

Application Plastifloor® 412 is notably suitable for the production of 0.078-0.16 inches (2.0 to 4.0 mm) broadcasting coatings.

Characteristics: Plastifloor® 412 coatings have excellent mechanical strength and high chemical resistance, as well as resistance to UV ageing and saponification.

Characteristics data of the resin as delivered:

Property	Measuring method	Approx. value
Density at 68 °C	DIN 51757	1.2 g/cm ³
Curing	approx. 30 min at 68 °F	
Pot life at 68 °F	approx. 10 min	
Shelf-life	dark at < 68 °F, 1 month maximum	
Form of delivery	slightly cloudy liquid	
Bundle	25 kg, 10 kg pails	

Processing Notes:

Suggested
formulation:
Coating 2-5 mm

			Consumption/mm
app.	55.0 ppW	Plastifloor® 410	0.205 lb/ft ²
	45.0 ppW	Quartz sand	0.143 lb/ft ²
	2.0 ppW	Hardener 50 W (68°F)	

This formulation is suitable for floors exposed to severe mechanical and chemical loading in dry and wet areas, e.g. electrolytic and galvanizing plants, chemical production plants, acid-proof installations, dairies and butcheries trade where slip-resistant floors are required.

This mixture is applied to well primed surfaces. If necessary, it is possible to apply a flexible membrane layer of Plastifloor® 332/Z.

Processing:

Stir up the resin well before use!

Before use, hardener and resin must be mixed and stirred for at least 1 minute, then fillers must be premixed in the power mixer for approx. 2 minutes. The coating then is applied immediately with a smoothing trowel.

Thin coats and excess filler will reduce the fluidity of the material and may cause cure defects.

Bleed the coating compound with a prick roller

For decorative surfaces, colored sand (resin coated), e.g. granulation 15 - 25 mesh can be scattered onto the coating.

It is recommended to seal this surface e.g. with Plastifloor® 522 or Plastifloor® 526.

Pot life and curing times depending on temperature:

Further coats of Plastifloor® should be applied only after the previous coat has completely cured.

Temperatur [°F]	Hardener [Vol%]	Hardener [wt%]	Pot life [min]	Curing time [min]
+ 41	2.6	1.7	approx. 10	approx. 23
+ 50	2.0	1.3	approx. 8	approx. 20
+ 68	1.6	1.0	approx. 8	approx. 18
+ 86	1.3	0.8	approx. 6	approx. 15

- Hardener quantity calculated according to Plastifloor® 410
- Temperature refers to resin, surface and air temperature

Attention: Hardener levels below 1 vol. % may cause polymerization failure!

Note: Always wait until the previous coat is completely cured before proceeding with the next coat. For applications below 32 °F (0°C) it is necessary to use Accelerator 101. (ask for data sheet!)

Storage: The handling regulations for highly flammable materials apply to methacrylate – resins. Plastifloor® resins should be stored cool, away from direct sunlight and preferably at temperatures between 59 - 68 °F (15 – 20 °C). During storage, paraffin particles and fillers may precipitate. Therefore, containers must be well agitated before use. Please refer to our Safety Data Sheets.

Industrial safety:

Provide adequate ventilation during work. During processing, observe the regulations of the Hazardous Substances Ordinance, the instructions of the Federal State Committee for Occupational Safety and Safety Technology (LASI), and our safety data sheets.

VbF: A I
GISCODE: RMA 10
HS-Code: 3208 2010

CE	
Plasti Chemie International GmbH • Falgarding 1 • 08223 Falkenstein • Germany	
EN 13813, SR-B2, 0-AR0, 5-IR12	
Plastifloor® 412	
Synthetic resins for internal uses (Application in accordance with the newest technical information)	
Reaction to fire:	E _n
Wear resistance (Abrasion Resistance):	AR 0.5
Impact resistance:	IR 12
Tensile bond strength:	B 2.0

CE-labelling

Data concerning our products and devices as well as concerning our data and procedures are based on an extensive research work and an application technology experience. We obtain these results, with which we do not take over adhesion going beyond the respective single contract, in word and writing after best knowledge, reserve ourselves we however technical changes in the course of the product development. Beyond that our application technology service stands when desired for large consultation as well as for co-operation with the solution manufacturing and application technology problems for order. That does not relieve the user however to examine our data and recommendations before their use responsible for the own use. That applies - particularly for deliveries to foreign markets - also regarding the keeping of patent rights third as well as for applications and procedures, which are not expressly in writing indicated by us. The case of loss our adhesion is limited to indemnifications of same extent, as they plan our general terms of delivery and sales with lack of quality.