

**CHEMICAL RESISTANT COATING, LINING & GROUTING RESIN**

**PROTECTION OF CONCRETE OR STEEL  
CURES UNDER COLD DAMP CONDITIONS  
EXCELLENT CHEMICAL AND WATER RESISTANCE  
CAN BE USED WITH FIBERGLASS FOR LAMINATING  
VERSATILE SITE GROUTING, PATCHING AND  
SCREEDING COMPOUND  
QUICK STRENGTH DEVELOPMENT**

**PRODUCT DESCRIPTION:**

A two component solvent-free liquid epoxy resin designed to have excellent surface wetting properties of substrates promoting adhesion, even under low temperature damp conditions. The cured chemical resistance and mechanical properties achieved make it an ideal construction site liquid resin system for adverse weather conditions.

**USES:**

- Laminating with Chopped Strand Mat in effluent tanks.
- Grouting reinforcing bars under damp conditions.
- Versatile grouting mortar when mixed with graded Stonhard # 622 Aggregates for concrete repairs and 5mm chemical resistant floor screeds.
- Crack injection resin applications under adverse conditions.
- Seal concrete floors from dusting.

**PACKAGING & COVERAGE:**

1 Litre and 5 Litre kits – Part A& B  
Laminating: 0,66m<sup>2</sup>/litre with 300g CSM  
Coating: 3 to 5m<sup>2</sup>/litre  
Mortar: 1 Litre + 6kg # 622 Aggregate = 3,6 litres/m<sup>2</sup> at 3,6mm thick

**SURFACE PREPARATION:**

Remove all oils, grease and other contaminants by scrubbing with Carboclean 252 and rinsing with clean running potable water, to obtain a water break-free surface. Allow to dry. Abrade the surface by vacu-blasting or scarifying to expose the aggregate and open all voids. If grinders are used to remove thin coatings, reduce or smooth the surface profiles, it will not give a surface pattern suitable for coatings unless followed by etching or vacublasting. The roughened surface should have a texture similar to 80-grit sandpaper, minimum tensile strength of 2 MPa and moisture content of 5 % maximum. Refer to Product Data Sheet for additional surface preparation requirements.

**MIXING:**

Precondition material to between 10°C and 23°C before using. Premix each component of the kit. Add the Activator component to the Base component and mix thoroughly for 3 minutes with a slow speed mechanical mixer. Do not aerate or mix more material than can be placed in 30 minutes. To prepare an epoxy mortar, slowly add pre-packaged Stonhard 622 Dry graded aggregate to a kit of mixed resin and mix to a uniform consistency.

**APPLICATION:**

Apply using squeegees and backroll with medium nap rollers, ensuring material is forced into the concrete pores. Within 8-12 hours, apply subsequent coats. When used as a laminating resin for tanking with fibreglass CSM, the layers should be applied wet-on-wet, utilising a fluted roller to fully impregnate the glass with resin and de-aerating it. Whilst wet, a surface tissue (PRT 684/3) is applied saturating again with Pro-Struct 632. This lining system must be done as one process.. As a grouting resin for holding down bolts, the system can be poured into pre-drilled dust-free holes and allowed to set for 24 hours before installation of the equipment. A high chemical resistant plaster/screed is achieved by blending the resin with a graded aggregate # 622 in a pan mixer and applying by trowel onto suitably prepared primed surfaces. The screed must be sealed with a roller-applied coat of Pro-Struct 632, to ensure it is non-porous and has an even gloss appearance. Clean equipment immediately after use with Pro-Struct 105 Brush Cleaner and rinse off in clean water

**CLEAN-UP:**

Clean equipment immediately after use with Pro-Struct 105 Cleaner and rinse with clean water.

**LIMITATIONS:**

Application temperature of substrate to be 4°C and rising. Low temperatures adversely affect flowability and time to gain strength. Hot temperature decreases working time. Do not apply over free standing water. Do not thin with solvent. Do not inject moving or leaking cracks. Minimum age of concrete must be 28 days.

