



Application Procedures

X-Bond over solid timber floorboards

Step 1 Preparing the Substrate:

Install cement sheets over existing floorboards. The sheets should be glued down and then secured with screws (do not use nails).

Apply fibreglass mesh over all joins and secure with staples. This will help eliminate movement between sheets and aid in the prevention of cracking.

Clean surface a damp mop to remove dust and debris. Avoid using excess water.

Step 2 Apply X-Bond primers:

Ensure surface has been thoroughly cleaned.

Stir **X-Bond** liquid thoroughly. Apply 1 -3 coats of **X-Bond** liquid thin and evenly on cement sheets to act as primer. Allow each coat to dry before applying the next. Apply coats of primer until the surface is tacky.

Step 3 The X-Bond Cement Mix:

1. **X-Bond Integral cement screed**

Combine the following ingredients to make each mix of the **X-Bond Integral** cement screed:

Half bag of Stone Tex (imported sand and cement)

1 Gallon of (diluted) X-Bond liquid

1 8oz container of Pre-Stain pigment if colour is desired

Note: It is best if one person makes the mix while several people apply it.

OR

2. **X-Bond cement screed** (for Pre-Stain process)

Combine the following ingredients to make X-Bond screed:

4 parts triple washed white sand

3 parts cement (Grey or Brighton Lite depending on required colour)

Add small amounts of X-Bond liquid whilst mixing to achieve a consistent smooth paste

Step 4 Applying X-Bond Mix – Scratch Coat:

Use a boat or pool trowel to apply a scratch coat of **X-Bond** cement mix over tiles. It should be thick enough to cover all joins and fibreglass mesh. This layer needs to be level but there is no need to finish it off during the drying stage.

Make sure the scratch coat is completely dry before applying a finishing coat.

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Step 5 Applying X-Bond Mix – Finishing Coat:

1. Repeat the above application of **X-Bond** primer and mixing instructions.
2. Use a gauge trowel to apply an even amount of **X-Bond** cement mix over the scratch coat (approximately 4 — 6 mm). Use a steel (pointy) trowel to smooth over and allow the surface to touch dry. (Depending on the climate this drying could take from one to three hours — be prepared for either) **Do not** let the surface dry completely or it can not be smoothed over.
3. Use the edge of a pool trowel to scrap off existing ridges. Discard any scrapings. Lightly wet (sprinkle) the surface, use a pool trowel to slurry the surface and smooth off. Any attempt to smooth **X-Bond** cement before it is touch dry will cause surface bubbles and delamination.
4. Allow full drying/curing times according to weather conditions. Under normal conditions, drying time is 24 hours.

Step 6 Colour Staining (not applicable if applying **X-Bond Integral**):

Note: *Colour/s should always be selected and approved by client. Test patches or samples are the recommended methods.*

1. Make sure the **X-Bond** screed is completely dry. Use a soft broom to sweep the floor. It is important that no debris of any kind is on the floor when the staining process begins. The stain penetrates into the **X-Bond**, any residue, debris or dust will keep the stain from penetrating.
2. Combine entire contents of 8 oz colour pigment to 4 litres of **Pre-Stain** Base. Thoroughly **stir mixture** to ensure the pigment has completely dissolved. Do this each time before applying stain. **Never shake Pre-Stain mixture.**
3. Pour **Pre-stain** into the spray gun pot using a filtered funnel. Apply colour/s using a HVLP (High volume low-pressure) spray. **Do not** apply heavy coats of stain. **Do not** allow puddles to form on the surface. Apply as many coats of stain as needed to achieve desired colour. (Same colour or different colours can be applied.)
4. **Stain needs to be completely dry before applying a sealer.** If the climate is not hot and dry, please allow stain to dry over night before applying a sealer.

Different effects can be achieved during the staining process:

Mottled Effect — apply colours wet on wet. This is difficult over large areas.
Leather Effect — apply a light colour, let it dry and then apply a dark colour

Step 7 Sealer Application:

X-Crete 500 - Matt Sealer

X-Crete 500 is a solvent based sealer and can be used on exterior and interior surfaces. The matt finish is a penetrative sealer and does not add any sheen to the surface creating a natural finish. **Use only in well ventilated areas.**

1. Apply 2 thin and even coats of **X-Crete 500**. Apply both coats with a 5 — 6 mm roller sleeve allowing first coat to dry before applying a second coat. **Do not** allow puddles to form on the surface. If using X-Crete 500, all works are now complete.

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X-Poxy — Hi Gloss Sealer

1. Apply 1 thin and even coat of ***X-Crete 400*** to surface using a HVLP (High volume low-pressure) spray. ***X-Crete 400*** acts as a primer for the ***X-Poxy***. **Do not** allow puddles to form on the surface.
2. Stir ***X-Poxy*** Part A thoroughly and mix with ***X-Poxy*** Part B on a ratio of 4:1 (4 Part A to 1 Part B).
3. Apply 2-3 thin and even coats of ***X-Poxy*** with a roller sleeve. Under normal conditions a 9mm roller sleeve is recommended. ***X-Poxy*** will appear milky white when applied but will dry clear. **Do not** allow puddles to form on the surface. Allow at least 8 hours between coats. If weather conditions are hot and dry, one coat can be applied in the morning and one in the afternoon. Allow each coat to dry before applying the next coat.
4. After last coat of ***X-Poxy*** has been applied, allow 4 to 7 days curing time. Whilst curing, do not allow traffic access to prevent damage occurring. Once cured, continue to the next step, ***Crystal Coat***.

Step 8 Crystal Coat:

Crystal Coat is an acrylic maintenance coating that is applied over ***X-Poxy*** high-gloss finish. Apply 2 thin and even coats with a polyester cotton mop (specially made for applying sealers). Wring out mop to avoid dripping. **Do not** allow puddles to form on the surface. Allow first coat to dry completely before applying the second coat.

For further information on floor maintenance, refer to ***X-Bond/Pre-Stain*** maintenance procedures.

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