

### PRODUCT DESCRIPTION

Stonchem 828 is a conductive and spark-proof, vinyl ester lining system applied at a nominal thickness of 3.5 mm. The mortar, engineering fabric, and mortar sequencing provides a smooth, heavy-duty, conductive and non-sparking chemical barrier which is resistant to thermal shock, thermal cycling, static cracks, permeation and abrasion. The Stonchem 828 system has excellent resistance to a broad base of chemicals, including hydrofluoric acid, strong organic acids, caustics, solvents and moderate to strong inorganic acids.

### USES, APPLICATIONS

- Pumping stations
- Trenches
- Truck ramp containment
- Pulp liquor storage
- Heavy-duty chemical process flooring
- Tanker loading/unloading areas

### PRODUCT ADVANTAGES

- Excellent chemical resistance to hydrofluoric acid
- Carbon filled topcoat
- Mortarcoat for added abrasion resistance
- Engineering fabric resists cracking
- Factory proportioned units for easy application
- Conductive and non-sparking

### CHEMICAL RESISTANCE

Stonchem 828 is formulated to resist a variety of chemical solutions. Refer to the Stonchem 800 Series Chemical Resistance Guide, which lists reagent concentration and temperature recommendations for each product.

### PACKAGING

Stonchem 828 is packaged in units for easy handling. Each unit consists of:

#### Mortar

3.25 cartons of Stonchem 800/820 Liquids.

Each carton contains:

- 2 jars of Peroxide
- 2 cans of Resin

6.5 bags of 820 Mortar aggregate

#### Engineering Fabric

1 roll @ 18.58 m<sup>2</sup> roll

### PHYSICAL CHARACTERISTICS

Compressive Strength (ASTM C-579)	76 N/mm <sup>2</sup>
Tensile Strength (ASTM D-638)	19 N/mm <sup>2</sup>
Flexural Strength (ASTM C-580)	55 N/mm <sup>2</sup>
Flexural Modulus of Elasticity (ASTM C-580)	6.8 x 10 <sup>3</sup> N/mm <sup>2</sup>
Hardness (ASTM D-2240, Shore D)	85-90
Abrasion Resistance (ASTM D-4060, CS-17)	0.1 gm max. weight loss
Thermal Coefficient of Linear Expansion (ASTM C-531)	2.1 x 10 <sup>-5</sup> mm/m°C
Color	Black
Cure Rate (@21°C)	4 to 6 hours tack-free 24 hours chemical service
VOC (ASTM D-2369, Method E)	820 Topcoat 48 g/l 800/820 Liquids 53 g/l

**Note:** The above physical properties were measured in accordance with the referenced standards. Samples of the actual floor system, including binder and filler, were used as test specimens. All sample preparation and testing is conducted in a laboratory environment, values obtained on field applied materials may vary and certain test methods can only be conducted on lab made test coupons.

#### Saturant

0.7 carton of Stonchem 800/820 Liquids.

Each carton contains:

- 2 jars of Peroxide
- 2 cans of Resin

#### Mortarcoat

1.5 cartons of Stonchem 800/820 Liquids.

Each carton contains:

- 2 jars of Peroxide
- 2 cans of Resin

3 bags of 820 Mortarcoat aggregate

## Topcoat

1 carton of Stonchem 820 Series Topcoat

Each carton contains:

- 2 jars of Peroxide
- 2 cans of Resin

## COVERAGE

Each unit of Stonchem 828 will cover approximately 16.72 m<sup>2</sup> at a thickness of 3.5 mm.

**Note:** Coverage rates shown are theoretical. Actual coverage rates may vary. Make necessary allowances for the condition of the surface to be coated, working conditions, waste, spillage, experience level and skill of the installers, etc.

## STORAGE CONDITIONS

Store all components between 10 to 24°C in a dry area. Keep out of direct sunlight. Avoid excessive heat and do not freeze. The shelf life is 6 months in the original, unopened container. Store all engineering fabric in a clean and dry area.

## SUBSTRATE

Stonchem 828, with the appropriate primer, is suitable for application over concrete and the following uncoated newly applied Stonhard mortars and grouts: GS, HT, UR, UT, TG6, TG8 CR5 and PM8. For questions regarding other possible substrates or an appropriate primer, contact your local Stonhard representative or Technical Service.

