Method Statement

STARBOND EP-SL400

(Multi Component, Solvent Free, High Performance, Pigmented, Self Leveling Epoxy 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. It is recommended to use STARBOND EPP 100SF/200SB on any type of concrete substrate.

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 EP-SL400 as supplied. Pre-mix Part A (Base Resin) briefly to ensure uniformity. Add the entire contents of Part B (Hardener) to Part A and mix using a slow-speed mechanical mixer for approximately 1 minute.

3.2 Gradually add Part C (Filler) and the color pack, if supplied separately, while mixing continuously. Continue mixing for approximately 1–2 minutes or until a homogeneous, uniform, lump-free mixture is obtained.

3.3 Avoid excessive mixing and air entrainment. Do not add solvent, thinner, or any other material to the mixed product.

4. Application

4.1 The substrate and application temperature shall be above 15°C during application and initial curing.

4.2 Immediately after mixing, pour STARBOND EP-SL400 continuously onto the prepared and primed substrate.

4.3 Spread the material uniformly using a notched trowel or gauged squeegee to achieve the specified thickness.

4.4 Apply STARBOND EP-SL400 at a recommended dry film thickness of 1.0–4.0 mm per coat, or as specified for the flooring system.

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Immediately after spreading, roll the applied material using a spiked nylon roller in a back-and-forth direction to assist air release, remove trowel marks, and achieve a uniform self-leveling finish.

4.5 Adjacent roller passes should overlap by approximately 50%. Further light rolling may be carried out, if required, before the material begins to set.

4.6 Maintain a continuous application and wet edge to minimize visible joints and variations in the finished surface.

4.7 Where an additional coat is required, apply it within the recommended recoating interval. If the maximum recoating interval is exceeded, mechanically abrade the cured surface and remove all dust before applying the subsequent coat.

5.0 Expansion Joints

5.1 Expansion joints in the existing substrate must be retained and continued through the **STARBOND EP-SL400**

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

6. Cleaning

6.1 **STARBOND EP-SL400** 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 EP-SL400**. 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