



# Flowcoat 340

## Application instructions

### Preparation/Substrate

Surfaces to be coated should be sound and provide adequate strength for the proposed end use (minimum 25 N/mm<sup>2</sup> compressive strength).

The surface profile and levels should be appropriate for the system to be applied. Substrate humidity must not exceed 75% RH, in which case use Hydraseal DPM.

Blasting, scouring or diamond grinding removes laitance. Irregularities, damage and cracks are filled with epoxy filler. All residues must be removed to provide a dry, dust free open textured surface.

Contact us for advice if there are impurities, such as oils etc., in the concrete. Check the relative humidity of floors at ground level. Follow our instructions for connections to grid drains, cesspools, pipes and pipe inlets.

### Primer

Application on an untreated, porous concrete surface can cause air bubbles and in the finished coating. To avoid this, prime the floor using an additional coat of Flowprime 348.

Pour Hardener B into the packaging holding Base A and completely pour out the resultant mixture. Mix using a low-speed drill and stirrer until a homogenous mixture is obtained (approximate mixing time 3minutes). Do not mix in too much air.

Allow the primer to harden until the surface can be walked on, approx. 15 hours at 20°C. At lower temperatures the hardening time is longer. It is important there are no dry patches. If in doubt, check the adhesion using an adhesion tester. Minimum requirement 1.5 MPa (1.8 MPa for heavy stress).

Apply immediately after mixing using a double-lipped rubber squeegee and/or roller. Ensure that the primer permeates any surface irregularities.

Consumption, primer: Approximately. 4m<sup>2</sup>/ℓ.

Hydraseal DPM is to be used as the primer in instances where the substrate exceeds 75% RH; refer to the separate application instruction for more information.



## Mixing

**Flowcoat 340** is supplied in complete batches, A+B. The coloured Base A must be stirred well. Transfer Hardener B to Base A. Mix thoroughly using a low-speed drill for 2-3 minutes. Thoroughly stir. The mixed material should be used within 20 minutes at 20°C.

Remember never to split batches/components. Incorrect mixing ratios or poor mixing can result in irregular hardening or variations in colour, etc.

## Application

**Flowcoat 340** is applied with a roller or rubber squeegee/roller.

The product can be applied in one (thick) coat or two coats. The second coat is applied after at least 10 hours, and no later than 24 hours after the first coat.

**NOTE!** Use a high-quality roller to avoid “fluff”.

**If anti-slip protection is required**, natural sand can be sprinkled into the first layer. Before applying the topcoat, lightly scour the surface and vacuum the floor thoroughly. Complete the process by applying a final layer of Flowcoat 340.

The degree of anti-slip protection should be discussed with the customer before application.

A layer of sand increases the surface profile and hence the coverage so more material is required on the second coat.

### Note that:

Flowcrete products are often multiple-component systems. Poor mixing, or incorrect mixing procedures, can result in irregular and incomplete hardening, which in turn can result in an inferior final result.

Coloured Base A is stirred first before Hardener B is added.

The temperature should be above 15°C to achieve the best results during application. The temperature of the substrate should be at least 10°C, although a temperature of 15-30°C is recommended.

The temperature of the substrate should exceed the “dew point” by more than 3°C during application and hardening.

The product should be stored in such a way that the temperature is the same as the room temperature where the product is to be applied, i.e. between 15-25°C. This improves the mixing, flow, penetration and hardening of the product.

The surface can normally be walked on after approx. 15 hours at 20°C. Complete hardening takes 5-7 days.

There are often several types of products at a workplace. Sort the products separately to avoid mistakes.

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## Consumption/Ratio of Components

### Flowcoat 340

**Consumption of Materials** approximately 4-5m<sup>2</sup>/ℓ per coat (may vary depending on the substrate)

**Ratio of Components** volume

A:B 2:1

## Cleaning of Tools

Cleaned immediately after use in solvent, e.g. Water soluble brush cleaner or Acetone.

*Any recommendation or suggestion relating to the use of the products made by Flowcrete SA Ltd., whether in its technical literature, or in response to a specific enquiry, or otherwise, is based upon data believed to be reliable, however the products and information are intended for use by Customers having requisite skill and know-how in the industry and therefore it is for the Customer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that the Customer has done so at its sole discretion and risk.*