## SUBSTRATE PREPARATION

Proper preparation is critical to ensure an adequate bond and system performance. The substrate must be dry and properly prepared utilizing mechanical methods. **For existing coated surfaces, the coating must be completely removed back down to an intact mortar or substrate. Once the coating is removed, prime the prepared surface with Stonchem epoxy Primer and broadcast with silica aggregate to refusal. Remove any excess silica aggregate prior to system overlayment. Omitting these steps could result in uncured material.** Questions regarding substrate preparation should be directed to your local Stonhard representative or Technical Service.

## APPLICATION GUIDELINES

For optimal working conditions, substrate temperature must be between 15 to 27°C. Cold areas must be heated until the slab temperature is above 13°C to ensure the material achieves a proper cure. A cold substrate will make the material stiff and difficult to apply. Warm areas or areas in direct sunlight must be shaded or arrangements made to work during evenings or at night. A warm substrate (15 to 27°C) will aid in the material's workability; however, a hot substrate (27 to 37°C) or a substrate directly in the sun will shorten the material's working time and can cause other phenomenon such as pinholing and bubbling. Substrate temperature should be greater than 3°C above dew point. Application and curing times are dependent upon ambient and surface conditions. Consult Stonhard's Technical Service Department if conditions are not within recommended guidelines.

## ELECTRICAL TESTING

Once the conductive mortarcoat layer has cured, it must be tested for proper conductivity. Point-to-point and point-to-ground readings should be taken and all values should fall below 5.0x10<sup>5</sup> ohms(Ω).

The floor must also be tested after the carbon filled topcoat has cured. Once the conductive sealer is tack-free, point-to-point and point-to-ground readings should be taken. All values must fall below 1.0x10<sup>6</sup> ohms(Ω).

## FIELD GEL TESTS

Due to the unique nature of the 800 Series resins, their reactivity is affected by storage conditions and age; therefore, it is important to test the cure of the materials prior to application. Gel tests should be performed for each lot of each product shipped to a job to prevent problems related to material curing.

Field gel test kits are included in every shipment of 800 Series material. One gel test contains directions and all of the necessary materials to conduct the testing. Test all lots of material prior to use.

## PRIMING

Vacuum the surface before priming, and make sure the concrete substrate is dry. The use of Stonchem 700/800 Series Primer is necessary in all applications of Stonchem 828. This ensures maximum product performance. (See the Stonchem 700/800 Series Primer Product Data sheet for details.)

**Note:** Stonchem 700/800 Series Primer must be wet during installation of the Mortar.

## APPLYING

### Mortar

Pre-mix the peroxide and resin in a 5 gallon mixing bucket on a J.B. Blender for one minute. Next, gradually add the Mortar aggregate while mixing for an additional 150 seconds. Mixing is complete when no clumps of dry material exist. For vertical applications use Vertical Mortar aggregate. Apply the mortar onto the substrate with a 3/8 in. x 3/8 in. V-notched trowel. To obtain the proper thickness, hold the trowel at approximately 45 degrees and keep the tips of the V-notches in contact with the substrate. The material must be applied evenly over the substrate with no clumps or ridges present before embedding the engineering fabric. The engineering fabric will not remove or hide any unevenness in the troweled mortar layer. If applying mortar on a vertical surface, use the same V-notched trowel to spread the material, then finish smooth with a flat steel finishing trowel. A smooth and even distribution of the material must exist on a vertical surface before embedding the reinforcement.

### **Engineering Fabric**

Place the engineering fabric on the mortar immediately after the mortar is applied. Press the fabric onto the mortar using a dry, medium nap roller. Overlap adjacent fabric 1/2 in. and immediately apply the saturant.

### **Saturant**

Mix the peroxide and resin in a 5 gallon mixing container using a heavy-duty, slow-speed drill (400 to 600 rpm) with a mixing blade for one minute. Apply the saturant to the engineering fabric with a saturated medium nap roller. To wet the roller, dip it into the mixing bucket. Always work from the bucket. Do not pour the saturant directly onto the glass. This will decrease the saturant's coverage. If the air temperature is high, the use of plastic mixing buckets will increase the pot life of the material. The fabric is completely saturated when white strands are no longer present. When the fabric is completely saturated, roll with a ribbed roller to release air pockets in the reinforcement and to embed the fabric into the mortar. To saturate the overlaps, roll several times over the length of the overlap with a saturated roller, then roll with a ribbed roller several times until the overlap is no longer visible. Allow the mortar, fabric and saturant to cure (usually 4 to 6 hours) before proceeding.

