

# Altro Crete™ 4mm slip-resistant (PTV≥50)

Multi-layer polyurethane flooring  
Technical and installation data sheet

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## Product description FeRFA type 4

**Altro Crete 4mm slip-resistant (PTV≥50)** is a multi-layer system that utilises Altro Crete polyurethane self-smoothing screed in conjunction with a hard wearing slip resistant aggregate dressing. The surface is a chemically resistant coloured high-build polyurethane providing a durable and very safe monolithic floor finish, ideal for applications in the food and beverage, pharmaceutical and chemical industry.

## Standard colours

Altro Crete 4mm slip-resistant (PTV≥50) is available in a range of 6 standard functional colours for hygienic zoning and differentiation of traffic ways.

It must be noted, in common with other polyurethane screeds, lighter colours will be prone to cosmetic yellowing on exposure to UV light.

## Typical areas of use

- Wet production areas
- Food and beverage production areas
- Industrial kitchens
- Wash down bays
- Pot wash areas
- Mortuaries and chemical industries

## Advantages

- Safe slip resistant finish
- HACCP approved
- Hygienic impervious sealed surface
- Durable: good impact and abrasion resistance
- Excellent chemical resistance

## Sustainability

Altro's steps to sustainability program seeks to optimise our performance with respect to the planet's resources. Please refer to [www.altro.com](http://www.altro.com) for further information.

## Chemical resistance

Altro Crete variants offer excellent resistance to a range of chemicals, including organic food acids and alcohols, designed for industrial food and drink manufacture. However, premature contact with chemicals (including water) during the curing process may give rise to discolouration, staining and variation in gloss. In all cases of chemical spillage, it is essential that the spillage be immediately removed and the surface washed down with clean water, removing water by wet vacuum after operation. Although some chemicals may cause discolouration, this may not affect the durability and integrity of the resin screed. Please refer to Altro and FeRFA Guidance Note No.3 for further information.

## Typical physical properties

<b>Slip resistance</b>	BS7976 PTV $\geq$ 50 DIN 51130 Shoes / oil R11; V4
<b>Usable working life</b>	25 minutes @ 20°C
<b>Speed of cure</b>	Light foot traffic – 17-24 hours at 20°C Full cure – 7 days at 20°C
<b>Service temperature</b>	-40°C to 60°C
<b>Bond strength EN 4624</b>	B3,5
<b>Impact strength ISO 6272</b>	IR2
<b>Wear resistance EN 13892-4</b>	AR 0.5

### Packaging

**Altro Crete 4mm slip-resistant (PTV $\geq$ 50)** is a combination system.

**Altro Crete™ primer** is available in a 4.7kg, two-part composite pack.

**Altro Crete 2mm slip-resistant** variant in a 12.6kg, four-part composite pack.

**Altro Grip** (0.4-0.8mm) aggregate in a 20kg bag.

**Altro Crete top-coat** 4.8kg, four part composite pack.

### Coverage

**Altro Crete primer** 20m<sup>2</sup> per 4.7kg unit.

**Altro Crete 2mm slip-resistant** variant 3.6m<sup>2</sup> per 12.6kg unit.

**Altro Grip** (0.4-0.8mm) aggregate 4- 6.7m<sup>2</sup> per 20kg bag.

**Altro Crete top-coat** 8.5m<sup>2</sup> per 4.8kg unit.

Material usage is dependent upon temperature, surface profile and porosity; stated coverage rates should be referred to for guidance only and cannot be relied upon to determine exact quantities. Although stringent quality assurance processes are employed, when colour consistency is required, a single batch should be used.

### Storage

Ensure that the product is received in good order and store in a dry, frost free environment, ideally between 15°C and 20°C for at least three days before application. It is important to maintain the temperature during storage; low temperature storage will adversely affect the product application. Excessively high and low storage temperatures will affect the application and performance of the product. Store in a dry place and avoid storage in direct sunlight.

### Suitable substrates

Altro Crete may be applied to a variety of substrates including, but not limited to, concrete, polymer-modified cementitious screeds, terrazzo, 25mm marine-grade plywood (consult Altro for further guidance). For all proprietary subfloor systems refer to the manufacturer for recommendations and seek further guidance from Altro.

