

Application Guide



Jotafloor Coating

Product description

This is a two component amine cured solvent free epoxy coating. It is a high performance product. It is a self smoothing, easy to apply product, leaving a seamless surface. It has excellent chemical, abrasion and impact resistance. If slip resistance is required Jotafloor Non Slip can be used in the system. To be used as finish coat in atmospheric environments. Suitable on approved primers on concrete substrates.

Scope

The Application Guide offers product details and recommended practices for the use of this product.

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

Referred standards

Reference is generally made to ISO Standards. When using standards from other regions it is recommended to reference only one corresponding standard for the substrate being treated.

Application

The following restrictions must be observed:

- Only apply the coating when the substrate temperature is at least 3°C above the dew point
- Do not apply the coating if the substrate is wet or likely to become wet
- Do not apply the coating if the weather is clearly deteriorating or unfavourable for application or curing
- Do not apply the coating in high wind conditions

Product mixing

Product mixing ratio (by volume)

NO PART MIXING. Use a slow speed drill and mixing paddle. Pour the full contents of the mixed material onto the floor immediately after mixing is completed.

Jotafloor Coating Comp A	2	part(s)
Jotafloor Coating Comp B (20)	1	part(s)
Jotafloor Coating Comp A	2	part(s)
Jotafloor Coating Comp B (40)	1	part(s)

Induction time and Pot life

Paint temperature	23 °C
Jotafloor Coating Comp B (20)	
Pot life	10 min

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Jotafloor Coating Comp B (40)

Pot life

20 min

Jotafloor Coating Comp B (20) - 30 min. after poured on to the floor.

Jotafloor Coating Comp B (40) - 45 min. after poured on to the floor.

The temperature of base and curing agent is recommended to be 18 °C or higher when the paint is mixed.

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

Application data

Other application tools

Brush application

After the JF Sealer application, when cured, apply a scraper coat in order to fill all imperfections, and to some degree level out the smaller valley and to further improve on the sealer effect to avoid bubbles. Airless spray unit

Roller application

After the JF Sealer application, when cured, apply a scraper coat in order to fill all imperfections, and to some degree level out the smaller valley and to further improve on the sealer effect to avoid bubbles. Brush application for small areas only.

Application with trowel

After the JF Sealer application, when cured, apply a scraper coat in order to fill all imperfections, and to some degree level out the smaller valley and to further improve on the sealer effect to avoid bubbles. Apply the JF Coating in a systematic way by concentrating on square by square. Make two or three parallel stripes, then spread that paint all over the selected square by cross rolling.

Application with other tools

After the JF Sealer application, when cured, apply a scraper coat in order to fill all imperfections, and to some degree level out the smaller valley and to further improve on the sealer effect to avoid bubbles. Use a steel trowel where there are adjustable pins or wheels at both ends of the trowel, adjust the specified WFT=DFT. One team is pouring out the ready mixed JF Coating, next team doing the spreading, moving the JF Coating in one direction but length by length.

Recommended film thickness per coat

Film thickness and spreading rate	Dry film thickness	Wet film thickness	Theoretical spreading rate
	(μm)		(m^2/l)
Minimum	200	200	5
Maximum	500	500	2
Typical	300	300	3,3

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Ventilation

Sufficient ventilation is very important to ensure proper drying/curing of the film.

Drying and Curing time

Substrate temperature	15 °C	23 °C	40 °C
Jotafloor Coating Comp B (20)			
Surface (touch) dry	6 h	3 h	2 h
Walk-on-dry	24 h	15 h	6 h
Dried to over coat, minimum	24 h	15 h	6 h
Dried to over coat, maximum, atmospheric	72 h	48 h	30 h
Dried/cured for service	10 d	7 d	3 d
Jotafloor Coating Comp B (40)			
Surface (touch) dry	8 h	5 h	2 h
Walk-on-dry	32 h	20 h	8 h
Dried to over coat, minimum	32 h	20 h	8 h
Dried to over coat, maximum, atmospheric	96 h	72 h	36 h
Dried/cured for service	12 d	9 d	3 d

Drying and curing times are determined under controlled temperatures and relative humidity below 85%, and within the DFT range of the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness. Dry sand sprinkled on the surface can be brushed off without sticking to or causing damage to the surface.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dried to over coat, minimum: The shortest time allowed before the next coat can be applied.