### **Mortarcoat**

Lightly sand the fabric/saturant layer with a sanding disc attachment in areas with protruding fibers. Pre-mix the peroxide and resin in a 5 gallon mixing bucket with a heavy-duty, slow-speed drill (400 to 600 rpm) with a mixing blade for one minute. Next, gradually add the Mortarcoat aggregate while mixing for an additional two minutes. For vertical applications, use Vertical Mortarcoat aggregate. Mixing is complete when no dry clumps of material exist. Pour the material onto the floor and spread out with a 15 mil notched squeegee. Backroll the area with a medium nap roller to remove squeegee lines. The material may appear rough at first but will level out to a smooth finish. For vertical surfaces, use a large steel trowel or knife to pull an initial coat of vertical material onto the wall, then finish smooth with a flat rubber squeegee.

**Note:** If the application requires a conductive system, you must test the mortarcoat layer for conductivity using the megger to ensure it is within the proper range. The conductivity of the mortarcoat layer must be below  $1 \times 10^8$  ohms at 500 volts.

### **Topcoat**

Lightly sand the Mortarcoat in areas where protrusions exist. Vacuum the area completely. Mix the peroxide and resin in a 5 gallon mixing container using a heavy-duty, slow-speed drill (400 to 600 rpm) with a mixing blade for 2 minutes. Pour the material onto the floor and spread out with a 15 mil notched squeegee. Backroll the area with a medium nap roller to remove squeegee lines, using long roll strokes to decrease the visibility of roller lines. For vertical surfaces, pour a bead of material along the base of the wall and, using a medium nap roller, roll the material onto the vertical surface. The wet film thickness of the coating is 250 to 300 microns. Check the thickness with a wet film gauge.

**Note:** If the application requires a conductive system, you must test the finished system for conductivity using the megger to ensure it is within the proper range. The conductivity of the final system should be below  $1 \times 10^9$  ohms at 500 volts. A static control report detailing the resistance readings over the entire area must be filled out and submitted to the customer.

### **PRECAUTIONS**

- Avoid contact with Stonchem 828 resin (vinyl ester resin and styrene monomer) and peroxide (catalyst/organic peroxide), as they may cause skin, respiratory and eye irritation.
- Acetone is recommended for clean up of Stonchem 828 resin (vinyl ester resin and styrene monomer) and peroxide (catalyst/organic peroxide) material spills. Use these materials only in strict accordance with the manufacturers' recommended safety procedures. Dispose of waste materials in accordance with government regulations.
- **The use of NIOSH/MSHA approved respirators using an organic vapor/acid gas cartridge is mandatory.**
- The selection of proper protective clothing and equipment will significantly reduce the risk of injury. Body covering apparel, safety goggles or safety glasses and impermeable gloves are required.
- In case of contact, flush area with water for 15 minutes and seek medical attention. Wash skin with soap and water.
- If material is ingested, immediately contact a physician. **DO NOT INDUCE VOMITING.**
- Use only with adequate ventilation. Inhalation of vapors may cause severe headaches, nausea and possibly unconsciousness.

### **NOTES**

- Safety Data Sheets for Stonchem 828 are available online at [www.stonhard-europe.com](http://www.stonhard-europe.com) under Products or upon request.
- Specific information regarding chemical resistance of Stonchem 828 is available in the Stonchem 800 Series Chemical Resistance Guide.
- A staff of technical service engineers is available to assist with installation or to answer questions related to Stonhard products.
- Requests for literature can be made through local sales representatives and offices or corporate offices located worldwide.

**IMPORTANT:**

Stonhard believes the information contained here to be true and accurate as of the date of publication. Stonhard makes no warranty, expressed or implied, based on this literature and assumes no responsibility for consequential or incidental damages in the use of the systems described, including any warranty of merchantability or fitness. Information contained here is for evaluation only. We further reserve the right to modify and change products or literature at any time and without prior notice.

**STONHARD** A Division of **StonCOR**<sup>Group</sup>

[www.stoncor-europe.com](http://www.stoncor-europe.com)

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Belgium	+32 67493710	Spain/Portugal	+351 707200088	Germany	+49 240541740
France	+33 160064419	United Kingdom	+44 1256336600	The Netherlands	+31 165585200
Poland	+48 422112768	East Europe	+31 165585200	Italy	+39 02253751