-EP3355 with a rubber squeegee in one application on to the sanded priming coat and spread evenly with a short nap wool roller.
Consumption: approx. 0,6 – 1,0 kg/m^2.
Optional: production of a decorative surface:
Spread BAYCO-DecorChips into the wet coating.
Consumption:
Closed surface: approx. 700 – 800 g/m^2
Open surface: from approx. 15 – 100 g/m^2
With a closed surface thoroughly remove all unbonded coloured chippings, once the coating has hardened, by vacuuming or sweeping. Afterwards lightly abrade and thoroughly clean by vacuuming.

Advice:
The waiting time between coatings is approx. 16 hours up to a maximum of 24 hours at +23°C and 65% relative humidity.

Possible situation:

Levelling of voids, large pores and unevenness:
After application of the primer, apply a scratch coat of
the mixed mortar (see above) in a single application.
Consumption of finished mortar:
approx. 1,6 kg/m^2/mm thickness.
To avoid the formation of bubbles in the following finish coat seal the scratch coat pore-tight with BAYCOFLOOR-EP1260.
Consumption: approx. 0,3 – 0,5 kg/m^2.
When waiting times will exceed 24 hours before the application of following coatings, broadcast dried quartz sand of particle size 0,2 – 0,7 mm into the wet sealing coat. Consumption: approx. 0,8 – 1,0 kg/m^2.
Once the sealing coat has cured, thoroughly remove all unbonded quartz sand. After a waiting time of min. 16 to max. 24 hours, apply the next coating.

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Notes:
Before application to vertical or sloping surfaces it is recommended that BAYCO-FibreFiller is added. The addition rate is between 3 and 5% by weight. Where there is residual moisture of > 4% or where there is negative moisture pressure use the moisture barrier BAYCOFLOOR-EP1240 as a primer (see Technical Data Sheet).

Cleaning & Equipment Maintenance:
Thoroughly clean tools immediately after use.

Packaging:
25 kg containers. Components A and B are delivered in a predetermined mixing ratio.

Storage & Shelf Life:
18 months when stored dry and cool above +10°C in the original unopened packaging.

Health & Safety:
Once cured BAYCOFLOOR-EP3355 is considered harmless. The hardener (B) component is corrosive. Current relevant legislation should be followed at all times when working with epoxies, e.g. hazmat transportation, etc. For more information please consult the valid safety data sheet.

Important advice:
- The application temperature neither may fall below +10°C nor exceed +40°C.
- Higher temperatures shorten the pot life. Lower temperatures increase the pot life and curing time. Material consumption is also increased at lower temperatures.
- To increase pot life/working time at higher temperature store material in a cool environment above +10° C and only expose to warm temperature shortly before mixing.
- The bond between the individual coats can be heavily impeded through the influence of dampness or contamination between the applied coats.
- When longer waiting times occur between application of the coats or where surfaces already treated with liquid resin must be re-coated after a long time, the surface must be well cleaned and abraded, after which a completely new closed-pore coating should be applied. It is not sufficient simply to overcoat.
- Surface protective systems must be protected for approx. 4 – 6 hours from dampness after application (e.g. rain, melt water). Dampness produces a white discolouration and/or stickiness on the surface and can impede the cure. Discoloured and/or sticky surfaces should be taken off e.g. by abrading and renewed.
- Applications that are not clearly explained in this technical data sheet may only be carried out after consultation with and written confirmation from our Technical Services Department.