

Archco-Rigidon 723D is normally applied to suitably prepared and primed concrete substrates.

The silica filled base coat is applied by trowel to a nominal thickness of 1.5mm and is immediately followed by a single layer of woven glass cloth 'G' which is saturated with resin. 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 uncatalysed resin for the base coat using a mechanical whip. The material should then be catalysed according to quantity and ambient temperature (see Doc. Ref. 32A/C3). As a general rule use 1 to 2% catalyst when applying at temperatures between 10°C and 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. The filler/resin 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 'G'. Wet out the woven glass cloth 'G' with catalysed **723D resin** (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 'G' 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 P21 Rolling Aid**, brush or roller out trowel marks. (Do not use excessive amount of Rolling Aid).

Notes

Pay particular attention to the stated pot life of the material (see material package labelling). Clean down tools and 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.

System 723D	
Application Method	Trowel and hand lay up
Catalyst Type	Archco-Rigidon C3
Volume Solids	N/A
Specific Gravity	1.2
Dry Film Thickness	3 to 4mm
Theoretical Spreading Rate	Refer to relevant Data Sheet Doc. Ref. 21A/723D
Practical Spreading Rate	
Overcoating Times	Min 6 hrs-Max 7 days
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 and Roller
Pot Life	40 mins-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

Please Note

The 2:1 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.