

**Archco-Rigidon 701 ESR** is normally applied to suitably prepared and primed substrates.

The silica filled base coat is applied by trowel at a nominal thickness of 1.5mm and is immediately followed by a single layer of woven glass cloth, which is saturated with 701 ESR, resin and hardener, mixed in the correct proportion.

Once the base coat and saturant have hardened a further silica filled coat is applied by trowel also at 1.5mm thickness.

### Preparation and Application of the Base Coat

Thoroughly mix the resin for the base coat using a mechanical whip. The material should then be mixed with the hardener in the proportion of 1.85 parts of resin to 1 part of hardener. Ensure that the components are fully mixed using a mechanical whip.

Add the FS1 Filler to the resin and hardener mix in a 2:1 filler/liquid ratio. Fully blend in the filler powder with a mechanical whip.

The filler/liquid ratio may vary slightly with temperature.

Never mix more material than can be applied within the stated pot life.

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

### Application of Reinforcement

Whilst the base coat is still soft inbed one layer of woven glass cloth.

Wet out the woven glass cloth with resin and hardener mixed (no filler) using a brush or short napped paint roller.

Ensure that there are no dry spots, but do not flood with resin.

Overlap the edges of the glass cloth by approx. 50mm. Immediately the saturant has started to harden but whilst still tacky apply the top coat.

### Preparation and Application of the Final Coat

Mix the top coat in the same manner and in the same proportions as the base coat.

The material should then be applied by plastering trowel.

Using a soft bristle brush (or short napped paint roller) dampened with Archco-Rigidon E20 Rolling Aid, brush or roll out trowel marks. (Do not use excessive amounts of Rolling Aid).

### Notes

Pay particular attention to the stated pot life of the material (see material package labelling). Clean down tools & equipment with Archco-Rigidon E2 Cleaner within the specified time.

Great care must be taken to avoid contaminating the coating material with E2 Cleaner as this can have adverse effects on the cure of the material.

System 701 ESR	
Application Method	Trowel and hand lay up.
Hardener Type	Amine
Volume Solids	100%
Specific Gravity	1.2
Dry Film Thickness	3 to 4mm
Theoretical Spreading Rate	Refer to relevant Data Sheet
Practical Spreading Rate	Doc. Ref. 21A/701 ESR
Overcoating Time	Min 6hrs-Max 15hrs at 25°C
Tool Cleaning Solvent	Archco-Rigidon E2
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	45-60 minutes at 25°C
Dilution	N/A
Shelf Life	12 months
Storage Temperature Limits	10°C - 20°C
Flash Point	98°C
Ventilation	Do not use in confined spaces without adequate ventilation or breathing equipment

### Please Note

The 2 to 1 filler/resin ratio is a practical guide but will vary slightly with temperature i.e. at low temperatures less filler will be needed to produce a good trowelable consistency, at high temperatures more filler will be needed.