

PRODUCT TECHNICAL DATA SHEET

Alkepoks 346

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| PRODUCT IDENTIFICATION | ALKEPOKS 346 FILLED EPOXY PRIMER 2-component, solvent-free primer for multilayer systems. | |
| USAGE AREAS | As primer coat in all multilayer epoxy and polyurethane coatings. | |
| PRODUCT CERTIFICATES | Quality management system ISO 9001 : 2015 Environmental management system ISO 14001 : 2015 Occupational health and safety system ISO 45001 :2018 CE (AT Declaration of Conformity) IDS.CE.19152.1 Brand Registry / No : Turkish Patent Institute 20145804 This product is manufactured in accordance with the EC Construction Materials Directive 305/2011. | |
| PRODUCT INFORMATION | EPOXY | |
| Package | A Component (Alkepoks 346 Filled Epoxy Primer) = 24 kg Tin Bucket | |
| | B Component (Alkepoks 319 Primer Hardener) = 6 kg Tin Bin | |
| | A + B Component. = 30 kg set | |
| Appearance/Color | A Component Resin = Clear, liquid | |
| | B Component Hardener = Clear, liquid | |
| Shelf Life | Shelf life is 12 months from production date. | |
| Storage | The product should be stored in its original, unopened and undamaged packaging in a dry and sunless environment between +5 °C and +30 °C. | |
| Consistency | A Component (Alkepoks 346 Epoxy Filled Primer) = 1,60 g/cm3 | |
| | B Component (Alkepoks 319 Epoxy Primer Hardener) = 1,05 g/cm3 | |
| | Mixture = 1,44 g/cm3 | |
| All values are made in accordance with DIN EN ISO. 2811-1 standards (23 ° C ' 100 ml Pyknometer). | | |
| Solid Matter | A Component (Alkepoks 346 Epoxy Filled Primer) = %100 | |
| | B Component (Alkepoks 319 Epoxy Primer Hardener) = %100 | |

| PHYSICAL STRENGTH | | |
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| Rigidity | ~80 DIN 53505 (7 Days +23 °C / %50 Relative humidity) | - DIN 53505 |
| Compression Resistance | ~52 N/mm ² (02-05mm quartz %10 Alkepoks 346 Resin) | - EN. 196-1 |
| Pull Off | ~1,5 N/mm ² (Rupture in Concrete) | - EN 196-1 |
| Tensile Force in Bending | ~20 N/mm ² (02-05mm quartz %10 Alkepoks 355 Resin) | - EN 4624 |
| APPLICATION TERMS and SYSTEM INFORMATION | | |
| Application Terms | <p>The reinforced concrete surface to be applied must have completed the 28-day concrete curing time, have a compressive strength of at least 225 kg / cm² and the ground moisture content must be maximum 4%.</p> <p>Alkepoks 355 Epoxy Resin is not suitable for floors with rising water vapor (capillarity).</p> <p><u>Ambient humidity and temperature during application</u> Ambient Temperature : +10 °C and +30 °C Surface Temperature : +10°C and +30 °C Relative Humidity : Mostly %60</p> <p>Dew Point: Attention to condensation during application and drying</p> <p>Please check. Use psychrometer for condensation point detection, the floor temperature must not be above +3 °C above the condensation point.</p> <p>Avoid low temperature (below +15 °C), high humidity (above 60%) and at night when you cannot determine the dew point</p> | |
| Surface Preparation | <p>The reinforced concrete surface to be treated must be cleaned from dirt, dust and oil.</p> <p>On reinforced concrete floors, the layer with weakened corrosive bonds due to hydration (cement grout) should be scraped off the surface by mechanical means (diamond blade abrasives and/or shot blasting machines).</p> <p>Dust generated during the process should be removed from the area by vacuum.</p> <p>Capillary and pore (bird's eye) spaces should be made visible as a result of the process.</p> | |
| Product Preparation for Use | <p>Mix component A with a low speed (300-400 rpm) mixer, slowly add component B during mixing and mix for 1 - 2 minutes. After the mixture is complete, transfer it to another clean container and mix again for 1-2 minutes. If quartz sand is to be added, slowly add it to the mixture and mix for another 1-2 minutes.</p> | |

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SYSTEM INFORMATION

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| Primer | Consumption 0,350-0,500 kg/m ² (0,243mm- 0,347mm) Application : With hoe | 1mm = 1,100 kg./m ² |
| Filled Primer | Consumption %50 Alkepoks 346 Epoxy Primer + %50 Quartz sand (01-03mm) Application: With steel hoe | 1mm = 1,875 g./m ² |

Note: The quartz thickness to be used for filling can be changed in the granulometer so that the highest grain size does not exceed 1/3 of the coating thickness.

IMPREGNATION (PRIMER) COAT FOR COATINGS

For impregnation (primer application) in accordance with the coating to be applied,

Alkepoks 346 Epoxy Filled Primer should be applied with a consumption of 0.350-0.500 kg/m² or

Alkepoks 346 Epoxy Filled Primer should be mixed with 50% quartz sand and applied with a trowel, without waiting on the surface preparation completed.

A continuous, non-porous surface should be obtained for the application of colored coats. If the process seems insufficient depending on the structure of the surface, the application should be repeated and leveled.

For sand rough systems, the above process should be applied in 2 layers and sand with a minimum grain size of 02-05 mm should be sprinkled homogeneously in 2 layers with a consumption of 2,500 kg/m².

DRY PROGRAM

| ALKEPOKS 346 FILLED EPOXY PRIMER | +10 °C | +20 °C | +30 °C |
|---|---------|---------|---------|
| Container Time (Product usage time) | 60 min. | 30 min. | 15 min. |
| Touch dry time (No dust) | 12 hr. | 8 hr. | 4 hr. |
| Installation Dry Time (New coat application time) | 48 hr. | 24 hr. | 12 hr. |
| Drying Time (Pedestrian and light forklift traffic) | 3 Days | 2 Days | 1 Day |
| Curing Time (Full dry chemical resistance) | 10 Days | 7 Days | 7 Days |

The data are measurements made in a 60% relative humidity environment and are approximate.

CLEANING OF EQUIPMENTS

All equipment used during application should be cleaned with thinner immediately after use. The hardened material must only be removed by mechanical means (do not burn, do not use highly abrasive chemicals).

All residual materials and empty containers must be disposed of in accordance with national regulations and legislation.

DATA BASIS

The information given in this product data sheet has been obtained under laboratory conditions or by knowledge, observation and experience. Conditions that we cannot control during implementation may change the data results. For this reason, this information provided in good faith as advice is not legally binding.