

Technical Bulletin # 412

Product Description

DecoBlend Flake System is an easily installed, inexpensive, attractive coating system that utilizes a number of the standard IMPAX products in conjunction with multi-colored vinyl flakes. The following application guide outlines some of the options available with this system.

Surface Preparation

Properly prepare all surfaces to be coated in accordance with Surface Preparation Bulletin #400. Note that the method of preparation may influence the coating selection. All substrates should be smooth and free of holes, cracks, gouges or other imperfections prior to applying the DecoBlend Flake system. Consult ITW Resin Technologies' Technical Department for more details.

Sprinkle Broadcast Application

This version of the DecoBlend Flake is intended as an inexpensive thin-film system (typically less than 25 mils).

All products should be applied in accordance with the appropriate technical bulletins. After proper preparation, apply one coat of the IMPAX 700 (color) at a spread rate of 125 square feet per gallon @ 12 mils DFT. Care should be taken during the installation of this coat to insure that all areas are completely covered by the colored coating. If floor is porous because of poor concrete, chemical attack, mechanical preparation or any other reason, two primer coats may be needed. A test area is always recommended to verify that the system will perform as expected. If unable to do a test and any doubt remains, use either two coats of the IMPAX 700 (200 sq. ft./gallon for each coat) or one coat of IMPAX Water Based Epoxy Primer Clear (250 sq. ft./gallon) and one coat of IMPAX 700 (150 sq. ft./gallon). These coverage rates can vary depending on the condition of the concrete, and again a test area is strongly recommended.

After the colored base coat(s) are applied, an applicator using spiked shoes should lightly sprinkle the vinyl flakes into the wet epoxy at a rate of 2 ounces to 10 ounces per 100 square feet. This coverage rate is dependant on personal preference, but should be light enough that there is coating between the flakes, which should not be allowed to "pile up". Flakes can either be broadcast by hand or by using a hand held "seeder". Again, a test area will verify the final appearance.

After the base coat has set up sufficiently to walk on without leaving an impression, apply the finish coat(s). The standard recommendation is for 10 mils (150 sq. ft. / gallon) of the IMPAX 650 Crystal Clear, however more may be applied if necessary or desired. This system is designed with a smooth finish, and if slip resistance is important either the full broadcast version of this system or another IMPAX product should be considered.

If a more abrasion resistant finish is desired, apply one coat of the IMPAX HPU High Performance Urethane (clear) at 3 mils DFT (350 sq.ft./gal) in accordance with Technical Bulletin 457.

Full Broadcast Application

This system is designed as a high build (typically greater than 50 mils) application of the DecoBlend Flake system. It provides for more film thickness and durability than a sprinkle broadcast system, while also allowing for a non-slip finish.

All products should be applied in accordance with the appropriate technical bulletins. After proper preparation, apply one coat of the IMPAX 3300 LV-N High Solids Clear Epoxy Primer 15 mils DFT (100 sq. ft./gal.). Care should be taken to insure that product is applied at sufficient thickness to seal the surface and that some of the film remains above the substrate to accept the flakes. Again, a test is strongly recommended with these systems to verify appearance. If in doubt apply an additional primer coat of the IMPAX 3300 LV-N at 8 mils DFT (200 sq. ft./gallon) and broadcast into the second primer coat only. After priming, proceed with saturation broadcast (approximately 15# per 100 square feet) until the area is completely covered with flakes and no wet spots are evident.

After the primer has set sufficiently to walk on, sweep and vacuum loose flakes, lightly pole sand the finish to remove any peaks or other imperfections and vacuum again. The area should then be finished with IMPAX 650 Crystal Clear applied at 15-25 mils DFT

(60-100 sq.ft./gal). This will provide for a non-slip texture, but if a smooth finish is required apply another coat of the IMPAX 650 Crystal Clear after lightly sanding to remove any remaining imperfections.

Again, if a more abrasion resistant finish is desired, apply one finish coat of the IMPAX HPU High Performance Urethane Clear at 3 mils DFT (350 sq.ft./gal.) in accordance with Technical Bulletin 450.

After the final coat allow the area to cure 24 hours for foot traffic, 72 hours for full service and 5 days for full chemical cure (@72°F, 50%RH).

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