FeRFA, The Resin Federation, does not recommend Calcium Sulphate, Anhydrite or Hemi-hydrate screeds for overlayment with synthetic resin surfaces.

### Substrate requirements

Substrates should be dry, structurally sound and free from contamination, friable materials or laitance which may affect either the adhesion or penetration of the resin system. All residues of old paint coatings and dust must be removed. The substrate should achieve 30N/mm<sup>2</sup> compressive strength (BS EN 12504-2) and surface tensile strength 1.5N/mm<sup>2</sup> (BS EN 13892-8). Substrates must include an effective damp-proof membrane and contain residual moisture not greater than 5% by weight (75% R.H.) to BS 8203. Thin-bed synthetic resin systems follow the surface of the substrate, so it is essential that the surface regularity of flatness conforms to or exceeds BS 8204.2 class SR2 (+/- 5mm under a 2 metre straight edge). Any deviation from this may require a surface improver to be applied which must be suitable to receive an epoxy resin overlay. Please consult Altro or FeRFA Guide to the Specification and Application of Synthetic Resin Flooring for further information.

## Substrate preparation

Surface preparation is the most vital aspect of resin flooring application. Inadequate preparation will lead to loss of adhesion and failure. The substrate in question will dictate the method of preparation. In the case of a concrete floor, preparation by dust enclosed diamond floor grinder may be appropriate, or if of a sufficient area for economic reasons, should be lightly shot blasted to leave a textured surface free from contamination. If the floor has been treated with a cementitious surface improver, then the surface should be prepared in accordance with the manufacturer's recommendations, or abraded with an STR machine followed by thorough vacuuming.

Treatment of local repairs such as cracks and holes, improvement or modification of levels and removal of high spots, should be undertaken prior to the flooring installation. A mechanical rebate should be formed around the perimeter of the installation to avoid weakness at the most vulnerable zones, evenly distributing loads and stresses and preventing ingress of aggressive media to the subfloor and bond line.

A chase should be provided at all peripheral edges, parallel to expansion joints, at thresholds, feather edges, at free edges of a cove, where dissimilar flooring materials join and at day joints. This is normally formed by casting a chase when the concrete is laid or by cutting using a wet cut concrete saw. The preferred dimensions of the rebate are twice the thickness of the screed in depth and twice the thickness of the screed in width. Anchorage rebates should be provided as close to the perimeter as is practicable.

Please consult Altro or FeRFA's Guide to the Specification and Application of Synthetic Resin Flooring for further guidance.

## Planning

Before proceeding with the installation, careful consideration should determine the best way of installing the Altro system. Efforts should be made to minimise day joints and optimise the open time of the product (i.e. minimise the distance between mixing and laying). It is best to also consider the effect of external influences on the final installation (i.e. direction of light from windows etc.). Time spent at this stage will be invaluable towards the success of your installation.

Altro recommend that stainless steel mixing, laying and application tools are used in this process. Metal transfer from mild steel tools may result in discolouration of lighter colours which will be unacceptable to your customer. Please contact Altro for further guidance.

## Application

The following application guide is based on laboratory and simulated site conditions. However, when installation conditions differ appreciably from those detailed by Altro, the performance characteristics of both mixing and laying may not be as expected. To achieve the best results at all times please endeavour to establish the correct conditions which in turn will allow the materials to be laid effectively and meet your customer's expectations.

## Installation conditions

Apply in well ventilated areas. Both the slab and air temperature should be between 10°C and 25°C. It is not advisable to mix and lay polyurethane resin products outside that range. Ambient conditions should be maintained at least 3°C above dew point or below 75% R.H. during the initial stages of cure. At site temperatures below 10°C cure times will be substantially increased unless some form of external heating is used. Avoid using heating sources that give rise to high levels of humidity, such as those burning fossil fuels. It must be recognised that the concrete slab temperature will generally be lower than the air temperature, often as much as 10°C, and this will govern the rate of cure. As the resin flooring cures, in condensing conditions moisture vapour may condense onto the surface and cause 'blooming', a permanent clouding of the surface.

