

METALLIX

100% SOLIDS

METALLIC EPOXY COATING

LEAVE THE ORDINARY BEHIND

APPLICATION INSTRUCTIONS

PATCHING: Patching pits and divots (*optional*), is the first step of the process. Remove loose Aggregate and repair voids. Fill pits and pock marks by using any epoxy-based patching compound, making sure to carefully follow the instructions as directed by the manufacturer of the product. Wait 24 hours for compound to fully cure before etching your concrete.

SURFACE PREPARATION: Concrete Surfaces: All surfaces must be sound, dry, clean and free of oil, grease, dirt, mildew, form release agents, curing compounds, efflorescence, loose and flaking paint and other foreign substances prior to applying your first coating. Remove laitance and roughen unusually slick poured or precast concrete as well any oil, grease, and dirt by using mechanical means (*shot-blasting or diamond grinding*). However, if those options are not available to you, you can etch with acid. *The Original Color Chips Etch n' Clean Solution* has the ability to provide both the cleaning and the profiling (*roughening the surface*) in one operation. Etching the concrete allows the primer coat to adhere securely. Pour onto surface and scrub into the pores of the concrete with a stiff bristle broom after diluting the etching solution with water (*mix 1 gallon of solution with 1 gallon of water*). The acid should only have contact with the concrete for a maximum of 10 minutes. Triple rinse **thoroughly** with water (*power washing is ideal*) and allow to dry a minimum of 8-10 hours. Remove loose aggregate by blower, vacuum, or broom. In the end, your floor should have a texture similar to 100 grit (*or rougher*) sandpaper. Alternatively, Muriatic Acid can be used for additional profiling.

Previously Painted Surfaces: Acid etching is not necessary (*or effective*) when recoating existing paint/ epoxy. Old coatings should be tested for lifting. If lifting occurs, remove the lifted coating. Scuff/ sand glossy areas and aged epoxy coatings. After the floor is dull or has a texture to it, clean with TSP or alternative and apply the basecoat epoxy. You would not need to use the primer/ sealer in this instance.

PRIMING: Using the **Norklad WB** will improve the effectiveness and efficiency of the coating by penetrating and sealing the concrete plus provide an additional bonding agent for your basecoat; improving the longevity of the system. Also, by using a primer for your **Metallix basecoat**, you eliminate the risk of outgassing. Outgassing occurs when the air from underneath the slab rises, tries to move through the wet coating and gets trapped; forming blisters on the surface. By priming the surface with a low-viscosity low solids primer, you seal off the slabs ability to breathe and trap any air escaping into the next coat.

MIXING: The entire contents of each container (*Part A & part B*) must be mixed together. Add the converter portion to the base portion slowly with continued agitation. Once the two components are mixed you have 50-70 minutes to use it. Norklad WB Primer has a low viscosity so usually one gallon will cover about 250 sq/ft when properly rolled out. It should be applied in one evenly in one coat to completely cover and penetrate the surface. The porosity of the substrate will directly affect the finished look of the floor. When applied thin (*or over extremely porous concrete*) it will have more texture. After it has been applied, wait until you can walk on it (*generally 12-18 hours*) before you apply the basecoat. It dries to recoat in 8-10 hours so wait the allotted time before applying the Metallix basecoat. It is best to use ¼" or 3/8" nap roller.

BASECOAT MIXING INSTRUCTIONS: Do not apply over wet surfaces or under very humid conditions where condensation or fog could settle on the coating during the cure process. Once you are ready to coat make sure you have a bucket to mix your epoxy. The entire contents of each container (*Metallix Part A and Metallix Part B Converter*) must be mixed together in a separate container. Mix both Portions by first using an electric mixer to obtain a smooth, homogeneous condition. Then pour Part A into your bucket (*5-gallon bucket preferred*), adding the converter slowly with continued agitation. After the converter add is complete, continue to mix very quickly. The mix ratio of the *Metallix* is 2 parts A to 1 part of B. You want to make sure you thoroughly mix the 2 components together. **Mixed material is usable for 30 minutes** (*while in the bucket*). Once the material is out of the bucket and onto your substrate, it will take much longer for it to tack up. Higher temperatures will reduce the working life of the coating; lower temperatures will increase it. **Recommended Coverage:** 150 Square feet per gallon (*At 10mils thick*) over **primed** concrete when it is squeegee applied.

APPLYING THE BASECOAT: After the material is thoroughly mixed, begin painting in the corner furthest away from the exit of the room. Use a brush to cut in along the walls, use a good quality squeegee to spread material on floor surfaces away from the wall. Pour a small amount of mixed epoxy directly onto the floor within your cut in area. Gently and evenly spread the epoxy with your squeegee across the entire area that has been cut in, leaving any excess material at the leading edge to be utilized in your next section. Gently backroll the entire wet area with a roller (*1/2" nap*) to further promote even coverage. **Dry Time:** At 70°F dries to recoat with epoxy or urethane in 10-16 hours and dry hard in 24 hours.

CLEAN-UP: Clean brushes rollers and equipment with a T-10 Thinner or Xylene. Applying this product in cold climates will not affect the protective properties, however, it will double your drying/curing times.

HELPFUL HINTS: Before beginning the application, keep in mind that Metallix can be applied anywhere from 10mils to 30mils thick. 30mils thick will cover 50 sq/ft. per gallon; at 15mils thick it will cover 100 sq/ft per gallon; at 10mils thick it will cover 150 sq/ft. per gallon, and so on. Please Section off the work area to know exactly how far each gallon needs to go to get the desired effect evenly.

We usually recommend a two to three day process: Day 1: Etch and clean the surface, and apply your primer (*If acid etching, let it dry out overnight before you apply the primer*). Once the primer is ready, (*If you don't have spike shoes wait overnight before applying Metallix*) Once the primer is dry, begin to squeegee and backroll your 100% solids.

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