



# weberfloor 4771N PU flex coating

- Low-emission
- Good flow
- Flame retardant
- Flexibly deformable
- Suitable on steel

### Area of use

- For flexible flooring on ships, off-shore plants and other maritime applications.
- Imitation wood flooring (ship's plank coverings) for decorative areas.
- Smooth coatings for medium mechanical loads.
- Support layers for slip-resistant coverings scattered with natural sands.

### Substrate

The substrate to be coated must be even, dry, dust-free, sufficiently resistant to tension and compression, and free of weakly bonded components or surfaces. Materials reducing adhesion, such as grease, oil and paint residues, must first be removed with suitable measures.

To prepare the substrate, it can be blasted or sanded. The specifications, especially for steel, regarding preparation must be observed. Surfaces already coated with anti-corrosion paint can be further coated directly after checking sufficient adhesion, if necessary.

### To know before applying

Thinner is recommended for cleaning the devices. Hardened material can only be removed mechanically.

### Mixing

Combo-packaging will be supplied in the correctly measured mixing ratio. The package of Component A has sufficient volume to contain the entire packaging unit. Empty all of the hardener B into the resin package. Blend with a slow speed mixer (200 - 400 rpm) for 2 - 3 minutes until a homogeneous, streak-free compound forms.

To prevent mixing errors, it is recommended to empty ('repot') the entire resin/hardener mixture into a clean container and mix again briefly. In case of partial withdrawals, the individual components must be stirred up and weighed out in the mixing ratio.

### Work instructions

#### Build-up of Coats\*

\* Build-up of coats show possibilities about the applications of the products in practically used systems.

They can consist of several IMO-approved systems. It is possible to install several systems tested as "lowest deck covering" on top of each other. The top layer always corresponds to a tested floor covering.

### Product specification

Material consumption	Approx. 1.5 kg/m <sup>2</sup> per 1 mm layer thickness
Mixing ratio A:B	Parts by weight: A : B = 5 : 1. Parts by volume: A : B = 100 : 25
Application temperature	Minimum 10 °C / 50 °F (room and floor temperature)
Pot life (Operating time)	35 minutes at 10 °C / 50 °F. 20 minutes at 20 °C / 68 °F. 15 minutes at 30 °C / 86 °F.
Curing time	24 - 36 hrs. at 10 °C / 50 °F. 18 - 24 hrs. at 20 °C / 68 °F. 12 - 14 hrs. at 30 °C / 86 °F.
Curing time for light traffic load	2 - 3 days until it is able to withstand mechanical loads at 20 °C / 68 °F
Curing time for full traffic load	7 days until it is able to withstand chemical loads at 20 °C / 68 °F
Density	Components A + B: Approx. 1.5 kg/l DIN EN ISO 2811-2 (20°C/ 68 °F)
Viscosity	Components A + B: Approx. 3500 - 4000 mPas DIN EN ISO 3219 (23°C / 73 °F)
Color	Weber Standard Colours – see chart. All RAL colours upon request!
Storage conditions	12 months (originally sealed). Store in a dry and preferably frost-free location. Ideal storage temperature: 10 - 20 °C / 50 - 68 °F. Bring to the correct processing temperature before handling. Tightly reseal opened packages and use up the content as soon as possible.
Package	Bucket combo 12 kg Hobback combo 30 kg

### Smooth coating on steel/mineral substrate (floating screed)

- Prepare steel by suitable processes, e.g. grinding or blasting. For corrosion-protected substrates, the adhesion to the anti-corrosion coating must be checked.
- Optional base coat: Apply EP 3124 Marine base coat to which 10 - 15% water has been added, using a velour roller, consumption: approx. 0.200 - 0.400 kg/m<sup>2</sup>.
- Optional scratch coat: Preferably for floating screed/ concrete, but also for steel. Apply a scratch coat of weberfloor 4762N Epoxy Primer and add approx. 5% water and 15 - 20% quartz sand, grain size 0.3/0.8 mm, consumption: approx. 1.3 - 1.5 kg/m<sup>2</sup> (mixture).
- Apply weberfloor 4771N PU Flex coating covering with a notched trowel, e.g. notched blades S3 or Pajarito 95, consumption approx. 2.0 - 2.4 kg/m<sup>2</sup>. Ventilate promptly with the spiked roller.
- Apply a solvent-based sealer weberfloor 4780N PU Matt Clear Sealer, depending on colour and requirements. Apply with a solvent-resistant velour roller crosswise, consumption approx. 0.150 - 0.180 kg/m<sup>2</sup>.

