

## **SHOP FLOOR INDUSTRIAL EPOXY FLOORING**

**IMPORTANT!** Read these instructions carefully several days prior to starting your work. Seek answers to any questions you may have before you begin. DUR-A-FLEX, Inc. maintains a Technical Staff who will be glad to assist with your questions. Pail or bucket mixers are highly recommended for mixing cove base and patching compound. Material for small areas can be mixed with a 1/2" - 3/4" heavy duty, slow speed, electric drill equipped with a Jiffler mixer attachment and a 5-gallon metal pail.

SHOP FLOOR is applied by the broadcast method. When recommended spread rates are followed, a Flintshot double broadcast produces a nominal 1/8" thick finish.

### **SURFACE PREPARATION**

Surface must be clean, sound, dry and free of all oil, grease, detergent film, sealers and/or curing compounds. A surface profile of CSP 3 minimum is appropriate for most applications. All paint should be removed unless it is a properly applied, totally de-glossed, high quality epoxy. Please refer to the DUR-A-FLEX Surface Preparation Guide on our website for detailed instructions. No epoxy coatings should be applied unless surface temperature is a minimum of 5 degrees F above dew point. See Dew Point Calculation Chart on our website for detailed instructions.

### **MIXING AREA**

Select a convenient mix area and protect the surface from spillage by covering with a layer of cardboard and/or sheet of plastic. Be generous with the amount of space you allocate for this function. The more comfortably your mixer works, the less likely you are to have a "mix error". Make ready all necessary tools, mix and measure containers, etc. **DO NOT MIX ANY EPOXY UNTIL READY FOR IMMEDIATE USE.** Once hardener and resin are combined, it must be used without delay. Apply masking tape wherever coating is intended to stop. To obtain neat, straight, chip resistant edges at termination points and/or drains, a "keyed edge" must be installed.

### **PRIMING**

Prime all surfaces with DUR-A-SHIELD, DUR-A-GLAZE WB PRIMER or DUR-A-GLAZE #4 TIE-COAT II as soon as the surface has been prepared. On oily concrete slabs, SIMONIZ 969 Cleaner is recommended. Be sure to apply primer **before** oil has a chance to "wick" up to the top of the slab and migrate across the surface.

### **QUALITY CONTROL**

The color of SHOP FLOOR resin may vary slightly from batch to batch. It is recommended that the lot number on the side of the resin pail be checked, if lot numbers are different, box together the different lot numbers to ensure a uniform color for topcoat applications.

### **JOINT GUIDELINES**

Refer to the Joint Guidelines for complete details on our website.

### **1. DOUBLE BROADCAST METHOD**

- A. Prepare the surface as outlined in the DUR-A-FLEX Surface Preparation Guide.
- B. Prime surface with appropriate primer and spread rate.
- C. Measure ½ gallon hardener and 1 gallon resin. When combining, be sure to add the hardener first. Add the resin and scrape out the container. Be careful to pour both hardener and resin into the center of the mixing pail. Mix the blended epoxy with a slow speed power drill with a Jiffler mixing blade for 3 minutes. **Always scrape the sides and bottom of the mixing bucket to assure thorough blending.**
- D. Apply a "flood coat" of blended epoxy at approximately 100 Sq Ft per gallon with a 3/16" notched squeegee and back roll with a quality non-shed roller.
- E. Broadcast Flintshot aggregate. Wearing spiked shoes or golf shoes, walk on the wet epoxy holding a 2 gallon container and broadcast the aggregate until the floor appears dry (about 1/2 lb. per Sq Ft). Be sure to keep moving while throwing the aggregate UP into the air so it falls vertically onto the epoxy. Do not rush, as it may take 15 to 30 seconds for the aggregate to be absorbed by the epoxy. **IMPORTANT:** Do not "seed" the edge that will be joining the next section. Be sure to leave "WET EDGE" (a 24" strip "unseeded" to permit overlapping when proceeding onto next section). Do not walk on the aggregate with spiked shoes. Be sure to keep any impurities out of the sand such as broom bristles, debris, etc. Allow to cure.
- F. Sweep off the excess aggregate using a stiff, clean, dry broom with synthetic bristles.
- G. Repeat steps C (mix), D (apply with a flat squeegee) & E (broadcast) again for 1/8" thickness, twice for a 3/16" thickness.
- H. Sweep off the excess aggregate. Sweep or vacuum the floor again.
- I. *See TOPCOAT INSTRUCTIONS below.*

