

# R 625 CE

High performance, antistatic, conductive self-smoothing, Epoxy flooring system

## DESCRIPTION

R 625 CE is seamless, self-smoothing, conductive epoxy flooring designed to eliminate build-up of static electricity with excellent conductive properties. The cured flooring exhibits an attractive joint free finish with chemical resistance and decorative properties. Suitable to be installed between 1-2mm in industries subjected to medium to heavy duty traffic and where hygiene and hardwearing properties are essential, such as Electronic & Telecommunication, Automotive, Pharmaceutical, Aerospace, Hospital Operation Theatres, Computer rooms, etc.

## FEATURES

- Electrostatically Conductive
- Excellent Chemical, Mechanical and Abrasion Resistance
- Seamless - easily cleaned to maintain high standards of hygiene
- Hard wearing and durable with low maintenance costs
- Solvent free
- Microelectronic industry grade conductivity  $10^4 \sim 10^6 \Omega$
- Available in any standard RAL colour

## PHYSICAL PROPERTIES

R 625 CE Conductive Coating @  $27 \pm 1^\circ\text{C}$

Pot life	30 minutes
Mixed Density	1.62 gm/cc
Foot Traffic	24 Hours
Full Cure	7 days
Surface resistance	Ohms $10^4 \sim 10^6 \Omega$
Shore D Hardness after 7 days	> 70
Bond Strength after 7 days	2.5 N/mm <sup>2</sup>
Tensile Strength (BS 6319, Part – 7)	> 16.00 N/mm <sup>2</sup>
Flexural Strength (BS 6319, Part – 3)	> 39.00 N/mm <sup>2</sup>
Compressive Strength after 7 days	> 70.00 N/mm <sup>2</sup>

## PACK SIZE

### R 625 CE Conductive Coating

2.250 kg  
Part A 1.80 kg  
Part B 450 g

## COVERAGE

Approx. 9 m<sup>2</sup>/coat

## R 625 CE Top Coat Coverage Estimates

Pack Size	14 kg	
	Thickness	2 mm
Resin (Part A)	3.8 kg	3.8 kg
Hardener (Part B)	1.7 kg	1.7 kg
Filler (Part C)	8 kg	5 Kg
Coverage/pack (approx.)	4.30 m	7.30 m
Mixed Density	1.62 g/cc	1.50 g/cc

Note: For 1mm thick application, reduce filler (Part C) content by 3 kgs.

## APPLICATION INSTRUCTION

Installation of R 625 CE should be carried out only by an approved applicator of ARDEX ENDURA.

### Surface Preparation

Good substrate preparation is essential for optimum performance. The concrete surface must be hard, sound and free of dust and other barrier materials such as paint, lime coatings, plaster, and curing agents. Laitance, adhesive residues etc. that will inhibit adhesion to the substrate.

Use a suitable degreaser to remove polish, wax, grease, oil and similar contaminating substances prior to mechanical preparation. Contaminated concrete surfaces should be mechanically prepared, either by scrubbing, scarifying, grinding or shot blasting equipment or similar, and be suitably prepared down to sound, solid concrete by mechanical methods. Dust and other debris should be removed using vacuum equipment.

Note: All construction joints, cracks and potholes shall be treated prior to the primer application in the concrete base where differential movement is anticipated e.g. movement joints, should be brought through to the finished surface. New concrete slabs must be allowed to cure for at least 28 days. The maximum moisture content of the substrate should be <4% measured by an accurate moisture meter.

### Priming

All areas to be treated with R 3 E or R 9 CE must be first primed with a suitable epoxy primer from the ARDEX ENDURA range. Selection of the primer must be made depending on the substrate condition & porosity. Please refer to the individual primer data sheets for further details.

One or more coats of the primer may be required depending upon the condition and porosity of the concrete substrate. High porosity substrates may be revealed after preparation and will be evident by their rapid suction and absorption. Poorly primed surfaces may lead to blistering or pin holing in the cured resin.

### R 625 CE Conductive Coating

Use a mechanical mixer and mix the two parts of the R 625 CE Conductive Coating for one minute so that it forms a homogeneous mix. Do not over mix as it will result in air

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entrainment and also the mixed material may get heated up. A minimum of two coats of R 625 CE Conductive Coating is required.

Apply first coat of R 625 CE Conductive Coating by roller on the primed surface to get a total thickness of 90 - 100 microns. Allow 6 - 8 hours (depending on temperature and humidity) and install self-adhesive copper tape of 12 - 20mm width and 70 - 100 microns thick (e.g. 3M scotch) maintaining 150 mm from the perimeters. A further grid of the conductive tape is fixed within this area at 3m centres. The applied tape matrix should be secure and fully bonded to a confirmed earth point. There should be an earthing point for every 100m<sup>2</sup> floor area. Floors of less than 100m<sup>2</sup> should have two earthing points.

Apply second coat of R 625 CE Conductive Coating at 70 – 100 microns thickness.

