



Please review entire contents of the application instructions before beginning your project.

PATCHING: Patching pits and divots is the first step of the process. Remove loose aggregate and repair voids.



Application of concrete patch to fill pits and cracks

Fill pits and pock marks by using any patching compound (such as Norcrete Crack Filler), 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 or grinding your concrete. **WARNING:** if you do not patch your concrete surface prior to applying the Pure Metallic System you run the risk of seeing the imperfections through the coating. With Pure Metallic Epoxy, the imperfections show up much more prevalent than with standard epoxy floor coatings.

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. The floor should be as level as possible. Remove laitance and roughen unusually slick poured or precast concrete as well any oil, grease, and dirt by using mechanical means (diamond grinding is preferred).



Diamond Grinder with 30-grit heads

SURFACE PREPARATION CONT.

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.

Begin by diluting the etching solution with water (mix 1 gallon of solution with 1 gallon of water). Pour onto surface and scrub into the pores of the concrete with a stiff bristle broom.



Scrubbing Acid Wash into substrate

Scrubbing in acid with stiff bristle broom

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 10-12 hours. Remove loose aggregate by blower, vacuum, or broom. In the end, your floor should have a texture similar to 80 grit (or rougher) sandpaper. Alternatively, Muriatic Acid can be used for additional profiling. (see website for tutorial)

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 primercoat epoxy (Norklad WB).

PRIMING: Using **Norklad WB** as a primer will improve the effectiveness and efficiency of the coating by penetrating and sealing the concrete plus provide an additional colored bonding agent for your **Pure Metallic** basecoat; improving the longevity of the system. Also, by using a primer for your **Pure Metallic basecoat**, you reduce 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.

PRIMER CONT.

It should be applied in one even 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. Wait until you can walk on it (generally 7-10 hours) before you apply the Pure Metallic basecoat / effects.

The colored primercoat must be **completely** dry before applying the Pure Metallic basecoat. Thickness and cooler surface temperatures can extend the curing process. It is best to use 1/4" or 3/8" nap roller and Lint-Free or Shed Resistant. Once you are ready to apply Basecoat and Effects, create a mixing station and open all of your cans to make sure you can quickly mix and pour once the process has started.

PURE METALLIC BASECOAT EPOXY MIXING/APPLICATION:

Before you start the basecoat process, create a mixing station where your cans of basecoat and effects can be mixed. Put down a dropcloth and open all the cans. Once the basecoat / effects process has started you will want to be able to mix and apply as quickly as possible. Also, it is recommended to measure out 200 square foot sections on your floor so you know where to start and stop with each basecoat kit. You can use markings with chalk on the primer coat to indicate this. **MIXING:** It is a good idea to mix the Part A portion of the Pure Metallic basecoat kits separately before administering the Part B to the container. This will help suspend any pigment that has settled to the bottom of the can during shipment and storage. Once the Part A portion of the material has been thoroughly mixed, you may now add the Part B component to the Part A container. Using a paint stir stick vigorously stir the material together creating a smooth consistency (Note: Most pigments create a swirl pattern in the material even after it is completely mixed) You don't want to see any clear streaks in the mixed material. Make sure you scrape the bottom and the sides of the container to ensure no pigment is left in the container.

The rest of the process requires spike shoes; do not continue if you do not have spike shoes. Do not apply over wet surfaces or under very humid conditions where condensation or fog could settle on the coating during the cure process.

APPLYING THE BASECOAT: (put on your spike shoes) After the material is thoroughly mixed, begin painting in the corner furthest away from the exit of the room. Pour a small amount of mixed epoxy in thin ribbons directly onto the floor within your cut in area.

Since Pure Metallic epoxy has a 30 minute pot life, and it may take you longer than that to "cut.in" around the edges of the floor, we recommend having at least 3 people to assist with all aspects of the Pure Metallic application. 1 person to mix material, 1 person to roll out the basecoat and cut in, and 1 person to apply the effects. Mix part A and B together thoroughly. (Mix Ratio 2 parts A, to 1 part B) Remember: **Once mixed, you must get the material out of the can in 30 minutes or less, otherwise it will harden.** We recommend pouring out a small portion of the basecoat kit around the edges of the 200 square foot section you will be covering, and then pour the rest of the material on to the floor in ribbons making sure not to pour it outside of the 200 sq/ft section you will be coating. Once the material is out of the can completely you can have 1 person start cutting in around the edges.

Cutting in using a chip brush



Dispensing the basecoat onto the floor in ribbons.

If you are using a roller to apply the Pure Metallic basecoat, you will need to roll fairly aggressively to move the material around. After the basecoat has been evenly dispersed, gently backroll the entire wet area with your roller (3/8" nap) in one direction to further promote even coverage.



Optional: Spreading the basecoat onto primed surface using straight squeegee.

Once the material is out of the bucket and onto your substrate, it will take much longer for it to tack up (possibly up to an hour depending on surface temp and air temp). Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

For best results you want to apply the effects immediately after the section is rolled out.



Backrolling in one direction after material is spread out.

