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Sociedad Industrial
de Britagem de Pedra

METHOD STATEMENT

SIB Extreme Flow

self levelling topping

MAY 2018

Surface preparation

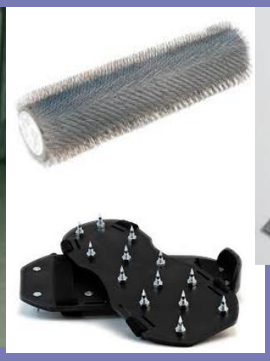
Prepare Surface according to Surface preparation Guide
Surface must be
1. Dry (both on the surface and inside)
2. Levelled
3. Cohesive
4. Even
5. Free of cracks (to be pre-treated)
6. Clean, free of dust and debris and loose materials and free of oils, grease or other chemical impurities

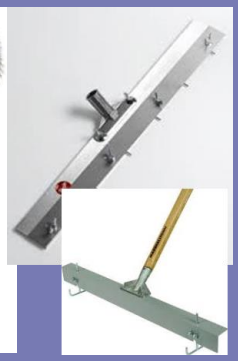
Recommended primers:
Epoxy SIB Aquapox or SIB E 100 with Sand carpet (1,3/1,8 mm)
SIB ECO Primer with mortar – textured Surface

Check Edge Isolation - if SIB Extreme Flow can run under the Edge isolation it can cause problems in the final appearence of the floor. Make sure it is well sealed.
Check that you have no dead spots, spills or loose particles on the primed floor
Make sure that you have stable temperature on floor and in room
Prefered between 10°C to 25° C
Floorheating should be turned off. Heavy diriect sunlight and heavy draft should be prevented

FINISH AROUND EDGES, WINDOWS, DOORS AND INSERTS
Clear out client expectations with the possible options and take precautions before installing the floor. Will there be a skirting board? And if not – how is the floor finished next to the walls?

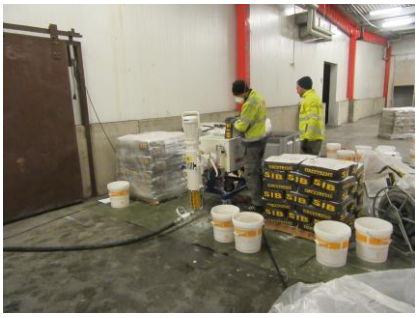
Tools Needed





Mixing machine or Hippo Mixers
Spike Shoes - Hight adjustable Gauge Rake- Metallic Spike roller with **30 mm fine spikes**
If tools are new spray them with a hydro repellent for easier cleaning and better performance

Prepare work area
Prepare a work area where you have good access to all work areas and cleaning after finishing
Make sure you have access to the power supply you need for machines
Make sure that you cover all areas where you do not want to stain or have risk to splash on
Be prepared for incidents – have buckets and cleaning gear ready if needed



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Screeding the floor

Mixing
Premix the Liquid B component – When mixerpump is used put a pump into the container with liquid.
Use intensive mixing accessories for the mixerpump.
Make a test mix to adjust the mixing rate – follow the instructions on the given material. It will normally be around 36 % B component to Powder in weight.
Once mixing rate is established make sure it is always the same.
Manual mixing – mix for minimum 2-3 minutes – mix till the mix is homogeneous and without lumps and all pigments are integrated in the mix. Make a flow test and make sure that the material has the right consistency.
When the floor is screeded manually with Hippo Mixer or equivalent you can use two mixers to secure an even material flow

When hand mixers are used, we recommend sieving the mix through a 2-3 mm mesh after mixing. That will eliminate the risk of lumps caused by exposure to moisture during transport, storage or mixing.

Thickness
We recommend to screed the floor in 12 mm thickness, so the finished floor is minimum 10 mm after grinding and finishing work
A good base is essential since the thickness of the screed is taken from the floor base
Consumption 21/22 kg + approx. 7 l liquid B component for 12 mm thickness
To achieve an even finish the floor should be screeded in even thickness

Pouring the material evenly
The material is poured out on the floor
One person with spike shoes use the Gauge Rake to spread the Extreme Flow self leveler evenly on the floor.
Another person with spike shoes follow right after with a spike roller to even out marks and smoothen the floor. This process takes air out of the floor leveling compound and evens the floor. For ideal and even application you should work with a team of approximately 5 people

Curing
At 21° C the SIB Extreme Flow cures in 48 hours. If temperature is lower curing will take longer.
SIB Extreme Flow should be curing at stable temperatures.
The SIB Extreme Flow cures without being covered and the material should not be touched during the curing. Touching the material with a trowel after that it has started to settle may cause separation and cracking in the material.

