

### Technical Data & Instruction Sheet

#### PRODUCT BENEFITS

Excellent levelling properties

High gloss seamless flooring

High durability and chemically resistant

Easy to clean and maintain

#### MECHANICAL PROPERTIES

Compressive Strength: 60 Mpa  
(ASTM C579)

Tensile Strength: 15 Mpa  
(ASTM C 307)

Bond Strength: >1.5 MPa

#### MIXING RATIO

A:B:C:D:: 5:2.5:10.5:0.315

#### PACK SIZE

Part A (Resin): 5kg  
Part B (Hardener): 2.5kg  
Part C (Filler): 10.5kg  
Part D (Pigment): 0.315kg

#### COVERAGE

1.5 Kgs/ Sq. mtr. for 1mm

#### TECHNICAL INFORMATION

Pot Life: 30 minutes

Curing Time (Touch Dry):

25°C-50°C: 2-5 Hours  
15°C-25°C: 5-7 Hours  
5°C-15°C: 8-24 Hours

Curing Time (Full Cure): 7 Days

Shelf Life: At least 2 year, if stored in a cool and dry place in original container

#### PRODUCT DESCRIPTION

RachTR Floor 1010N is three components, self-levelling industrial epoxy flooring with high durability, chemical resistance and good aesthetics. It provides a seamless floor which is hygienic and easy to clean. It recommended for thickness of 0.5mm to 1.5mm.

#### APPLICATION CONDITIONS

Residual moisture content of the concrete substrate should not exceed 5%

No rising moisture & potential osmosis problems

Substrate temperature should be at least 3°C above dew point but not above 50°C

Recommended ambient temperature for application is between 10°C - 40°C

Relative Air Humidity (RH) to not exceed beyond 80%

#### APPLICATION GUIDELINES

##### Substrate Quality

Concrete substrates must be sound and of sufficient compressive strength (minimum 20 Mpa) with a minimum tensile strength of 1.5 Mpa

A sound, clean and dry substrate is absolutely essential to ensure optimum bonding between the substrate and the coating system

The substrate must be clean, dry and free of all contaminants such as dirt, oil, grease, coatings and surface treatments, etc. The moisture content should be less than 5% prior to application of the primer. Ensure that the substrate does not suffer from rising moisture and potential osmosis problems

#### Surface Preparation

New concrete floors:

Should be at least 28 days old or have a moisture content of less than 5% before proceeding with epoxy primer application.

Old concrete floors:

Determine the general condition, soundness, presence of contaminants, and presence of moisture vapor emissions. Mechanical surface profiling by grit or shot blasting, grinding or scarifying should be done for floor preparation of old concrete floors

Remove localized weak or deteriorated materials from the surface. Remove bond-inhibiting materials such as oils, grease, wax, fatty acids, and other contaminants. Clean with detergent scrubbing, low pressure water cleaning, steam cleaning, or chemical cleaning. Acids and alkalis can be removed by neutralizing to form a water-soluble salt and then high pressure water cleaning and mopping it off to dry state

Surface defects such as voids, bug holes, excess porosity, and physical and chemical damage are should be filled or repaired. Materials such as slurries, mortars, and polymer concrete are used to level, smooth and patch concrete surfaces. Floor should be made smooth by grinding.

Acid etching of the surface is not recommended

## Floor Joints

All cracks and construction joints present, should be filled either with epoxy putty or mortar after primer application

The expansion joints should not be coated with the coating and are to be treated with suitable products.

## Primer Application

Surface should be primed with RachTR EP 101. The primer should be applied to the prepared substrate using stiff brushes and/or rollers. The primer should be well 'scrubbed' into the substrate to ensure full coverage, but avoid over application or 'ponding'

Porous substrates may require a second primer coat, but minimum over-coating times must still be observed

Freshly applied primer should be protected from damp, condensation and water for at least 24 hours

## Mixing

RachTR 1010 N flooring is supplied in 4 pre-weighed packs (Base, Hardener, Filler and Pigment) which are ready for immediate on-site use.

Part A: Resin  
Part B: Hardener  
Part C: Filler  
Part D: Pigment

A suitable power-driven mixer such as a slow-speed drill fitted with mixing paddle is recommended for uniform mixing

Part D (Pigment) should be added to the Part A (Resin) container and mixed for 1-2 minutes, until homogeneous. Then add Part B (hardener) and mix for further 2 minutes, until an even colour and texture is obtained

Thereafter, the contents of Part C (filler) should be slowly added and mixing carried out for a further 3 minutes until a completely homogenous material is obtained.

## Application

The product may be applied by a serrated/ notch trowel to the required thickness

The entire mixed material should be poured onto the primed surface and spread slowly and evenly

To ensure proper levelling and appearance avoid overspreading.

The laid material should be rolled firmly with a spike roller to ensure compactness and de-aeration of the film

Always wear spike shoes when rolling with spike roller. The rolling should be carried out using a 'back and forth' technique along the same path

An overlap of 50% with adjacent paths is recommended

Further light rolling may be required to remove surface imperfections, or for subsequent release of trapped air. This should be done immediately

To avoid roller marks prevent over rolling of the coating

Freshly applied material should be protected from damp, condensation and water for at least 24 hours

At low temperatures, the chemical reactions are slowed down; this lengthens the pot life, open time & curing times

High temperatures speed up the chemical reactions thus the time frames mentioned above are shortened accordingly

## SAFETY MEASURES

Use gloves, goggles & respirators while applying.

## STORAGE AND HANDLING INSTRUCTIONS

May be harmful if swallowed. May cause skin, eye and respiratory irritation. Do not spray. Avoid prolong exposure to vapors. Use in a well ventilated area. Do not ingest. KEEP OUT OF THE REACH OF THE CHILDREN. Do not freeze or store above 40° C. Do not mix with other chemicals

## EMERGENCY/ FIRST AID PROCEDURES

Ingestion: Do not induce vomiting. Call a physician

Eye Contact: Flush thoroughly with water for at least 15 minutes. Remove contact lenses, if applicable, and continue flushing. Call a physician if eye irritation persists

Skin Contact: Wash skin with mild soap and water. Call a physician if skin irritation persists. Wash clothes before wearing again

Inhalation: Remove to fresh air. Call a physician if respiratory irritation persists

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