

## **505 FORM COATING INSTRUCTIONS**

(Temperature at application should be 60-90°F)

### **FORM PREPARATION**

- WOOD:** No preparation required if wood is free of wax, oils and excessive dirt.
- CONCRETE:** Acid etching is recommended for new beds. Used bed preparation contact technical service.
- STEEL:** Forms must be blasted to a “white metal” state. Care should be taken to use clean sand and protect clean form from airborne oils or dust prior to coating. A solvent wipe prior to coating is recommended.

### **MIXING**

- BULK:** Carefully measure two parts by volume of the resin (A-505) and one part of the hardener (B-505) into separate, clean containers that are large enough to accommodate mixing. Using a mixing blade on a low speed drill, mix the resin (A-505) while carefully pouring the hardener (B-505) into the resin (A-505). Mix completely, taking care to mix the sides and bottom of container for three (3) minutes.
- KITS:** Using a mixing blade on a low speed drill, mix the resin (A-505) while carefully pouring the hardener (B-505) into the resin (A-505). Mix completely, taking care to mix the sides and bottom of container for three (3) minutes.
- APPLICATION:** Application to bare, rough concrete forms may require a priming or wetting coat to prevent outgassing. This step consists of the application of a very thin squeegee coat that is “worked” in with a 3/8 inch nap roller and allowed to tack or fully cure prior to the finish coat.

Pour the mixed material in 4” ribbons across horizontal forms. Use a ribbed fiberglass roller or notched squeegee to spread evenly over entire form. It may be necessary to follow squeegee applications with a short nap mohair roller to evenly distribute the material. Apply all mixed material as quickly as possible. The mixed material should be applied within 10 to 30 minutes (depending on temperature). **DO NOT SCRAPE SIDES OF MIXED CONTAINER AFTER MIXING!**

Once the material is spread evenly to all parts of the form it should be allowed to level and cure. Avoid over-working the material.

Thickness can be adjusted by selecting the depth of the notches on the roller or squeegee or by calculating the amount of material required to produce a specific thickness over a specific area. Allow 6-24 hours (depending on temperature) before use or sanding (if desired).