Important note: The base coat weberfloor 4762N Epoxy Primer Marine can be coated directly with weberfloor 4771N PU Flex coating after a curing time of at least 16 to max. 48 hours (at 20 °C (68 °F)), without sanding. Relative humidity above 70% may require longer setting times.

### **Smooth, sanded covering (imitation ship's floor, wood plank floor)**

- Prepare the substrate as described above.
- Optional: As required, prime and, if necessary, scratch coat as previously described.
- Apply the self-flowing coating weberfloor 4771N PU Flex coating with a notched or pin screed scraper to a layer thickness of 3 - 5 mm, consumption approx. 4.5 - 7.5 kg. Adherence to the layer thickness is necessary for subsequent processing.
- After 16 - 24 hours, the decorative grooves/joints are milled into the surface and filled with weberfloor 4771N PU Flex coating in a contrasting colour.
- Processing is carried out with a grooving machine (HSS grooving cutter).
- After 16 - 24 hours, the surface is finished with the belt sander (grain size 40 - 60) until the required surface is achieved. Seek advice!
- The surface is then cleaned using a floor mop.
- After drying, the sealer can then be applied. The sealer type differs from the standard.

### **Scattered, slip-resistant, light-resistance floor covering.**

- Prepare the substrate as described above.
- Optional: As required, prime and, if necessary, scratch coat as previously described.
- Apply the support layer for the subsequent scattering, with weberfloor 4771N PU Flex coating coating, using a smoothing trowel or notched trowel in a layer of approx. 0.9 mm, consumption: distribute approx. 1.4 kg/m<sup>2</sup> with a roller or needle roller and ventilate.
- After a time delay of 10 - 20 minutes, scatter with 0.3/0.8 mm quartz sand until completely saturated. Consumption: 2.5 - 3.5 kg/m<sup>2</sup>.
- After curing, sweep or vacuum off the excess sand carefully until no more grains of sand come loose.
- Seal with the coloured, light-resistance top sealer weberfloor 4772N PU top coat. Apply with a rubber squeegee and then distribute evenly with a velour roller, pile height 8 mm. Consumption: approx. 0.5 - 0.7 kg/m<sup>2</sup>, depending on slip resistance.

### **Processing/ handling**

Process the material immediately after mixing and apply the product by skimming a uniformly thick layer with a scraper or notched trowel over the prepared substrate. The product is adjusted for optimum deaeration, however, rolling with a spiked roller is recommended to improve the wetting of the substrate, to optimise levelling and to remove remaining air bubbles. Rolling with the spiked roller should be done after a delay of 10 - 15 minutes. To work seamlessly, always work "fresh-in-fresh" and define work areas before starting.

Do not scatter too early due to ventilation; optimum time at 20 °C / 68 °F is after 10 -20 minutes. Continue scattering until the entire area is covered with sand. If the scattering is performed too late, this can lead to an uneven surface texture

and subsequent formation of "bald" patches. The floor and air temperatures must not fall below 10 °C / 50 °F and the humidity must not exceed 75%. The material to be processed must be at room temperature during processing.

The floor temperature may – within the recommended working conditions – be a maximum of 3 °C / 3 K / 5.4 °F colder than the ambient room temperature to preclude a dew point on the wall surface to be coated and on the fresh coating itself. If a dewpoint situation arises, regular drying and cross-linking will not be possible, with hardening problems and foaming to occur. Do not work in strong sunlight or on strongly heated substrates as the processing time will be greatly reduced and bubbling is possible. Polyurethane coatings are sensitive to moisture when fresh, so the humidity specifications must be adhered to as a matter of urgency.

The coating of dew-damp substrates as well as the use of damp sand or even sweat lead to foaming of the material and must be avoided.

The specified curing times apply to 20 °C / 68 °F; temperatures below this require longer processing and curing times, while higher temperatures require shorter times. Ensure the recommended conditions during the curing time. If the working conditions are not complied with, the technical properties of the end product may deviate from those specified.

### **Coating**

After 18 - 24 hours; however at the latest after 48 hours at 20 °C / 68 °F

### **Please observe**

This product is regulated by the German Ordinance on Hazardous Substances (GefStoffV), the German Ordinance on Industrial Safety and Health (BetrSichV), and transport regulations for hazardous goods. The necessary information is contained in the DIN Safety Data Sheet. Observe the labelling information on the product label!

GISCODE: PU 40

### **Disclaimer**

As there are different conditions at every opportunity, Weber can not be held responsible for anything other than the information provided under the heading "Product Specification". Examples of information and circumstances, which are outside Saint-Gobain (whether specifically stated or not) include storage, construction, processing, interoperability with other products, workmanship and local conditions.