Cold substrates can give rise to pinholes through the uncured resin. In unheated areas raise the substrate temperature prior to application and maintain the temperature of the substrate during application.

## Mixing equipment

- Slow speed drill (200-500rpm), such as MM17 \*
- Mixing paddle, such as MR2 60B \*

\* All tool number references relate to Refina Ltd 01202 632 270

## Priming the substrate

When the surface quality of the finished Altro Crete variant is important for hygiene or aesthetic reasons, a primer should be used. Priming helps to achieve a uniform finish, prevent bubbles and maximises adhesion.

An Altro primer should be selected which is suited to the installation, and appropriate for the nature and moisture content of the substrate (seek further guidance from Altro). For substrates less than 75% RH (BS8203) Altro Crete primer is recommended. For substrates with greater than 75% RH (BS 8203) an effective damp proof membrane should be laid such as Altro Proof™.

If Altro Proof is used this may be installed instead of Altro Crete primer. The primer should be well sealed and inspected for pinholes prior to the application of the Altro Crete system. A further coat of Altro Proof may be necessary to prevent the pinholes from reflecting through. Any areas of under-thickness should be addressed prior to installing the system. The Altro primer should be applied in accordance with the product data sheet. If the over-coating time period for the primer is exceeded, the surface should be lightly abraded and vacuumed before further coats are applied.

Do NOT seed the primer with aggregate, experience shows that this can lead to pinholes from entrapped air.

## Product installation

Using a slow speed drill and paddle thoroughly mix together the Altro Crete 2mm slip-resistant variant base, colour pack and hardener. Pour the entire mixed base, colour pack and hardener contents into a suitable clean polypropylene or stainless steel mixing vessel. The Altro Crete 2mm slip-resistant aggregate should be added gradually into the pre-mixed binder, whilst continuing the mixing action, and mix for a further 2-3 minutes. Incorrect mixing, either too short or too long may affect the application and cause imperfections in the floor finish such as pinholes or unevenness. Variations in the mixing time may produce variations in the colour or surface texture. Care should be taken to ensure that any material adhering to the sides, bottom and corners of the mixer is thoroughly blended in. If the mixing area is not adjacent to the laying area the time required to transfer the mixed material will reduce the open installation time.

### **Remember to always use the correct PPE.**

Using a clean stainless steel trowel or pin rake apply the Altro Crete system to the prepared primed substrate. Ensure that the system is being laid to the desired depth. The use of a spiked roller will ensure good air release and a smooth finish.

While the Altro Crete is still wet the Altro Grip aggregate should be broadcast into the system until fully blinded to excess or saturation. This is to ensure an even slip-resistant profile that is free from bald patches. (This should not be done before 12 minutes and is critical that this is not done too late as the aggregate will not penetrate sufficiently.) Take care to broadcast the system in such a way as not to cause 'ripples' in the Altro Crete. Because the flooring is hand finished, there may be slight variations in the surface appearance resulting from the trowelling. A skilled operative will endeavour to keep these to a minimum so that the overall appearance and performance of the flooring will not be affected. The system must be sealed with one coat of Altro Crete top-coat. Ensure the surface of the resin screed is contamination-free and all the loose aggregate has been removed and thoroughly vacuumed as necessary. Pour the contents of the Altro Crete top-coat hardener and colour pack into the base unit and using a slow speed drill and paddle thoroughly mix the contents for 30 seconds. Add the Altro Crete top-coat aggregate while mixing and mix for a further two minutes. Apply the seal coat to the screed using a dense polypropylene foam squeegee, taking time to work the seal into the surface, ensuring that all porous areas of system are fully satisfied. Roll the surface with a short nap synthetic roller to remove excess material and leave to cure.

## Coving detail

All coving detail where chemical resistance is required should be installed using the Altro Crete™ cove variant, which is specifically designed to be used in conjunction with the Altro Crete™ variants. This product complements the floor but does not have the same appearance as the floor system. This should be identified to the end user.

