

PRODUCT DESCRIPTION

Stonkote 723 is a two-component, 100% solids, high build protective epoxy floor coating. Stonkote 723, due to its high build composition, has increased abrasion resistance when compared to a general service thin film coating. It also has enhanced aesthetic appeal and cleanability. Stonkote 723 cures to a high gloss, smooth finish.

USES, APPLICATIONS

Stonkote 723 is designed for use whenever a high build, 100% solids, chemical resistant, high gloss, smooth epoxy coating is required on horizontal surfaces. Some applications of Stonkote 723 are:

- In conjunction with various Stonhard flooring systems
- Substrates requiring high build, protective coating that is easily cleaned and maintained
- Protection of concrete surfaces exposed to abrasive or corrosive environments

PRODUCT ADVANTAGES:

- 100% Solids.
- High build epoxy coating.
- Dense, impervious finish with good stain resistance.
- Long term abrasion and corrosion resistance.
- Easily applied to horizontal surfaces.
- Excellent bond strength assures good adhesion.
- Bonds to many different substrates.
- Durable, high gloss finish permits easy cleaning and maintenance.
- Factory proportioned packaging ensures consistent high quality, simplified mixing.

PACKAGING AND COVERAGE

Primer: 5lt Stonprime 639 Part A + B: 4 to 6m²/litre/coat

Topcoat: 5 and 20lt Stonkote 723 Part A + B:
Roller application 4 to 5m²/litre/coat, 2 coats required, 400 to 500 microns
Flocoat application 1 to 1.5m²/litre, 660 to 1000 microns

STORAGE CONDITIONS

Store all components of Stonkote 723 between 16 to 32°C in a dry area. Avoid excessive heat and do not freeze. The shelf life is one year in the original, unopened container.

COLOUR

Stonkote 723 is available in 9 standard colours. Refer to the Flooring colour chart. Custom colours are available upon request.

REFERENCE SAMPLE

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

TYPICAL PROPERTIES AT 25°C

Percent Solids	100%
Pot Life at 25°C	35 Minutes
Cure Rate at 25°C	8 Hours for tack-free surface 24 Hours for normal operation
Temperature Limitations	60°C continuous exposure 93°C intermittent exposure
Fire Resistance of Dry Film	Self-extinguishing
VOC	27 g/l

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.

PLACEMENT GUIDELINES

SCOPE OF WORK (BOQ):

Prepare surfaces and apply Stonkote 723 onto Stonprime 639 primed surfaces.

Option 1: Flocoat 1mm self-smoothing applied with 3mm notch trowels and spike rollers at 1m²/litre.

Option 2 Roller Coat: High build 0.5mm roller application at 4 to 5m²/litre/coat, 2 coats required.

SUBSTRATE PREPARATION

Proper preparation is critical to ensure an adequate bond. The substrate must be dry and free of all wax, grease, oils, fats, soil, loose or foreign materials and laitance. Laitance and unbonded cement particles must be removed by mechanical methods, i.e. abrasive blasting or grinding. Other contaminants may be removed by scrubbing with a heavy-duty industrial detergent (Carboclean 250 or Carboclean 252) and rinsing with clean water. The surface must show open pores throughout with main aggregate in concrete exposed and have a sandpaper texture. Substrate moisture content should be below 5% and substrate tensile strength above 1.5 MPa. For recommendations or additional information regarding substrate preparation, please refer to surface preparation, technical data sheet or contact StonCor Africa Technical Service Department.

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.

PRIMING AND PATCHING

Mix Stonprime 639 Part A and B thoroughly for 5 minutes using a drill fitted with a spiral impeller. Apply one coat or two coats, dependant on the porosity, of Stonprime 639 Penetrating Primer at 4 to 6m²/litre with a roller to seal pores and achieve a uniform gloss finish. Allow to cure for 8-12 hours before coating. If necessary, patch cracks and holes by filling with Pro-Struct 30/35NS Adhesive or, if badly pitted, skim the surface with the edge of a steel trowel, using Stonkote 723 Scraper Coat. Allow to cure and sand smooth before coating.

MIXING STONKOTE 723

Under no circumstances are the supplied kits to be split. The contents of the base component in the kit are to be thoroughly mixed for 1 minute before use. Empty entire contents of the activator into the base component. Mix thoroughly for 2 minutes with an impeller fitted to a variable speed high torque 550 RPM mixer. Transfer mixed material into another mixing container, scraping the sides and bottom of the container and remix for another 2 minutes. This step is critical to ensure complete cross-linking of components is achieved. Do not mix by hand.

COATING

Dependant on wear and surface finish requirements, apply by either method 1 or 2 Stonkote 723.

