

**HIGH BUILD 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**

**PRINCIPAL USES**

Whenever high chemical resistance, quick cure coating, fibreglassing or grouting is required, e.g. food processing plants, chemical manufacturing installations, water/sewage treatment works, building sites. For secondary containment, use Stonchem 658.

**RESISTANCE**

**Acids:** Resists splash, fumes or spillage of up to 20% solutions of Hydrochloric, Sulphuric, Acetic and Lactic.

**Alkalies:** Resists splash and spillage of most diluted alkalies and salts.

**Petroleum Products:** Resists splash, spillage or immersion in paraffin, diesel oil, petrol, alcohol and aliphatic solvents.

Contact StonCor Africa Technical Service Department for specific chemical resistance.

NOTE: Staining may occur depending on length of exposure time, chemical concentration and temperature.

**SPECIFICATION**

All surfaces treated with Pro-Struct 632 High Build Coating and Grouting Resin to be in accordance with Manufacturer's detailed instructions.

**SUBSTRATE PREPARATION**

Proper preparation is critical to ensure an adequate bond. The substrate must be dry and free of all wax, grease, oils, fats, soil, loose or foreign materials and laitance. Laitance and unbonded cement particles must be removed by mechanical methods, i.e. abrasive blasting or grinding. Other contaminants may be removed by scrubbing with a heavy-duty industrial detergent (Carboclean 250 and Carboclean 252) and rinsing with clean water. The surface must show open pores throughout with main aggregate in concrete exposed and have a sandpaper texture. Substrate moisture content should be below 5% and substrate tensile strength above 2 MPa. For recommendations or additional information regarding substrate preparation, please refer to surface preparation data sheet or contact StonCor Africa Technical Service Department.

**MIXING**

Under no circumstances are the supplied kits to be split. The contents of the components in a kit are to be thoroughly mixed together for 1 minute before use. Empty entire contents of the activator into the base component. Mix thoroughly for 2 minutes with an impeller fitted to a variable speed drill. Transfer mixed material into another mixing container, scraping the sides and bottom of the container and remix for another 2 minutes. This step is critical to ensure complete cross-linking of components is achieved. Do not mix by hand.

**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.

**CAUTION**

Under no circumstances should Pro-Struct 105 Brush Cleaner be mixed with any Pro-Struct/Stonhard Epoxy Compound as this will inhibit the curing of the material. To avoid confusion, Pro-Struct 105 Brush Cleaner is coloured **blue**. In all cases, ensure that the first coat has not been contaminated by any foreign matter before applying subsequent coats. Abrade and vacuum to give a dust-free surface. Remove spots of Pro-Struct/Stonhard Epoxy on hands with cotton waste dipped in water. Always wash well with soap and water after using this material.

**See also Instruction Sheet "Handling of Epoxy Products"**

April 2012 SA replaces April 2010 SA

(Pro-Struct 632 / 632-22 Mortar)

**TYPICAL PROPERTIES AT 25°C**

<b>Finish</b>	Gloss
<b>Colour</b>	Dark Amber
<b>Consistency</b>	Thick Liquid
<b>Volume Solids</b>	100%
<b>Theoretical Coverage per Coat</b>	2-4m <sup>2</sup> /litre (Coating) 0,66m <sup>2</sup> /litre (Laminating) 3.6litres/m <sup>2</sup> at 3.6mm thick (632/22 Mortar)
<b>No. of Components</b>	2 – Resin & Activator 3 – When mixed with Pro-Struct 622 Aggregate 1lt Resin plus 6kg
<b>Aggregate</b>	yields 3.6lt
<b>Mix Ratio by Volume</b>	2:1
<b>Pot Life</b>	20-30 Minutes
<b>Apply Over</b>	Concrete or steel
<b>Apply By</b>	Brush, roller or trowel
<b>Curing Time</b>	8 Hours – recoat 24 Hours – service 5 Days – full cure
<b>Thinner</b>	Nil
<b>Shelf Life</b>	18-24 Months
<b>Service Temperature</b>	50°C wet/dry
<b>Application Temperature Range</b>	5°C to 35°C

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# 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 TANK LINING SYSTEM (CONCRETE)

### DESCRIPTION

This specification deals with the preparation, priming and coating of smooth concrete and plastered surfaces.

### SURFACE PREPARATION

All surfaces, prior to coating, are to be clean, dry, sound and smooth. Lightly sand the ensure surface 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.

### MIXING

Under no circumstances are the supplied kits to be split. The contents of the components in a kit are to be thoroughly mixed together before use, note being taken of the limited pot life necessitating short application times per kit.

### PRIMING AND COATING

Apply a generous primer coat of Pro-Struct 632 Resin and lay in a chopped strand fibreglass 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.

### CURING

Allow system to cure for seven 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 NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES



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