## Joints

The spacing of movement joints must be determined by the design of the subfloor. All live movement joints in the subfloor must be continued through the resin flooring. In all instances the type and positioning of movement joints should be agreed at the design stage between all parties concerned. Please refer to Altro or FeRFA's Guide to the Specification and Application of Synthetic Resin Systems for further guidance. All joints should be filled with Altro Expand™ flexible jointing compound. Please see Altro Expand data sheet for further information.

## Protection

Whilst of an extremely durable nature these floor systems must be thoroughly protected from the rigours and abuse that exist during the ongoing contractual works. The resin floor should reach full chemical cure in seven days at 20°C. Untreated felt paper will suffice as protection from light traffic, however if protection is required from other trades then the following protection option should be considered. Where heavier access is required then a more suitable medium to take the loadings, such as shuttering ply or Correx by Cordek, should be placed on top of the untreated felt paper. The resin system should have cured for at least 48 hours prior to placing the protection. No polyethylene sheets, linseed-treated hardboard, print or dyed card should be placed in contact with the resin surface. All joints in the protection medium should be taped, and all accidental spillages should be recovered immediately by removal and reinstatement of the protection. Damage will occur to the system if the above guidance is not followed.

## Cleaning (during installation)

All tools and equipment should be regularly cleaned using Altro Solve™ PU to reduce build up and maintain the quality of the installation. **Ensure that the correct PPE is worn at all times.**

## Disposal

Due diligence must be adopted if accidental spillages occur. Recover using inert absorbent granules, transferring into a suitably marked container. Disposal of all empty containers and accidental spillages should be in accordance with the local waste disposal authority.

## Cleaning guidance

Optimum slip resistance can only be maintained with regular cleaning. The texture of the surface will require mechanised cleaning making use of the blue Altro Unipad™ or similar or the use of a long-handled scrubbing brush; mop cleaning will not be effective. Steam cleaners and / or hot pressure cleaners should not be used on the floor or walls. A cold / ambient pressure washer may be used if required, but the pressure should not exceed 1400psi. Warm water will offer improved cleaning. Correct maintenance and entrance matting should enhance the longevity of the floor.

- Sweep or vacuum the floor to remove debris
- For normal cleaning, dilute an alkaline detergent such, as Altro Clean 44 or similar, by 1:40 in clean water
- Alternatively, dilute by 1:10 for infrequent heavy cleaning
- Liberally apply the water and detergent solution to the floor, scrubbing with a deck scrubber or slow-speed (< 400rpm) scrubbing machine and Altro UniPad or similar
- Pay particular attention to areas where residues may accumulate, such as internal corners of perimeter coves and around columns etc
- If possible, allow the detergent solution to remain on the floor for several minutes to break down deposits, but not sufficiently long to allow the solution to evaporate
- Remove the solution by wet vacuum recovery and follow this with a fresh water rinse, or rinse the solution into drains if permissible
- It is important that all detergent residue is removed from the textured surface of the floor. Detergent may become slippery which affects safety, or sticky which attracts and holds more dirt

Altro Clean 44 and Altro Unipads are available through the Resins Sales Desk.

Please refer to the most up-to-date technical documents, including safety data sheets, for the Altro resin variant prior to beginning your installation.

### To order

**E-mail [ResinSalesDesk@altro.com](mailto:ResinSalesDesk@altro.com)**

**Call 01300 320620**

**Fax 01300 321122**

**NOTE:** "Altro Ltd" ("Altro") endeavours to ensure that advice and information given in Product Data Sheets, Method Statements and Material Safety Data Sheets (all known as Product Literature) is accurate and correct. However, where Altro has no control over the selection of its products for particular applications, it is important that any prospective customer, user or specifier, satisfies him / herself that the product is suitable for the intended application. In this process, due regard should be taken of the nature and composition of the background / base and the ambient conditions both at the time of laying / applying / installing / curing of the material and when the completed work is to be brought into use.

However, as site conditions and the execution of the work are beyond our control, we accept no resultant liability.

Altro's policy is one of continuous research and development and we reserve the right to update our products and information at any time without prior notice.

**If you'd like any more information or guidance please get in touch, we're here to help.**

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