1. Flocoat 1mm Notch Trowel Method (1 coat at 20m²/20 litre kit):

Pour mixed material in a bead on the floor and rake out using a 3mm notch trowel, spreading evenly at a thickness of 1,0 – 1,5mm. If necessary, use a mohair or looped roller to even out undulations. Deaerate and level by rolling with a spiked roller for up to 20 minutes after application. Spiked shoes are utilised to walk onto wet material during the levelling and de-aeration process.

2. High Build 0,5mm Roller Application Method (2 coats at 4-5m²/litre/coat):

Apply a minimum of 2 coats of mixed material out of paint trays using short nap rollers at 4-5m²/litre/coat, allowing 8-12 hours between coats. If skilled, trained staff are available, the application time can be shortened by applying the material as a scraper coat with a steel trowel and rolling evenly with short nap rollers.

NB: If cold conditions prevail, material is thicker, substrates and material should be warmed to allow for good flow out of material. An easy cleaning mild non-slip finish can be achieved by overcoating the floor with Stonseal 722 Non-slip Sealer at 6-8m²/litre/coat. Variable non-slip finishes can be achieved by broadcasting Fine Texture # 6221 or Medium Texture # 6222 into the 1st coat at 2kg/m², sweeping off unbound grit when cured, and sealing with 2nd coat of Stonkote HB4 method at 3m²/litre/coat.

CURING

At normal temperature conditions, 25°C, the coating system can be exposed to light traffic after 24 hours. Excessive traffic, aqueous cleaning and exposure to aggressive chemicals should only take place after seven days when full cure has been achieved.

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.

RECOMMENDATION:

- DO NOT attempt to install material if temperature of components and substrate are not within 16 to 32°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 service or literature can be made through local sales representatives and offices, or corporate offices located throughout the world.

To the best of our knowledge the technical data contained herein are true and accurate at the date of issuance and are subject to change without prior notice. User must contact StonCor Africa to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to StonCor Africa quality control. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, is limited to replacement of products. Prices and cost data, if shown, are subject to change without prior notice. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY STONCOR AFRICA, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

CHEMICAL RESISTANCE GUIDE

The purpose of this guide is to aid in determining the potential value of Stonkote HB4 when exposed to the damaging effects of corrosive chemical environments.

RATING CODE

E – Excellent
G – Good
NR – Not Recommended
OS – Suitable for use where “occasional spillages” occur, when flushing with water immediately follows

ACIDS

	RATING		RATING
Acetic – 5%	G	Hypochlorous – 5%	E
Acetic – 20%	OS	Lactic – Up to 20%	OS
Acetic – Glacial	NR	Maleic – 30%	G
Benzoic – Sat	E	Maleic – 40%	OS
Boric – Sat	E	Nitric – 10%	G
Butyric – 10%	OS	Nitric – 30%	OS
Chromic – 10%	G	Oleic	G
Chromic – 20%	OS	Oxalic – Sat	E
Citric – 50%	E	Perchloric – 35%	G
Cresylic	OS	Phosphoric – Up to 50%	OS
Diglycolic	G	Picric – Sat	E
Fatty	G	Phthalic	G
Fluoboric	G	Succinic – Sat	E
Formic – Up to 10%	OS	Sulfuric – 20%	E
Heptanoic	OS	Sulfuric – 50%	G
Hydrochloric – 15%	G	Sulfuric – 70%	OS
Hydrochloric – 37%	OS	Tannic – Sat	G
Hydrofluoric – 10%	OS	Tartaric – Sat	E

ALKALIES AND SALTS

Stonkote HB4 is rated Good to Excellent when exposed to most alkalies and salts

SOLVENTS AND OTHER CHEMICALS

	RATING		RATING
Acetone	NR	Linseed Oil	G
Alcohol (Methyl)	OS	Methyl Ethyl Ketone	NR
Alcohol (Ethyl, Propyl, Isopropyl, Butyl)	G	Methylene Chloride	NR
Benzene	OS	Milk	E
Carbon Tetrachloride	OS	Mineral Spirits	G
Corn Oil	E	Naphtha	G
Cyclohexane	G	Oils – Cutting	G
Denatured Alcohol	G	Oils – Mineral	E
Ethylene Glycol	G	Oils – Vegetable	G
Ether	OS	Perchloroethylene	G
Formaldehyde	G	Skydrol	G
Gasoline	E	Sucrose – Sat (Sugar)	E
Glycerine	E	Toluene	OS
Hydrogen Peroxide – 10%	G	Trichloroethylene	NR
JP5 Jet Fuel	G	Urea	G
Juices – Fruit	E	Vinegar (Household)	G
Juices – Vegetable	E	Water	E
Lard	G	Xylene	OS

NOTE: This data is based on laboratory tests performed under carefully controlled conditions. (All solutions are at ambient temperatures). No warranty can be expressed or implied regarding the accuracy of this information as it will apply to actual plant operation or job site use. Plant operations and job site uses vary widely and the individual results obtained are affected by the specific conditions encountered, which are beyond our control.

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