## **2. SLURRY BROADCAST METHOD**

- A. Prepare the surface as outlined in the DUR-A-FLEX Surface Preparation Guide.
- B. Prime surface with appropriate primer and spread rate.
- C. Measure out 1/2-gallon DUR-A-GLAZE #4 hardener and 1 gallon SHOP FLOOR resin. When combining, be sure to add the hardener first. Add the resin and scrape out the container. Be careful to pour both hardener and resin into the center of the mixing pail. Mix the blended epoxy with a slow speed power drill with a Jiffler mixing blade for 3 minutes. **Always scrape the sides and bottom of the mixing bucket to assure thorough blending.**
- D. Add 1/2 gallon of #1/2 Jersey Sand, 1/2 gallon of Flintshot aggregate and 1/2 gallon of #290 flour. Blend thoroughly with drill and Jiffler mixer. Be sure to stir the slurry mix each time immediately before you pour it on the floor, as the sand will settle in the bucket.
- E. Pour out about 1/3 of the slurry and spread with a cement finish trowel. Do not tilt the trowel more than a 45° angle. Use the jersey sand as a guide and let the trowel slide over it. (A loop roller may also be used to help make the slurry more uniform). Allow 5 to 10 minutes for the slurry to level before proceeding to the next step.
- F. Broadcast Flintshot Aggregate. Wearing spiked shoes walk on the wet epoxy holding a 2-gallon container and broadcast the aggregate until the floor appears dry (about 3/4 lb. per Sq Ft). Be sure to keep moving while throwing the aggregate UP into the air so it falls vertically onto the epoxy. Do not rush, as it may take 15 to 30 seconds for the aggregate to be absorbed by the epoxy. **IMPORTANT:** Do not “seed” the edge that will be joining the next section. Be sure to leave this “WET EDGE” (a 24” strip “unseeded” to permit overlapping when proceeding onto next section). Do not walk on the aggregate with spiked shoes. Be sure to keep any impurities out of the sand such as broom bristles, debris, etc. Allow to cure.
- G. Sweep off the excess aggregate with a stiff broom. Sweep or vacuum the floor again.
- H. *See TOPCOAT INSTRUCTIONS below.*

### **TOPCOAT INSTRUCTIONS (Flintshot Only)**

*(1 coat for standard, 2 for orange peel, 3 for smooth)*

*DUR-A-GLAZE #4 WATER CLEAR and REGULAR hardeners are recommended for topcoat applications.*

*NOTE: Do not use “Fast” Hardeners for topcoats as they yellow very quickly and could produce pinholes.*

- A. Measure out 1/2-gallon DUR-A-GLAZE #4 hardener and 1 gallon SHOP FLOOR resin. Follow the same pouring and mixing procedures as described in the broadcast coat. Apply the topcoat with a 12” flat squeegee. Move squeegee in a continuous semi-circular motion from left to right to left, etc. Steady

pressure on squeegee is necessary to obtain a uniform appearance. Do not advance squeegee too rapidly, each semi-circular swing should advance approximately 4 inches. It takes practice to reverse direction of the squeegee movement at the end of each left to right to left stroke. Remove all puddles and ridges before they are out of reach. Start movement of squeegee in a dry area, move onto wet GLAZE and continue to move squeegee until it reaches a dry edge.

- B. Back roll with a quality short nap, non-shed roller.
- C. For multiple topcoats, sand the floor in between topcoats with a floor buffing machine and sanding attachment. Use 3½” closed coat sandpaper.
- D. Sweep or vacuum the floor again and repeat for each topcoat. Apply pigmented Armor Top per Product Data Sheet instructions.

**IMPORTANT:** Be sure to pour the hardener into the mixing bucket first, then the “resin”. Always scrape the sides and bottom of mixing container to assure thorough blending. **USE SIGNS AND BARRIERS** to keep traffic out of the area. Do not allow any water on coated surface for 24-48 hours. Chemical spillage must be prevented for approximately 5 days. **NOTE:** Use DUR-A-SOLVE for clean up.

### **CAUTION**

**Follow the Hazardous Materials Identification System labeling guide for proper personal protective equipment to use when handling this product. Use only as directed. KEEP OUT OF REACH OF CHILDREN.**

### **JOINT GUIDELINES**

Refer to the Joint Guidelines for complete details on our website.

*Before using any DUR-A-FLEX, Inc. product, be sure the Material Safety Data Sheet is read and understood.*