STONHARD

PRODUCT DATA

STONKOTE® 681

PRODUCT DESCRIPTION
Stonkote 681 is a two component pigmented water-based polyamide cured epoxy enamel. The cured film provides a tough, cleanable, aesthetically pleasing surface which is easily recoatable.

USES
Economical wall and floor coating in ablution blocks, food processing plants, hospitals and schools which are subject to light traffic and non-aggressive chemical cleaning and spillage. Ideal product for the DIY enthusiast needing to coat domestic garage and laundry floor areas.

PRODUCT ADVANTAGES
- Easy application
- Bonds to green plaster
- Excellent water resistance
- No toxic vapours in confined spaces
- No fire risk
- Self-priming

PACKAGING & COVERAGE
5lt kit; Part A + B
6 to 8m²/litre/coat One primer coat diluted with 5% water
Two topcoats, dependent on substrate porosity

SHELF LIFE
24 Months if stored between 15°C and 30°C

TYPICAL RESISTANCE GUIDE

Exposure	Splash & Spillage	Fumes
Acids	Good	Good
Alkalies	Very Good	Very Good
Solvents	Very Good	Very Good
Water & Salt	Excellent	Excellent
Weather	Coating will chalk	

STORAGE CONDITIONS
Store all components of Stonkote 681 between 16 and 32°C in a dry area. Avoid excessive heat and do not freeze. The shelf life is one year in the original, unopened container.

TYPICAL PROPERTIES AT 25°C

Finish	Semi-gloss
Colour	Refer to Epoxy colour chart / Off-white & Black
Consistency	Thixotropic Liquid
Volume Solids	38 to 42%
Number of Components	2
Mix Ratio by Volume	4:1 (Base:Activator)
Pot Life	60 Minutes
Apply Over	Prepared plaster, concrete, wood or primed steel
Apply By	Brush, roller or air spray
Curing Time	6 to 8 Hours – recoat 24 Hours – service 7 Days – full cure
Max Service Temperature	75°C Dry 45°C Wet
Application Temperature Range	15°C to 35°C
Dew Point	Substrate to be 2°C above dew Point
VOC Content	6g/l
Chemical Resistance	Consult StonCor Africa Technical Service
Thinner	Water (not to exceed 5% by volume)

NOTE: The above physical properties were measured in accordance with the referenced standards. Samples of the actual floor system, including binder and filler, were used as test specimens. All sample preparation and testing is conducted in a laboratory, values obtained on the field applied materials may vary

REFERENCE SAMPLE
A trial reference sample should be installed by the applicator prior to start of contract to ensure correct coverages and workmanship.

APPLICATION

SCOPE OF WORK (BOQ):
Prepare surfaces and apply Stonkote 681 to prime and then subsequent coats to seal floor and wall surfaces subjected to light traffic and non-aggressive cleaning methods.

SUBSTRATE PREPARATION:
Remove oils, grease and other contaminants by scrubbing with Carboclean 252 and rinsing with clean running potable water, to obtain a water break-free surface. Allow to dry. Abrade the surface by etching or grinding or light vacublasting to remove laitance and open all voids. The roughened surface should have a texture similar to 100-grit sandpaper, and minimum tensile strength of 1.5 MPa and moisture content of 5% maximum.

PREPARING STONHARD FLOORING SYSTEMS OR RECOATING:
Before coating a Stonhard floor, all trowel marks and surface imperfections must be removed to produce a smooth surface. Grind the floor using a floor grinder with medium stones and vacuum using an industrial wet/dry vacuum to remove all dust particles. The Stonhard floor is now ready to be coated. For recoat applications, after removing contaminants, abrade surfaces with 100-grit sandpaper, sweep and vacuum to remove dust and grit, then protect from traffic until ready to recoat.

MIXING:
Empty the entire contents of the Activator component into the Base component and mix thoroughly for 2 minutes using an impeller fitted to a variable speed drill. Transfer material into another mixing container, scraping the sides and bottom of the container and remix for a further 2 minutes. This step is critical to ensure complete cross-linking of components is achieved. Do not aerate mix nor mix by hand.

PRIMING & PATCHING:
Apply one coat of Stonkote 681 thinned with 5% water at approximately 6m²/litre with a roller to seal the pores. Allow to cure for 6 to 8 hours before overcoating. If necessary patch cracks and holes by filling with Pro-Struct 30/35NS Quickset Epoxy Paste or, if badly pitted, skim floor surface with a trowel, using Stonkote 723. Allow to cure and sand smooth before coating.

COATING:
Apply two coats of Stonkote 681 Water-based Epoxy Coating at 6 to 8m²/litre/coat using a medium nap roller, allowing 6 to 8 hours curing between coats. **NB:** If cold conditions prevail, this curing time must be extended.

COLD CONDITIONS:
Low temperatures decrease flow, delay set and affect water resistance and final appearance. Materials should be conditioned for 16 hours at 21-27°C; heaters should be utilised to warm floors.

CURING:
If temperatures are between 16°C to 30°C, the coating system can be exposed to light traffic after 24 hours. Excessive traffic, aqueous cleaning and exposure to chemicals should only take place after 7 days, when full cure has been achieved.

RECOMMENDATIONS:
- DO NOT attempt to install material if temperature of components and substrate are not within 16°C to 30°C. The cure time and application properties of the material are severely affected.
- DO NOT use water or steam in the vicinity of the application. Moisture can seriously affect the working time and other properties.
- Protect areas from dust and isolate access. Contamination between layers will affect the final appearance.
- Avoid contact with all liquid Parts A and B as they may cause skin and/or eye irritation. Workmen should cover hands with protective creams or rubber gloves and wear safety glasses.
- Use only with adequate ventilation.

NOTES:
- Procedures for maintenance of the flooring system during operations are described in “StonCor Cleaning Procedures”.
- Specific information regarding chemical resistance is available in the Chemical Resistance Guide.
- Material Safety Data Sheets are available on request.
- A staff of technical service engineers is available to assist in installation or to answer questions related to our flooring products specifically, or flooring problems in general.
- Requests for technical literature or service can be made through local sales representatives and offices, or corporate offices located worldwide.