STONHARD

PRODUCT DATA

STONKOTE® 627

PRODUCT DESCRIPTION
Stonkote 627 is a two component, pigmented, solvent-based aliphatic amine adduct cured epoxy enamel. The cured film provides a rough, cleanable, aesthetically pleasing surface which is easily recoatable.

USES
Wall and floor coating in ablution blocks, food processing plants, hospitals and schools. Machine maintenance when normal paint fails.

PRODUCT ADVANTAGES
- Durable protection for concrete or metal surfaces
- Versatile coating for walls and floors
- Good water and chemical resistance
- Standard colours available

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

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	

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

Finish	Gloss
Colour	Refer to Epoxy colour chart
Consistency	Liquid
Volume Solids	40 to 45%
Number of Components	2
Mix Ratio by Volume	4:1 (Base:Activator)
Pot Life	6 to 8 Hours
Apply Over	Primed concrete or steel
Apply By	Brush, roller or air spray
Curing Time	6 Hours – recoat 24 Hours – service 7 Days – full cure
Thinner	Thinner # 10 (not to exceed 5% by volume)
Max Service Temperature	120°C Dry 60°C Wet
Application Temperature Range	16°C to 30°C
VOC Content	500g/l

NOTE: The above physical properties were measure 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.

SHELF LIFE
24 Months if stored between 16°C and 32°C

STORAGE CONDITIONS
Store all components of Stonkote 627 between 16 to 32°C in a dry area. Avoid excessive heat and do not freeze.

APPLICATION

SCOPE OF WORK (BOQ):
Prepare surfaces and apply two coats of Stonkote 627 onto Stonprime 639 primed substrates.

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.

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 mechanical mixer. 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 AND PATCHING:
Apply one or two coats of Stonprime 639 Primer at approximately 6m²/litre with a roller to seal the pores and strengthen the top concrete layer. Allow to cure for 8 to 12 hours before overcoating. If necessary, patch cracks and holes by filling with Pro-Struct 617 Epoxy Paste or, if badly pitted, skim floor surface with a trowel using Stonkote 723. Allow to cure and sand smooth before overcoating.

APPLICATION:
Dependent on wear and chemical resistance properties required, apply 2 or 3 coats of Stonkote 627 Epoxy Enamel Coating at approximately 7m²/litre/coat using a short nap roller, allowing 6 to 12 hours curing between coats.

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 aggressive chemicals should only take place after 5 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.

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