

Archco-Rigidon System 623D is normally applied to suitably prepared and primed steel or concrete substrates.

The silica filled base coat is applied by trowel to a nominal thickness of 1.5mm and is immediately followed by a laminate consisting of a chemically resistant resin combined with two layers of 450g/m² chopped strand mat. A surface tissue is applied over the laminate and is followed, after curing, with a waxed resin top coat.

Preparation and Application of the Base Coat

Thoroughly mix the uncatalysed **623D** resin using a mechanical whip. The material should then be catalysed according to quantity and ambient conditions (see Doc. Ref. 32A/C3). As a general rule use 1% to 2% catalyst when applying at temperatures between 10°C & 20°C. Ensure the two components are fully mixed using a mechanical whip.

Note Use of less than 1% catalyst will not produce a full cure of the coating material. Inadequate mixing will lead to areas of unsatisfactory cure.

Add the FS1 Filler to the catalysed base coat resin in a 2:1 Filler/resin ratio. Fully blend in the filler powder with a mechanical whip. Never mix more material than can be applied within the stated pot life. The filler/liquid ratio may vary slightly with temperature.

The filler base coat should be trowelled onto the substrate with a plastering trowel in strips approx. 1.2 metres wide.

Preparation and Application of the Laminate

Thoroughly mix the uncatalysed laminating resin using a mechanical whip. The material should then be catalysed according to ambient conditions (see Doc. Ref.32A/C3). Ensure the two components are fully mixed using a mechanical whip prior to application. Cut 2 strips of 450g/m² CSM and 1 strip of Surface Tissue of sufficient size to overlay onto the base coat, the base coat should extend beyond the edges of the CSM & tissue approx.50 mm.

Apply the first layer of CSM directly to the base coat while it is still wet and roll with a metal ribbed roller - this will ensure a good bond between the base coat and laminate. Wet out the CSM with catalysed resin and roll out to expel any air entrapment. The second layer of CSM is applied in a similar manner, as is the subsequent layer of Surface Tissue. When consecutive areas are coated the laminate must overlap the adjacent newly applied lining, having an overlap of 50 mm at each joint.

Application of the Waxed Top Coat

The uncatalysed Wax Top Coat should be thoroughly mixed using a mechanical whip. Again catalyse according to ambient conditions and mix thoroughly. Use a minimum of 1.5% catalyst. Apply the waxed top coat in a thin film by brush or roller. Application of this top coat should not be carried out until the laminated lining has cured sufficiently (approx. 6 hrs)

System 623D	
Application Method	Trowel and hand lay up.
Catalyst Type	Archco-Rigidon C3
Volume Solids	N/A
Specific Gravity	1.2
Dry Film Thickness	Approx.3 mm
Practical Spreading Rate	Refer to relevant Data Sheet Doc. Ref. 21A/623D
Tool Cleaning Solvent	Archco-Rigidon T2
Max Humidity during Application	90% Rh
Min Substrate Temperature	10°C
Min Dewpoint/Substrate Differential	Dewpoint +3°C
Preferred Equipment	Trowel, Brush & Roller
Pot Life	40-60 mins
Dilution	N/A
Shelf Life	6 months
Storage Temperature Limits	10°C-20°C
Flash Point	31°C
Ventilation	Do not use in confined spaces without adequate ventilation or breathing equipment
Lighting – Heating in an Enclosed Environment	Use only BASEEFA Zone 1 E Ex d IIA T1 or better

Notes

Pay particular attention to the stated pot life of the material (see material package labelling). Clean down tools & equipment with **Archco-Rigidon T2 Cleaner** within this specified time. Great care must be taken to avoid contaminating the coating material with **T2 Cleaner** as this can have adverse effects on the cure of the material.