**PRECAUTIONS:**

Use materials in strict accordance with the manufacturer's Material Safety Data Sheet. Protective clothing and equipment will significantly reduce risk of injury. Body coverage apparel, safety goggles and impermeable gloves are recommended. In case of contact, flush with copious amounts of water and seek medical attention. Dispose of waste materials and containers in strict accordance with Government Regulations.

October 2017 replaces January 2014

(Pro-Struct 632-22)

**TYPICAL PROPERTIES AT 25°C**

<b>Colour</b>	Dark Amber
<b>Consistency</b>	Liquid
<b>Volume Solids</b>	100%
<b>Number of Components</b>	2
<b>Mix Ratio by Volume (Base:Activator)</b>	2:1
<b>Pot Life</b>	20 to 30 Minutes
<b>Apply Over</b>	Prepared concrete surfaces
<b>Apply By</b>	Pour, Brush, Roller or Trowel
<b>Initial Set</b>	8 Hours – recoat
<b>Service</b>	24 Hours
<b>Full Cure</b>	5 Days
<b>Application Temperature Range</b>	5°C to 35°C
<b>Maximum Service Temperature</b>	50°C Wet / Dry
<b>Compressive Strength</b>	> 55 MPa at 7 days
<b>Tensile Bond Strength</b>	>5 MPa
<b>Concrete Bond Strength</b>	Breaks concrete
<b>12mm Rebar Pull-out Depth 126mm</b>	Bar failure 50 kN
<b>Shelf Life</b>	24 Months if stored between 15°C to 35°C
<b>VOC</b>	6.5 g/l

# APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

## SPECIFICATION FOR PRO-STRUCT 632 RESIN LINING SYSTEM

### 1. SCOPE OF WORK (BOQ)

As a lining system, apply Pro-Struct 632 Resin reinforced with 300gm CSM Engineering Fabric and PRT surface veil to all prepared wall and floor surfaces. All products to be installed strictly in accordance with the Manufacturer's guidelines.

### 2. SUBSTRATE

Remove all oils, grease and other contaminants by scrubbing with Carboclean 252 and rinsing with clean running potable water, to obtain a water break-free surface. Allow to dry. Abrade the surface by vacu-blasting or scarifying to expose the aggregate and open all voids. If grinders are used to remove thin coatings, reduce or smooth the surface profiles, it will not give a surface pattern suitable for coatings unless followed by etching or vacublasting. The roughened surface should have a texture similar to 80-grit sandpaper, minimum tensile strength of 2 MPa and moisture content of 5 % maximum. Refer to Product Data Sheet for additional surface preparation requirements

### 3. SUBSTRATE REPAIR

Lightly sand to remove laitance and repair any areas that are not sound using Pro-Struct 30/35NS. Reprofile aggregate exposed surfaces which have been chemically attacked with Pro-Struct 526 Five Star Waterproof.

### 4. PRIMING AND COATING

Apply a generous primer coat of Pro-Struct 632 Resin and lay in a chopped strand fiberglass mat (300gm/m<sup>2</sup>) saturating from above with Pro-Struct 632 Resin, deaerating all layers with a fluted roller. While still wet, apply a surface tissue (PRT Reinforcing Tissue) again saturating same with Pro-Struct 632 Resin. When cured, sand down surface and apply a final finishing coat.

This coating system must be done as one process.

The approximate coverage of Pro-Struct 632 Resin is 1,5lt/m<sup>2</sup> in the above described system. It is, however, imperative that trial consumption figures be obtained on the given surface.

### 5. CURING

Allow system to cure for 7 days before exposing to chemical conditions.

**CAUTION: MAY CONTAIN FLAMMABLE SOLVENTS.** KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRONIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NON-FERROUS TOOLS AND TO WEAR CONDUCTIVE AND NON-SPARKING SHOES.



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