

Processing

- Remove all soiling (ideal is acetone). In particular oils and grease have to be removed thoroughly. Afterwards dry the surface.
- Roughen the surface up to about 100 µ. Sand blasting is ideal.
- Mix resin (component A) and hardener (component B) in the correct mixing ratio as indicated below. Use an electric stirrer and make sure that all zones of the container are stirred.
A homogeneous colour indicates that the process can be finished.
- First apply a thin adhesion layer under pressure. Then add additional material up to the final thickness. The second layer should be applied onto the sticky first layer (at the latest after 5 h).
- In order to increase the wear resistance the last layer should be smoothed under moderate pressure after 2 to 3 h with a roller which has been wetted with a water/surfactant mixture. Please note, that coating of this surface is critical due to delamination. For a reliable adhesion on this layer it has to be cleaned with acetone and grinded.

Processing Modes:

B1SF can only be puttied.

Conditions for Processing:

Minimum temperature:	10°C
Max. humidity:	80 %
Temperature of the surface to be coated:	at least 3°C above dew point
Minimum thickness:	3 mm

Mixing Ratio (by weight):

Resin (component A, putty, grey)	2,5
Hardener (component B, putty, black)	1

Typical quantities:	100 g	250 g	500 g
Resin:	71,4	178,6	357,1
Hardener:	28,6	71,4	142,9

Pot Life (25°C, 100 g):

Ca. 30 min.

Curing at 25°C:

Light mechanical load:	After 20 h
Full mechanical load:	After 48 h
Full chemical resistance:	After 72 h

Coverage:

Coverage of one sqm (thickness: 5 mm) requires 12,5 kg.

Additional Information:

Storage:	Below 35°C; close container thoroughly.
Shelf life:	The material can be stocked in originally closed containers for at least 6 month.
Safety:	Read material safety data sheet prior to use.

The technical data mentioned in this technical data sheet have to be regarded as rough guidelines. They have been obtained in our laboratory under optimal conditions. For the suitability of the product for specific applications we do not take the responsibility and we deny any liability. We recommend to do trials under conditions which reflect the individual practical application prior to the use of the material for the real application.