



Application process for ASPART-X *Splash Accent* (*Splatter Texture*)

The **ASPART-X splash accent texture application** is intended for use as an industrial floor coating, providing an impact and chemical resistant flooring that is visually pleasing.

The coating is applied in 3 separate applications.

1. A "**prime coat**" is applied at 8 mils wet film.
2. The "**splash accent**" is applied in a color by color application that will be specific by the number of colors to be added.
3. The "**top coat**" is applied in *clear, non-skid* at 2 mils wet film.

The following is a step by step guide to applying the **ASPART-X Floor Coating**.

Equipment required

- A 110 volt EDOC grinder with 6 diamond heads is recommended. The grinder needs to be rated for the size of the surface area to be coated.
- Pulse back vacuum - To control dust from both the floor grinder and hand-grinders
- Hand-held grinder – Must have dust collection attachment
- Crack Chaser

Note: Ensure you have the proper size mandrel, (ie. ¼", 3/8", or ½") for the hand-held grinder being utilized.

Preparation of substrate

- Clear area to be coated of **ALL** debris and **ALL** items that will not be coated.
- Sweep or blow off entire area to be coated
- Locate all control/expansion joints (useful in dividing floor into zones)
- Identify any potential areas of contamination that may need to be cleaned; oil spills may require emulsification prior to application of base coat.
- Determine what imperfections exist in floor such as cracks, broken concrete or spalls.
- Grind all imperfections to expose a suitable base for repair
- Use crack filler to repair all imperfections
- Allow crack filler to cure for 45–50 minutes*

* refer to "**crack and joint repair**" section

Surface grinding

- Grind entire concrete surface with a diamond floor grinder. Remove enough surface to expose virgin concrete, with no old surface remaining. (Make sure a pulse back vacuum is used to control the concrete dust.)

- Hand-grind all areas that cannot be accessed by the floor grinder. All surfaces to be coated must be ground, exposing a fresh surface.
- Blow or vacuum entire surface to be coated, leaving no loose material behind**

****Refer to “surface preparation for concrete” section for more details**

Items needed to apply ASPART-X FLOOR COATING

- **ASPART-X IC 320** pigmented- **“Prime Coat”**
Prime Coat is applied @ 8 mils wet film; 1 mixed gallon of **ASPART-X IC 320** will cover 170*** sq. ft.
 - **ASPART-X IC 320** - **“Splatter Coat”**
Splatter coat is applied in drop sizes ranging from 5-10 mils; 16 oz of **ASPART-X IC 320 Splatter Color** will cover 700 sq. ft.
 - **ASPART-X IC 320** clear, non-skid **“Top Coat”**
Top Coat is applied @ 2 mils wet film; 1 mixed gallon of **ASPART-X IC 320** will cover 754*** sq. ft.
*****A reduction of 15% has been subtracted from theoretical coverage rates to account for roller absorption and excess product left in roller trays and container.**
- Graduated mixing cups
 - Pour lids
 - Stir sticks
 - Wet mil gauge
 - Rollers - 18”, with 3/8” nap of shed resistant synthetic or lambs wool, with a phenolic resin core. Always count on having at least 1 new roller for each coat (more is better).
 - Extendable roller handles capable of extending 10-20 ft.
 - Roller trays - must be deep trough /high capacity
 - H.V.L.P. gun with 2 Qt. pressure pot and 2.0 tip
 - 5 ft. hose for spray gun
 - Duct tape
 - Masking tape
 - Plastic sheeting
 - Razor knife
 - Leaf blower
 - 5-gallon buckets (minimum quantity of 2, quantity depends on size of job)
 - Spiked shoes
 - Safety gear - Nitro gloves, eye protection, long-sleeve shirt, 3M approved respirator

Mixing ASPART-X IC 320

- **ASPART-X IC 320** is a 1:1 mix ratio
 - i.* Always pre-mix “B”(resin side) prior to mixing with “A”

- ii. Mix equal parts of part A to part B into a graduated mixing cup. (Mix only enough product that can be used in a 20-25 minute window.)
- iii. Stir product to a smooth consistency

Pot life of **ASPART-X IC 320** is approximately 30-40 minutes (pot life is calculated at 70° ambient temperature). Humidity will greatly decrease pot life, as **ASPART-X IC 320** is a moisture cure product

Application process

- **Prime coat- pigmented**

- i. Mix **ASPART-X IC 320** base coat in a large mixing container, refer to coverage chart for 8 mil coat
- ii. Pour ribbons of **ASPART-X IC 320** on the floor and squeegee evenly to 8 mil wet coat
- iii. Roll in a back-and-forth direction, opposite to that of the squeegee, to achieve an even coating. Remember, the product is in the process of polymerizing and you need to move at a swift pace.
- iv. Back-roll in 1 direction to insure that no roller marks are present
- v. Let this coat stand for 1-2hrs
- vi. When coating is dry inspect for any contamination****
**** refer to "substrate repair section for specific contamination repairs"

- **ASPART-X Splatter texture application**

The **ASPART-X Splatter texture** is achieved by mixing small amounts of specifically pigmented **ASPART-X IC 320**, usually 8-16 oz. Begin by determining how many colors you will need (most applications will incorporate 3-4 colors) you will apply **Splatter texture** with your HVLP gun.

- Turn the fluid pressure to approx. 20 PSI on the pressure pot, and the air at the gun to approximately 5 PSI. This gives a nice, consistent droplet/texture. The air pressure on gun will determine the size of the droplets. Clean gun with Xylene immediately after using.

- **ASPART-X IC 320 Primary color**

- i. Mix **ASPART-X IC 320 Primary color** in a mixing container, refer to coverage chart for 5-10 mil coat
- ii. Fill pressure pot with **ASPART-X IC 320** primary color*
- iii. Adjust fluid pressure on pot to approx. 20 PSI
- iv. Adjust air pressure on gun to approximately 5 PSI for desired drop size
- v. Adjust spray pattern to close to a full fan
- vi. Start in the furthest back corner, sweeping from left to right as you continue to walk your way off surface
- vii. Texture should be applied at a 15% coverage rate per color

- **ASPART-X IC 320 Secondary color**
 - i. You will now need to be on spiked shoes, as you will be finishing this process on wet product
 - ii. Repeat steps in primary color application with subsequent colors until the desired look is achieved
 - *Splatter texture can be applied wet on wet, or let texture dry between coats for a more distinguished droplet*
 - iii. Let floor cure for 1 hr.
 - *Clean gun between coats to stop the polymerization of wet product in gun and pot*
- **Top coat**
 - i. Mix non-skid clear ASPART-X in container and pour in tray – mix regularly, making sure microspheres don't settle.
 - ii. Apply at 2 mil - refer to coverage chart for 2 mil coat
 - iii. Finish by back-rolling. To avoid roller marks, you must finish with 1 complete back-roll in same direction over the entire floor. Tape off or tag all areas with "**Do Not Enter Warnings**" to protect your work area.

Cure time

- 4-hrs for light foot traffic
- 24-hrs for return to service work loads

Clean-up

- Clean up all tools with MEK or Xylene
- Dispose of all used rollers
- Allow roller trays, mixing cups and 5-gallon buckets stand for 24 hrs. The dry product can then be peeled away, and items can be used again.
- Remove all masking within 4-6 hours of final coat
- Make sure work area is clean of all trash or debris.