

REC COAT 670 FC

SOLVENT FREE, HIGH BUILD, EPOXY RESIN FLOOR COATING

DESCRIPTION

REC COAT 670 FC is a solvent free system based on epoxy resins and curing agents specially selected for their ability to withstand chemical attack. The system consists of pre-weighed base & hardener components and a color pack, all of which contain reactive elements that are essential to the installation of the system.

A slip resistant texture can be provided by the use of one of a range of anti slip Grains which have been carefully graded to ensure an even texture.

PRIMARY APPLICATIONS

REC COAT 670 FC provides a hard wearing, chemical and abrasion resistant floor finish. It is ideally suited for use in wet areas where a high degree of resistance to chemicals, oils and grease is required such as:

- Dairies
- Soft drinks production facilities
- Chemical manufacturing plants
- Car parks and workshops.

FEATURES/BENEFITS

- Durable, low maintenance costs.
- Proven against a wide range of industrial chemicals.
- Solvent free - no odour during application.
- Slip resistant - different textures available to suit conditions to avoid slipping.
- Liquid applied providing complete protection.
- Available in a wide range of colours to improve the working environment and identify slip hazard areas.

TECHNICAL INFORMATION

The following values were obtained when tested at 20°C and 30°C.

PROPERTIES	@ 20°C	@ 30°C
Port life	40 mins	20 mins
Cure time	24 hours	18 hours
Maximum time between coats	36 hours	15 hours
Light traffic use after	24 hours	18 hours
Full traffic use after	48 hours	24 hours
Dry Slip Resistance @ 23°C	Extremely low	
Resistance to chemical spillage	7 days	
Compressive strength	70 N/mm ²	
Flexural strength	40 N/mm ²	
Tensile strength (ASTM D638-99)	20 N/mm ²	
Water absorption (ASTM D570-98)	<0.1%	
Shore D Hardness (ASTM D2240 : 1996)	77 - 85	
Reaction to fire	Class A	
VOC	6.4 g/l	

DIRECTIONS FOR USE

SPECIFICATION

The epoxy resin floor coating shall be **REC COAT 670 FC** from Reckon. The total dry film thickness of the coating shall be a minimum of 400 microns and shall have a compressive strength of 70 N/mm², flexural strength of 40 N/mm² and a tensile strength of 20 N/mm². The floor shall be prepared and the coating mixed and applied in accordance with the manufacturer's current data sheet.

DESIGN CRITERIA

REC COAT 670 FC is applied as a floor coating system comprising of two top coats (depending on the substrate conditions a primer might be required), each top coat to be a minimum of 200 microns thick. To provide a slip resistant texture, the first top coat can be dressed with anti slip Grains.

SURFACE PREPARATION

The long term durability of any resin floor system is determined by the adhesive bond achieved between the flooring material and the substrate. It is most important therefore that substrates are correctly prepared prior to application.

NEW CONCRETE FLOORS

These should normally have been placed for at least 28 days and have a moisture content of less than 5%. Floors should be sound and free from contamination such as oil and grease, mortar and paint splashes or curing compound residues. Excess laitance deposits are best removed by light mechanical scabbling, grinding or grit/captive blasting followed by vacuum cleaning to remove dust debris.

OLD CONCRETE FLOORS

A sound, clean substrate is essential to achieve maximum adhesion. As for new concrete floors dry removal of laitance deposits are best removed by light mechanical scabbling, grinding or grit/captive blasting. Oil and grease penetration should be removed by the use of a proprietary chemical degreaser or by hot compressed air treatment.

Any damaged areas or surface irregularities should be repaired using epoxy repair mortar.

PRIMING

Priming is not normally required provided the substrate is sound, untreated and good quality nonporous concrete. If any doubts exist of the quality of the concrete, or if it is porous it should be primed with **REC PRIMER**. Contact the TECHNICAL representatives of **RECKON CHEMICALS PVT Ltd.**, Lahore for advice.

REC PRIMER should be mixed in the proportions supplied. Add the entire contents of the hardener can to the base can. When thoroughly mixed, preferably using a slow speed drill and paddle, the primer should be applied in a thin continuous film, using rollers or stiff brushes. Work the primer well into the surface of the concrete taking care to avoid ponding or over application.

