

# Epoxy Application Tips

## **Mixing / Strategy**      Norklad 200 or 100 (100% Solids Epoxy)

As with most application tasks, your strategy for batch sizes is dependent on the size of the job and the number of installers on hand. With epoxy, 1 installer can mix 150 sq/ft at a time, (1 gal of Part A to .5 gal of Part B), 2 installers can mix and coat up to 500 sq/ft at a time (beginners should do 1 batch of 1.5 gallons and work up to 3 eventually). 3 installers can do 500-800 sq/ft at a time, and you can add 300-400 sq/ft more for every additional installer – again, this is for how much area can be covered with a single mix batch. If you only have 2 and you have 2000 sq/ft, you'd mix 4 or 5 batches. If you have 5 or more you may do that same 2000 sq/ft in 2 mix batches.

For this example, we'll assume a crew of 3 coating 1500 sq/ft with 3 mix batches. **Don't begin mixing until you are ready to begin coating, there must be no delay** between mixing and pouring epoxy onto your first batch area. Mix 3 gallons of Epoxy (2 gallons of Part A and 1 gallon of Part B) for two minutes with a paddle mixer. Mix at medium speed and ensure the paddle doesn't draw air into the mix unnecessarily...some bubbles should be expected, but you don't want to whip air into the epoxy. Pour the mixed gallons from the container into another after two minutes and mix for 30 more seconds....this ensures a complete mix. If you just poured 1 gallon of B into a pail of 2 gallons of A, mixed for two minutes and poured directly onto the floor, you'll still have a higher concentration of A around the sides of your mix pail. Pouring your mix into a new pail causes the residual part A on the edge of the original pail to be poured into the center of the second container, additional mixing gives you a complete mix.

**Application**      DO NOT WAIT TO DUMP OUT THE EPOXY ONTO THE FLOOR – IT MUST BE DONE IMMEDIATELY AFTER MIXING. LEAVING MIXED EPOXY IN THE PAIL EVEN ONE OR TWO MINUTES AFTER MIXING CAN CAUSE THE CURING REACTION TO CATALYZE AND CUT YOUR USABLE TIME IN HALF....OR TO NOTHING AT ALL VERY QUICKLY

**Establish Your Boundaries**      At this point it's time to determine the boundaries of the first 150 sq/ft to be coated. This can be achieved by measuring out 150 sq/ft and marking it off with chalk. Continue to mark off your 150 sq/ft sections to be covered until all of your area is completely mapped. Open up all your cans to make sure you are ready to mix. At this point, you are ready to put on your spike shoes. Starting with your first batch, dump out the 1.5 gallons of mixed epoxy onto the floor in a 1-2 inch bead. Start along the edge and continue pouring progressively smaller concentric circles towards the middle of the area. Immediately have one or two guys edging the epoxy with a brush along the first two inches next to walls or objects. Use a squeegee to mil out the material – don't be concerned with precise material placement while squeegeeing – your goal is to get 100% of the 150 sq/ft covered in epoxy. Squeegee back and forth across the area in a snake pattern – don't pull the epoxy past the first 150 sq/ft. Instead of cutting in with a small brush, you can use your squeegee to push the material to the wall to save time. Immediately back roll slowly one roller width at a time (if you have multiple people: once one of your edgers have finished, they can start back rolling while you are still squeegeeing) across the floor, and have a second guy grab a roller (1/4" or 3/8" Lint Free Nap) and begin rolling one width at a time perpendicular to the direction you are rolling so the area gets back rolled once in each direction. Have your third guy start mixing the second batch when you are within 3 minutes of completing back rolling so you're pouring the second mix batch out in the adjacent area immediately. Don't be afraid to back roll numerous times. You have 45 minutes of good working time for each batch, so you can back roll and come back 20 minutes after you first placed and back roll again if need be.

**Notes:** Roller marks caused by excess epoxy along the side of the roller will lay down on their own. 100% solids epoxy is self-leveling, so if put down at the proper mil thickness it will level out like glass. 100 sq/ft per gallon put down at 16 mils is thick as you want to go. If the epoxy is too thin in any area, it will have a difficult time leveling out smooth. Your chances of fish-eyes or orange peel effect increase with thinner mil applications, and you'll find yourself doing an additional coat(s) to achieve a perfect floor. 100 sq/ft per gallon is ideal if you want a glass smooth floor with one application. **Recoat Times:** 100% solids epoxy becomes so hard, glossy and smooth that if you plan on recoating (*ie; applying a clearcoat, etc*) you must do it within 24 hours, otherwise you will have to degloss and wipe with solvent. We recommend checking on it around the 14 hour mark to see if it is safe to walk on. Once it is safe to walk on you are able to start your next coat.