### R 625 CE Top Coat

The individual contents of R 625 CE Top Coat should be thoroughly stirred before being mixed together. Mix Part D with Part A and ensure smooth mixing. The entire contents should be poured in to a larger mixing vessel to incorporate Part B and Part C. The materials are mixed thoroughly with a spiral mixing paddle in a slow speed drill for 2 minutes until a consistent homogenous mix is achieved. One or more packs may be mixed simultaneously to ensure a quick rate of installation. Do not over mix as it will result to an increase in the resistance of the floor and may no longer comply with the specification for antistatic floors along with issues like air entrainment and also the mixed material may get heated up which will eventually reduce the pot life.

R 625 CE Top Coat should be applied to the prepared surface without delay using a trowel or depth set rake to achieve the desired thickness of 1 - 2mm.

As soon as the R 625 CE Top Coat has been laid and as work progresses, the surface should be gently rolled with a spike roller in order to release any entrapped air from the mix also to blend out any trowel marks. R 625 CE is self-curing and the work area should be protected during the installation process and during the initial curing time for at least 24 hours, to ensure that no debris, insects, dust, spillage can contaminate the surface, as this will lead to unwanted blemishes in the hardened, cured surface.

### LIMITATIONS

R 625 CE should not be applied to floors that are known to have rising moisture or have relative humidity of greater than 75% at the time of application. These products should not be applied in temperatures less than 10 C. Once the mixed material has exceeded its pot life, the viscosity and the characteristics of the product will change and any unused product should be discarded at this time. Do not steam, clean or use hot water above 55 C to wash the surface.

Note: All products are manufactured under strict Quality Assurance procedures; however, it is recommended that wherever colour consistency is essential, products from one batch should be used as much as possible.

### CLEANING

R 625 CE can be removed from tools and equipment by using RTC 100 immediately after use. Any hardened material will need to be removed mechanically.

### CHEMICAL RESISTANCE

R 625 CE is resistant to a wide range of liquids and chemicals, for specific information please refer to the following ARDEX ENDURA "Chemical Resistance" chart.

### CHART

Reagent	Concentration in %	R 625 CE
Acetic acid	10	R
Acetic acid	50	N
Acetone	100	N
Ammonia	10	R
Ammonia	35	L
Beer	100	R
Citric acid	50	R
Formic acid	50	N
Hydrochloric acid	25	R
Hydrogen Peroxide	20vol	R
Kerosine	100	R
Lactic acid	25	R
Methylated Spirit	100	N
Milk	100	R
Nitric acid	30	R
Nitric acid	70	N
Oleic acid	100	R
Orange Juice	100	R
Petrol	100	R
Phosphoric acid	10	R
Red Wine	100	R
Salt	Saturated	R
Sodium hydroxide	50	R
Sodium hyperchlorite	15	R
Sugar	Saturated	L
Sulphuric acid	10	R
Sulphuric acid	25	R
Sulphuric acid	75	R
Xylene	100	L

Resistant	R	28 Days +
Limited Resistance	L	up to 7 Days
Not Resistant	N	
Short Term Resistance	S	up to 1 Day

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## STORAGE AND SHELF LIFE

R 625 CE store under cover, out of direct sunlight and protect from extremes of temperature. In tropical climates the product must be stored in an air-conditioned environment. Shelf life is 12 months when stored as above.

## MAINTENANCE

Good housekeeping and regular cleaning are essential in order to maintain the performance of R 625 CE. It is particularly important in areas that are subject to regular spillage of chemicals. Spillages should not be allowed to dry, which results in higher concentrations of the chemicals, which may lead to early failure. Regular cleaning of the surface with a rotary scrubbing machine in conjunction with a water miscible cleaning agent or hot water washing at temperatures up to 50 C is recommended.

## PRECAUTIONS

In case of contact with the eyes, rinse immediately with plenty of water and seek medical advice and after contact with the skin wash immediately with plenty of soap and water (do not use solvents). Prolonged contact with the skin should be avoided, especially where the user has an allergic reaction to epoxide materials. Always wear gloves and eye/face protection is necessary. Observe personal hygiene, particularly washing the hands after work has been completed or

at any interruption whilst work is in progress. Care should be taken when removing gloves to avoid contaminating the insides. In case of accidents seek medical advice.

## DISPOSAL/SPILLAGE

Spillage of any of the component products should be absorbed onto sand or other inert materials and transferred to a suitable disposable vessel. Disposal of such spillage or empty packaging should be in accordance with local waste disposal authority regulations. For further information please refer to the Product Safety Data Sheet.

## CONDITIONS OF SALE

Sold subject to the Company's conditions of sale which are available on request.

## NOTE

The information supplied in this datasheet is based upon extensive experience and is given in good faith in order to help you. Our Company policy is one of continuous Research and Development; we therefore reserve the right to update this information at any time without prior notice. We also guarantee the consistent high quality of our products; however, as we have no control over site conditions or the execution of the work, we accept no liability for any loss or damage which may arise as a result thereof.



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