The primer should be left to achieve a tack-free condition before applying the top coat. A second coat of primer may be required if the substrate is excessively porous.

MIXING THE COATING

The base and hardener components of **REC COAT 670 FC** should be thoroughly stirred. The entire contents of the color pot should be poured into the base container and the two materials mixed thoroughly, then add the hardener component and mix for at least 3 minutes. The use of a heavy-duty slow speed, flameproof or air driven drill fitted with a mixing Paddle is desirable. Mix these components in the quantities supplied taking care to ensure all containers are scraped clean. Do not add solvent thinners at any time.

STANDARD APPLICATION

The first coat of **REC COAT 670 FC** should be applied using a good quality medium haired pile roller,

suitable for epoxy application, or squeegee to achieve a continuous coating.

Ensure that loose hairs on the roller are removed before use. A minimum film thickness of 200 microns should be applied. This can be increased where specifications demand. When the base coat has reached initial cure (12 hours @ 20°C or 5 hours at 35°C). The top coat can be applied by medium haired roller, at minimum film thickness of 200 microns. Care should be taken to ensure that a continuous film is achieved.

ANTISLIP APPLICATION

If a slip resistant texture is required, the base coat shall be applied as per the standard application, but at a minimum film thickness of 250 microns. The base coat should then be dressed with the chosen Antislip Grain. This should be done as soon as possible after laying. The recommended procedure is to completely blind the base coat i.e. apply excess dressing aggregate to completely obliterate the base coating.

Alternatively, the Antislip Grains can be broadcast in a light random dressing to provide a less dense finish. When the base coat has reached initial cure (12 hours @ 20°C or 5 hours at 35°C), the excess aggregate should be vacuum cleaned from the surface.

The top coat can now be applied by medium haired roller, at a rate of 4.0m²/litre. Care should be taken to ensure that a continuous film is achieved and the rough surface, caused by the aggregate, is completely sealed. This top coat must be applied within 36 hours @ 20°C (15 hours @ 35°C) of the application of the first coat.

EXPANSION JOINTS

Expansion joints in the existing substrate must be retained and continued through the **REC COAT 670 FC** topping. RECKON have a range of joint sealants specifically designed for flooring, contact TECHNICAL representatives of RECKON CHEMICALS PVT Ltd., Lahore for advice.

CLEANING

Tools and equipment should be cleaned with RECKON CLEANER immediately after use. Spillages should be absorbed with sand or sawdust and disposed of in accordance with local regulations.

LIMITATIONS

- **REC COAT 670 FC** should not be applied on to surfaces known to, or likely to suffer from, rising dampness, potential osmosis problems or have a relative humidity greater than 75% as measured in accordance with BS 8203 Appendix A, or by a Hammond concrete/mortar moisture tester type COCO.
- RECKON does not recommend acid etching as a method of floor preparation. If used, the method should be approved by the project consultant.
- In common with all epoxy materials, some slight shade changes may be experienced over the long term when placed in adverse exposure conditions. Any such change in shade is not regarded as being detrimental to performance.

PACKAGING

REC COAT 670 FC is available in 6kg, 20 kg and 30 kg packs.

STORAGE

SHELF LIFE

REC COAT 670 FC has a shelf life of 12 months when stored in warehouse conditions below 35°C in the original, unopened packs.

STORAGE CONDITIONS

Store under warehouse conditions, below 35°C in the original, unopened packs.

For further information, refer to the Product Material Safety Data Sheet.

CLEANING AND DISPOSAL

Spillages of component products should be absorbed on to earth, sand or other inert material and transferred to a suitable vessel. Disposal of such spillages or empty packing should be in accordance with local waste disposal regulations.

HEALTH & SAFETY

As with all construction chemical products, caution should always be exercised. Protective clothing such as gloves and goggles should be worn. Treat any splashes to the skin or eyes with fresh water immediately. Should any of the products be accidentally swallowed, do not induce vomiting, but call for medical assistance immediately.

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RECKON CHEMICALS PRIVATE LIMITED
21 CCA, BLOCK B, KHAYABAN-E-AMIN, LAHORE
Tell: +92-42-35452620, +92-42-35230419
Web: www.reckonchemicals.com
Email: Info@reckonchemicals.com