Dried to over coat, maximum, atmospheric: The longest time allowed before the next coat can be applied without any surface preparation.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

Maximum over coating intervals for atmospheric exposure

Substrate temperature	15 °C	23 °C	40 °C
Jotafloor Coating Comp B (20)			
Itself	4 d	3 d	1.5 d
epoxy	4 d	3 d	1.5 d
polyurethane	4 d	3 d	1.5 d
Jotafloor Coating Comp B (40)			

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Itself	4 d	3 d	1.5 d
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Other conditions that can affect drying / curing / over coating

Adding anti-skid to the coating system

Anti skid should only be added in the final coat and not used in a single coat system direct to the surface. Spread the Jotafloor Non-slip Aggregate on the surface before half of time to Surface dry. The recommended usage is 2.5 - 3.3 kg per 10 litres of paint.

Repair of coating system

Damages to the coating layers:

Prepare the area through sandpapering or grinding, followed by thorough washing. When the surface is dry the coating may be over coated by itself or by another product, ref. original specification.

Always observe the maximum over coating intervals. If the maximum over coating interval is exceeded the surface should be carefully roughened in order to ensure good intercoat adhesion. Damages exposing bare substrate:

Remove all rust, loose paint, grease or other contaminants by spot abrasive blasting, mechanical grinding, water and/or solvent washing. Feather edges and roughen the overlap zone of surrounding intact coating. Apply the coating system specified for repair.

Quality assurance

The following information is the minimum recommended. The specification may have additional requirements.

- Confirm all welding and other metal work, whether internal or external to the tank, has been completed before commencing pre-treatment and surface preparation of the substrate
- Confirm installed ventilation is balanced and has the capacity to deliver and maintain the RAQ
- Confirm the required surface preparation standard has been achieved and is held prior to coating application
- Confirm that the climatic conditions are within recommendation in the AG and held during the application
- Confirm the required number of stripe coats have been applied
- Confirm each coat meets the DFT requirements of the specification
- Confirm the coating has not been adversely affected by rain or any other agency during curing
- Observe adequate coverage has been achieved on corners, crevices, edges and surfaces where the spray gun cannot be positioned so that its spray impinges on the surface at 90°
- Observe the coating is free from defects, discontinuities, insects, spent abrasive media and other contamination
- Observe the coating is free from misses, sags, runs, wrinkles, fat edges, mud blistering, blistering, obvious pinholes, excessive dry spray, heavy brush marks and excessive film build
- Observe the uniformity and colour are satisfactory

All noted defects should be fully repaired to conform to the coating specification.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

For further advice please contact your local Jotun office.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

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Accuracy of information

Always refer to and use the current (last issued) version of the TDS, SDS and if available, the AG for this product. Always refer to and use the current (last issued) version of all International and Local Authority Standards referred to in the TDS, AG & SDS for this product.

Colour variation

Some coatings used as the final coat may fade and chalk in time when exposed to sunlight and weathering effects. Coatings designed for high temperature service can undergo colour changes without affecting performance. Some slight colour variation can occur from batch to batch. When long term colour and gloss retention is required, please seek advice from your local Jotun office for assistance in selection of the most suitable top coat for the exposure conditions and durability requirements.

Reference to related documents

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

When applicable, refer to the separate application procedure for Jotun products that are approved to classification societies such as PSPC, IMO etc.

Symbols and abbreviations

min = minutes

h = hours

d = days

°C = degree Celsius

° = unit of angle

µm = microns = micrometres

g/l = grams per litre

g/kg = grams per kilogram

m²/l = square metres per litre

mg/m² = milligrams per square metre

psi = unit of pressure, pounds/inch²

Bar = unit of pressure

RH = Relative humidity (% RH)

UV = Ultraviolet

DFT = dry film thickness

WFT = wet film thickness

TDS = Technical Data Sheet

AG = Application Guide

SDS = Safety Data Sheet

VOC = Volatile Organic Compound

MCI = Jotun Multi Colour Industry (tinted colour)

RAQ = Required air quantity

PPE = Personal Protective Equipment

EU = European Union

UK = United Kingdom

EPA = Environmental Protection Agency

ISO = International Standards Organisation

ASTM = American Society of Testing and Materials

AS/NZS = Australian/New Zealand Standards

NACE = National Association of Corrosion Engineers

SSPC = The Society for Protective Coatings

PSPC = Performance Standard for Protective Coatings

IMO = International Maritime Organization

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.