Precaution
It is ideal to finish the floor once you have started to work on it.
Before the floor has been fully finished it is sensitive to water and other liquids that can penetrate and make marks in the floor.
The floor needs to breathe also after the curing process if finished, why the floors should only be covered with breathable materials

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Grinding the floor

Metal diamonds
Do the grinding with a constant slow speed always overlapping 50 % the previous grinding line
You should always be checking that parts of the machine or big particles are not dragged around and cause scratching in the floors
Continue with crossed grinding till the surface is even and all scratch marks form the previous steps are gone
Crossed grinding is always the best – North – South, Eeast –West
Repeat the grinding if needed – after the initial grinding the floor should d be uniform

30 Grit Metal We recommend to start rough/deep
Going rough and deep on the first grinding steps makes the floor even and more uniform

Remember that the first grinding step is the deepest an the one that set the standard for the finished floor.
All dead spots should be evened out at this grinding stage.
Clean between Grinding Steps – make sure you do not drag lose particles around that scratch the floor

70 grit metal – the speed on the grinder can be turned up a bit

120 grit metal - the speed on the grinder can be turned up a bit

Comments on Grinding
We recommend to go deep to get the best result. If you due to time issues or budget jump over grinding steps be sure that you always have gone so deep in the grinding that you have taken off the surface film layer formed from the curing of Extreme Flow.

Bigger machines save time and give a flatter grinding with less effort

Edge Grinding
Perfect EDGE work require a lot of tools and
perfect edge work takes a lot of work hours
Follow the same steps as in the grinding of the floor

Resin Diamonds
Before starting with the resin diamonds the floor should be totally even and all rests of resin in the surface layer should have been removed
Going into the resin diamonds we go from grinding to polishing
50 Grit Resin
Do the polishing with a constant slow speed always overlapping 50 % the previous grinding line
Continue till all scratch marks from the 120 grit metal are gone

Blow the floor with high pressure air to get the dust out of the pores
Vacuum the floor well and clean it afterwards with a scrubber dryer with brush and a good vacuum - the next step is the pore filling

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Pore Filling And Floor finish

Pore Filling
Make a sample of the porefiller the day before – Make 3-4 small tests with different concentrations of pigment
Use the mix that gives the right color match when dry
Porefilling will give you a better finished and smooth floor that is easier to clean
Mix the powder component of SIB ECO FILL with approximately with 30 % water
Mix till you have a homogeneous paste with a good workability – adjust with water and keep the same mixing rate in the application

Spread the slurry over the floor with a rubber rake. Spread it evenly over the floor in a thin layer and work it well into the pores in the floor with a slow speed swing machine with flexible blades.
Go over the same place several times
SIB ECO FILL is a very strong binder. Make sure that you scrape off eventual excess of material. Excess of material can stain the floor and take a lot of extra work to get off
Leave the pore filler to dry – minimum 4 hours, but best till next day

Continue Grinding with 50 Grit resin
Continue till the floor is cleaned and there is no more porefiller left on the surface
Repeat the porefilling process if necessary

Epoxy Trowel or Swing machine
With flexible plastic blades to push the material into the pores

Material spread with rubber rake
A rubber rake si used to extend the material and to take of excess of material

Hand trowel application
Make sure you get over the same spot several times to get the material into the pores

100 Grit Resin Diamonds
The grinding process is continued
A properly porefilled extreme is a very strong and dense surface why a good gloss level is achieved earlier on extreme than on traditional Concrete
If a higher gloss or a tight surface is desired continue **with 200 Grit and 400 Grit**

Extreme can be polished further after 400 grit, but if you do polish further make sure that you use diamonds that do not cause burnmarks on the surface

Water can stain the floor before the floor is sealed if it stand too long on the floor

Specially on grey or darker colors wet grinding is risky and we recommend to take necessary precautions

Clean the floor well with diamond impregnated pads - if the floor has been left at 400 grit use 400 grit of finer

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Sealing the floor

PROSIB 330 or PROSIB PLUS
Clean the floor well with a scrubber dryer with a cleaning pad
Make sure that the scrubber dryer is in good conditions – do not leave water sacking on the floor
When the floor is fully dry it is ready to receive sealer

Mix the sealer and apply on the sealer
Use a low pressure sprayer to apply the sealer evenly
Pass over with a roller and right after with a dry roller
Let dry for an hour approximately and impregnate a second time

Impregnate with SIB OIL 2K for good protection.

Low Pressure Sprayer
Ideal Sprayer for penetrating sealers

Sealer application
Sealers applied with Low Pressure Sprayer and roller

Cleaning and maintenance
Clean with PH neutral cleaning agent

To maintain sealer
Clean the floor with Concrete Soap with a certain frequency
Add a little SIB OIL 2k when needed

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