Using multiple Pure Metallic effect colors can give your floor even more variation. You have a maximum of 8 minutes after your basecoat has been applied to use the effects. So you want to act fast otherwise the effects won't spread as evenly. Again, for best results apply effects as quickly as possible after the basecoat has been applied.

PURE METALLIC

METALLIC EPOXY FLOOR SYSTEMS



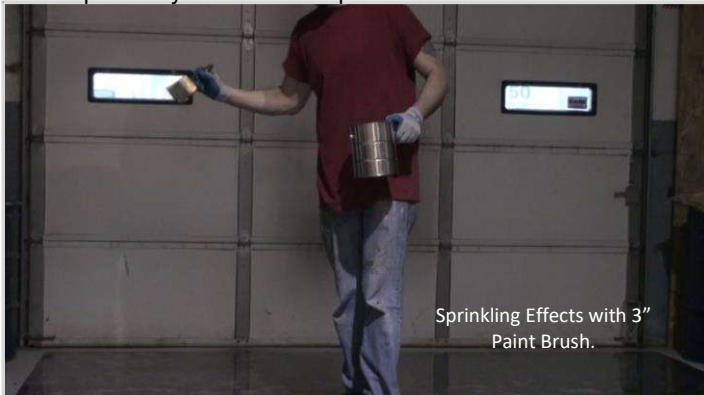
Mixing Part A and B of the Effects kits together.



APPLYING PURE METALLIC EFFECTS IMMEDIATELY AFTER ROLLING BASECOAT:

The entire contents of each container (Pure Metallic Effects Part A and Pure Metallic Effects Part B Converter) must be mixed together (equals one quart). (2 to 1 mix ratio). You can mix these together by hand, thoroughly. **It's easiest to pour the Part A and Part B into a container that is bigger than 1-qt to make mixing and dispersing easier.** Once that is finished, walk upon the wet Pure Metallic basecoat with your spike shoes and apply the effect. The Pure Metallic effects are applied by saturating a paint brush with the effects and gently sprinkling the effects off the paint brush bristle side down. This will leave drops and splatters of different sizes depending on brush size and saturation of the brush. Apply as heavy as possible. (100-150 sq/ft of area per 1-qt effects kit).

We recommend keeping the drops of effects as close together as possible. Overlapping of effects gives the floor a much more appealing and dramatic look. Over the next few hours the effects will morph over your area and spread.



Sprinkling Effects with 3" Paint Brush.

Once your whole floor is complete, walk back and forth throughout the full length of your area dispersing effects where you see fit.



OPTIONAL CLEARCOAT: You can Clearcoat the floor after the effects have been put down for additional protection and depth. You can Clearcoat with 100% solids epoxy clear (Norklad 100) or Urethane (HWU 420 Urethane), depending on your application. Whatever product you decide to use it is VERY important that the coating has completely cured. After the effects go down, check the floor after 14 hours. Do not attempt before 14 hours. If the effects portion seem hard (not soft), then you can Clearcoat the floor. If they are still soft, wait until they fully harden. The effects will take longer to dry than the rest of the floor so please be patient. You do NOT want to Clearcoat the floor if the effects aren't properly cured, it can cause solvent entrapment and never cure properly. **Do not exceed 24 hours before clearcoating the floor.** Refer to the instructions with the clear for application instructions.

FLOORSHINE / NEUTRAL PH CLEANER:

After the basecoat / effects have cured for at least 24 hours, it is safe to apply the **Floorshine**. The Floorshine wax is a 25% solids copolymer finish that will provide a uniform finish to your floor, additional protection and more non-slip. Apply a thin uniform coat of finish to floor with new mop. Allow to dry approximately 30 minutes. We recommend applying 3 - 4 uniform coats in this manner. Never pour left over finish back into the container to avoid contamination. Coverage: 2,000 - 2,500 sq. ft per gallon. Using any product that does not have a neutral pH will break down floor finish. Eliminate the high cost of re-waxing by using the right floor cleaner: **Lemon Damp Mop** A super concentrated lemon scented neutral cleaner. Especially designed to clean acrylic floor finishes, marble and granite. This no rinse cleaner can be used to clean any surface that is not harmed by water.

CLEAN-UP: The Primer Coat (if using Norklad WB) is waterbased therefore you can clean brushes, etc with soap and water. The Pure Metallic Basecoat, and Effects are epoxy and can be cleaned away using Solvent. Clean brushes rollers and equipment with Xylene or solvent.

HELPFUL HINTS: Before beginning the application, keep in mind that the Basecoat is made from 100% Solids Epoxy. 100% solids epoxy 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 and so on; We recommend spreading it thinner so the effects don't get swallowed up, therefore once the material is on the floor spread it out to cover the area sufficiently. 200 sq/ft per .75 gal kit. Please Section off the work area to know exactly how far each gallon needs to go to get the desired effect evenly (visually or chalk lines). You can substitute your own primer (as long as it's colored similarly to the Pure Metallic Basecoat, or clear coat. And deglossed prior to applying Pure Metallic basecoat)

We usually recommend a three-four 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 dry (wait overnight), begin to apply the basecoat and effects. Then wait 12-24 hours after that to apply Clear Coat.