

Low-viscosity, slightly bluish-colored Methacrylate resin for hard sealing

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**Characteristics:** Plastifloor® 523 Additive is a newly developed hard methacrylic resin of low viscosity that is preferably used as a sealer for Plastifloor® coatings to improve heavy mechanical and scratch resistance as well as maintenance. The main application areas are trowel-smoothed industrial floors made of Plastifloor® 510 N and Plastifloor® 418 N. Plastifloor® 523 Additive excels in:

- Improved self-levelling
- Minimal yellowing
- Excellent chemical resistance
- Increased Solvent resistance
- High thermal endurance
- High scratch resistance by using Hardener/M
- Low tendency to staining

**Characteristic data:**

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**Plastifloor® 522**

Delivery form	Liquid, violet	
Flow time	26-32 s	68 °F (4mm DIN cup)
Density	8,34 lb/gal	DIN 53217
Flash point	+ 50 °F	DIN 51755
Curing time	30-40 min	68 °F (1% Hardener)
Shelf life	In the original container, closed, dry, cool, frost-free max. 6 months	
Bundle	55,12 lb, 22,04 lb pails 396,83 lb barrels	

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**Plastifloor® Additive 523**

Delivery form	Liquid, transparent	
Flow time	600 cps	77 °F
Density	8,43 lb/gal	77 °F
Shelf life	In the original container, closed, dry, cool, frost-free max. 6 months	
Bundle	22,04 lb, 11,02 lb cans	

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## Processing notes:

Processing: Stir up well all Plastifloor® resins before application! Pour the required preparation quantity into a mixing pail and stir in Plastifloor® Additive 523 for about 1 min by using a suitable agitator. After stirring in the Plastifloor® hardener 50 W (1 min), the sealer is poured out onto the floor and immediately dispersed evenly.

Plastifloor® 523 N is preferably applied crosswise with short hair rollers (mohair) in a layer thickness of up to 0,016 inch max (~ 0,01 gal/ft<sup>2</sup>).

Layer thickness must at least be 0,008 inch (0,005 gal/ft<sup>2</sup>) and should not exceed 0,0197 inch (0,012 gal/ft<sup>2</sup>) with 2 layers – depending on the required coating structure (smooth or coarse).

Scratch and water resistance can be ameliorated by using Hardener/M. Hardener/M leads to a mat surface. Please mind the indications on the product data sheet.

Mixing approach: 2,11 gal Plastifloor® 522 N  
0,11 gal Plastifloor® Additive 523  
2,71 oz Plastifloor® Hardener 50 W  
(5,41 oz Plastifloor® Hardener/M)

Material consumption: 0,007 – 0,012 gal/ft<sup>2</sup>

Curing time: Continue the coating work only after full hardening of the previous layer.

Temperature [°F] **	Hardener [Vol-%] *	Pot time [min]	Curing time [min]
+ 41 to + 50	2	~ 35	~ 50
+ 50 to + 68	1,5	~ 30	~ 40
+ 68 to + 77	1	~ 25	~ 35
+ 77 to + 86	1	~ 20	~ 30

\* Hardener quantity calculated on amount of Plastifloor® 523 N (Hardener 50 W)

\*\* The temperature specifications are based on resin, soil and air temperature

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**Attention:**

At temperatures below 32°F, the resin needs to be put into a warm environment before processing - minimum 41°F and add up to 2% hardener maximum. Basically accelerator cannot be added to sealers – neither as thinner nor as accelerator – due to yellowing aspects.

**Additional Information:**

Sealings with Plastifloor® 523 N should not be applied onto coatings with Plastifloor® 332 N as the coating's high flexibility in combination with the very hard sealer Plastifloor® 523 N might cause cracking on loading. Hardener concentrations of > 2 % may cause discolorations (yellowing). Furthermore, a waiting time of about 2 hours between the coating's curing and the application of the sealer has proven.

Despite the good chemical resistance of Plastifloor® 523 N, one must reckon a reduced resistance when sealing coatings based on Plastifloor® 418 N or 510 N. With these solvents (on continuous loading), a swelling by diffusion may take place after some time.

This process depends on the sealer's layer thickness. In these cases, we thus recommend a layer thickness of 0.02 inch minimum or better a double application of Plastifloor® 523 N.

**Storage:**

Methacrylate resins are subject to the handling regulations of highly flammable materials. Plastifloor resin has to be stored cool, at temperatures between 59 – 68° F and protected from direct sun.

During storage paraffin particles can be deposited. Therefore, materials have to be stirred thoroughly before processing the mixture. Please note the advice of our safety datasheet.

data concerning our products and devices as well as concerning our data and procedures are based on an extensive research work and an application technology experience. We obtain these results, with which we do not take over adhesion going beyond the respective single contract, in word and writing after best knowledge, reserve ourselves we however technical changes in the course of the product development. Beyond that our application technology service stands when desired for large consultation as well as for co-operation with the solution manufacturing and application technology problems for order. That does not relieve the user however to examine our data and recommendations before their use responsible for the own use. That applies - particularly for deliveries to foreign markets - also regarding the keeping of patent rights third as well as for applications and procedures, which are not expressly in writing indicated by us. The case of loss our adhesion is limited to indemnifications of same extent, as they plan our general terms of delivery and sales with lack of quality.