Method Statement

STARBOND EPC 600

(Two Component, Solvent Free, High Performance, High Build Epoxy Flooring System)

Rev.: A, Date: 25.06.2025

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Section A: General Considerations

Tools & Equipment

It is suggested that the following list of equipment is adopted as a minimum requirement.

Equipment Type	Equipment Description
Protective clothing	▪ Protective Coveralls ▪ Good quality gloves and face mask ▪ Eye Protection
Mixing equipment	▪ Paddle Mixer ▪ Manual Mixing Tools
Surface Preparation Equipment	▪ Solvent ▪ Steam Cleaning Equipment ▪ Industrial Vacuum
Application Equipment	▪ Brush, Trowel, Short Haired Lamb Wool Roller, Gauged Squeegee ▪ Spatula ▪ Rollers

High temperature working

It is suggested that, for temperatures above 35°C, the following guidelines are adopted as good working practice:

1. Store unmixed materials in a cool environment, avoiding exposure to direct sunlight.

2. Keep equipment cool, it is especially important to keep cool those surfaces of the equipment which will come into direct contact with the material itself.

3. Try to avoid application during the hottest times of the day, arrange temporary shading as necessary.

4. Make sufficient material, plant and labour available to ensure that application is a continuous process.

Application - points of note

STAR Technologies operates a policy to encourage the use, where possible, of approved or licensed applicators. This ensures that applications are completed satisfactorily so that the long-term performance of the materials is assured.
For contractors who wish to apply the materials themselves STAR is also able to offer technical assistance and training. Either on-site or at its Training Centre in the Kingdom of Saudi Arabia.

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Section B: Application Instructions

1. Surface Preparation

1.1 Surfaces be dry, clean, solid, free from loose materials, oil grease, paints and free from contamination such as oil, grease, loose particles, decayed matter, moss algal growth, laitance, and all traces of mold that could interfere with bonding.

1.2 STAR solvent can be used to clean and degrease surfaces.

1.3 Abrasion may be involved, as lightly sanding surfaces to improve adhesion, especially on smooth or glossy materials.

1.4 Surfaces should be dry and within the recommended temperature range specified by the manufacturer (typically 10°C to 40°C).

2. Priming

2.1. If the concrete surface is porous, it is recommended to use STARBOND EPP 100SF/200SB.

2.2. Mix **STARBOND EPP 100SF/200SB** as supplied, add the entire content of hardener (Part B) into the base (Part A) and mix thoroughly about 2minutes, avoid over mixing.

2.3. When thoroughly mixed, preferably using a slow speed mixer, apply the primer in a thin, continuous film using rollers or stiff brushes.

2.4. Work the primer well into the concrete surface, taking care to avoid ponding or over application

2.5. Leave the primer to achieve a tack-free condition before applying the topcoat.

3. Mixing

3.1 Mix **STARBOND EPC 600** as supplied, add the entire content of hardener (Part B) into the base (Part A) and mix thoroughly about 3 minutes, avoid over mixing, DO NOT USE SOLVENT THINNERS.

4. Application

4.1 The application and cure temperature must be above 15°C.

4.2 Lay the first coat of **STARBOND EPC 600** using a short- haired lamb wool roller or gauged squeegee to achieve a continuous coating.

4.3 Ensure to remove loose hairs on the roller before use.

4.4 Apply a minimum film thickness of 200 microns per coat for the flooring system (this can be increased where specifications demand).

4.5 Apply the topcoat in the same manner within 8 to 24 hours of applying the topcoat.

5. Anti-slip Aggregates

5.1 If the option of using anti-slip aggregates has been chosen, the base coat should be dressed in the chosen anti-slip aggregates as soon as possible after laying the base coat.

5.2 The recommended procedure is to blind the base coat completely,

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i.e., apply excess dressing aggregate to obliterate the base coating.

5.3 Alternatively, the anti-slip silica particles can be broadcast in a light random dressing to provide a less dense finish, or the product can be used to obtain a smooth finish by omitting the anti-slip aggregates.

5.4 When the base coat has reached the initial cure (after 12 hours at 20°C or 5 hours at 35°C), the excess aggregate should be vacuum cleaned from the surface.

5.5 The top coat can now be applied by a short-haired roller or airless spray equipment.

5.6 Ensure achieving a continuous film and to seal the rough surface caused by the aggregate.

5.7 Apply this topcoat within 36 hours at 20°C (15 hours at 35°C) of applying the resin base coat.

6.0 Expansion Joints

6.1 Expansion joints in the existing substrate must be retained and continued through the **STARBOND EPC 600**

6.2 STAR Technologies has a range of joint sealants specifically designed for flooring (see STARFIX PU 600 product data sheets).

7. Cleaning

7.1 **STARBOND EPC 600** should be removed from tools, equipment and mixers with Star Solvent prior to the initial set.

Section C: Approval and Variations

This method statement is offered by STAR Technologies as a 'standard proposal' for the application of **STARBOND EPC 600**. It remains the responsibility of the Engineer to determine the correct method for any given application.
Where alternative methods are to be used, these must be submitted to STAR Technologies for approval, in writing, prior to commencement of any work. STAR Technologies will not accept responsibility or liability for variations to the above method statement under any other condition