

DHDC-6400(S) Method Statement

[Epoxy Self Leveler(D.F.T. 500 μ m)]

NOROO

General

Information

DHDC-6400(S) is a two part solvent-free epoxy composed of modified amine epoxy resin. It has solid dry film, good adhesion, appearance, durability and chemical resistance. 500 μ m dry film thickness is achievable in a single coat. It is suitable for concrete floors thanks to its excellent self-leveling. The sample which was manufactured by NOROO Paint & Coatings or equivalent needs to be approved by the inspector before use.

Use

Indoor concrete floors

Underground car park, electricity room, machinery room, garage, various factory floors

System

System	Product	D.F.T.	Number of coats	Application method	Colour	Remark
Surface Treatment	Completely remove dust, oil, contaminants and foreign substances from the substrate.					
Primer	Cleanpoxy Primer DNY-200	50 μ m	1 coat	B,R,S	Transparent	To reinforce the substrate and increase adhesion
Topcoat	Cleanpoxy DHDC-6400(S)	500 μ m	1 coat	R,S Squeegee, Trowel	Specified colour	Wear resistance, shock resistance, chemical resistance, good physical properties

* Application method: B → Brush, R → Roller, S → Spray

Surface

Preparation

1. The concrete substrate must be at least 28 days old(21°C). Proper pH value is 7-9. Substrate moisture content must below 6% prior to application.
2. The substrate must be clean, dry and free of all contaminants such as dirt, oil, grease, coatings, etc. Grinding or vacuum blasting is recommended.
3. If concrete densifier is applied on the substrate, check the adhesion before application.
4. After applying primer, fill cracks, blow holes and voids using Epoxy Putty(Noruseal #6600).

How

to

apply

1. Primer

1. After surface preparation, mix Part A & Part B of Cleanpoxy Primer DNY-200 thoroughly by 4:1 weight ratio. Apply a single coat using a brush, a roller or a spray to form 50 μ m dry film thickness.
2. It is required to apply uniformly on the substrate. If the certain area absorbs too much, apply one more priming.

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3. Primer needs to be dried completely before the subsequent coat. If you overcoat before primer has not fully dried, blister or adhesion problem may occur.
4. If the maximum overcoat time has passed, apply primer thinly for adhesion to topcoat.

2. Topcoat

1. After letting primer dry at least 8 hours in 20°C, remove contaminants or foreign matters before topcoating. Mix Part A and Part B of Cleanpoxy DHDC-6400(S) thoroughly by 5:1 weight ratio. Apply a single coat using an airless spray to form 500 μ m dry film thickness. Or calculate the exact paint consumption to obtain 500 μ m on the area then pour the mixture of Part A & Part B on the substrate. Apply topcoat using a squeegee or a roller.
2. DHDC-6400(S) is a solvent-free type thus do not use a thinner. (Poor drying or color separation may occur.)
3. Spray the designated thinner DR-100 thinly to remove air bubbles after applying topcoat.

Precautions

1. Do not apply if temperature is below 5°C. Avoid using early morning due to dew condensation. Need to apply after the dew has dried.
2. If the substrate is damp, blister may occur due to the reaction with water. Please dry the substrate completely. (Concrete substrate moisture content: 6% or below)
3. Screed substrate or high spots must be removed by grinding. Otherwise, poor adhesion and peel-off may occur.
4. Priming is mandatory to fill voids on the substrate and avoid blister and cratering.
5. 2 part paints must be mixed by a proper mixing ratio. Please mix thoroughly for 4-5 minutes using a power disperser.
6. Solvent-based epoxy is designed to form a thin film. If you apply too thick in a single coat, solvents cannot evaporate and the film hardness can be lowered.
7. Eliminate ignition sources (sparks, smoking, flames, hot surfaces) when working with solvent-based paints. Keep the working area well ventilated especially in summer.
8. In winter, delayed curing is expected thus it is a good idea to block cold air. Do not use solvents or thinners as they slow down curing. In cold weather, it is recommended to run a warm air fan.
9. When applying solvent-free epoxies, air bubbles may pop up under below conditions;
when mixing Part A and Part B,
if the substrate is not even and well prepared, or
if it dries too quickly in summer.
In these cases, store paints in a cool and dry place. Spray the designated thinner DR-100 thinly to remove air bubbles.

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Precautions

10. 2 part paints must be used within pot life after mixing Part A and Part B. When the ambient temperature is high, it shortens pot life. Store in a cool and dry place.

- Pot life(20°C): Cleanpoxy Primer DNY-200 → 5 hours

DHDC-6400(S) → 30 minutes

11. DHDC-6400(S) will have fully cured after 7 days at 20°C.

12. When you apply over existing coatings or for other inquiries, please contact to NOROO Paint & Coatings.

