

KLB-SYSTEM ACRYL

AC 357

Rapid-setting acrylic resin mortar for renovations and repair works

Packaging units

Article no.	Packaging	Content (kg)	Units/pallet
AK0018-17	Combo packaging	25.00 kg	40



Product characteristics

Mixing ratio parts by weight	A : B = 1 part by weight resin : 8 parts by weight powder
Processing time	10 - 20 minutes at 20 °C / 68 °F
Processing temperature	Minimum: 0 °C / 32 °F Optimum: 18 °C / 61.4 °F Maximum: 30 °C / 86 °F
Curing time (accessibility)	1 - 2 hours at 20 °C / 68 °F
Further coatings	After curing and accessibility
Consistency	Mortar consistency
Consumption	2 kg/m ² for 1 mm of layer thickness or 12 kg/m ² for 6 mm of layer thickness
Packaging	Combo packaging 25 kg
Colours	Grey (similar to concrete)
Shelf life	6 months (originally sealed)

Product description

KLB-SYSTEM ACRYL AC 357 is a ready-to-use 2- component acrylic resin mortar.

KLB-SYSTEM ACRYL AC 357 has excellent application properties and, above all, is rapid-setting. With a processing time of 10 - 20 minutes, the mortar can resist mechanical load after 60 - 120 minutes.

KLB-SYSTEM ACRYL AC 357 is used as repair and mortar coating for areas with mechanical load where a fast return to the use of the floor is important. Usually, the mortar is being applied in layers of 5 - 15 mm. It is recommended to add fire-dried quartz sand for an increased thickness of layers. See the section about mixing! The mortar cures shrinkage-free and achieves high bending tensile and compressive strength. The product is suitable for traffic areas, for the repair of commercially and industrially used areas, for the rigid sealing of joints, holes in the asphalt, connecting ramps and so on, for interior and exterior use.

Area of application

- Fast area and repair mortar.
- For production, storage, and working areas.
- For vehicle traffic and parking areas.
- As bedding layer for subsequent coatings.

Product features

- very rapid-setting
- quickly accessible
- ready-to-use
- low-shrink
- for renovations and repair works
- good resistance to water and chemicals
- reworkable after 1 hour
- high mechanical resistance

Technical data

Solid content	100	%	KLB method
Density - Component A+B	2.01	kg/l	DIN EN ISO 2811-2 (20 °C / 68 °F)
Water absorption	< 0.2	weight-%	DIN 53495
Flexural strength	> 22	N/mm ²	DIN EN 196/1
Compressive strength	> 80	N/mm ²	DIN EN 196/1
Shore-hardness D	80	-	DIN 53505 (after 7 days)
Flashpoint	Component A: 11 °C / 51.8	°F	DIN 51755

The values established in tests are average values. Deviations from the product specification may occur.

Tests

- Product is compliant with DIN EN 13813: 2003-01.

Build-up of coats

- Prime with **KLB-SYSTEM ACRYL AC 20**, consumption 0.4 kg/m², openly scattering with quartz sand 0.7/1.2 mm.
- Apply the mortar in layers of 5 - 15 mm.
- For subsequent coatings, it is mandatory to prime with **KLB-SYSTEM ACRYL AC 20** first.

Substrate

The substrate to be coated must be even, dry, free of dust, sufficiently resistant to tension and compression as well as be free from weakly-bonded components or surfaces. Materials impairing adhesion such as grease, oil and paint residues should be removed with suitable measures. Substrates suitable for coating are concrete C20/25, cement screed as well as other sufficiently solid substrates. Screeds treated with synthetic dispersions are not always suitable, as the curing reaction of the acrylic resin can be disturbed. In case of doubt, it is recommended to create a test surface. The substrate has to have adequately high strength for the intended occupational use. The substrates to be coated should be prepared mechanically, preferably by shot blasting. The surface strength must then be at least 1.5 N/mm². For concrete, moisture content must not exceed 4.5 CM-%, remaining residual humidity. Prime the surfaces to be coated with **AC 20** and scatter them openly with quartz sand 0.7/1.2 mm.

Mixing

Components A and B are supplied in aligned mixing ratios 1 : 8. 1 kg binding agent (fluid, component A) is being blended with 8 kg of powder (component B). Depending on the desired consistency, 7.5 kg - 9.0 kg of powder (component B) can be added. Adding 7.5 kg of powder results in a very pourable mortar, adding 9 kg of powder makes it more mouldable. **To ensure a completely cured material, stay within the recommended amounts of additives!**

Use a compulsory mixer for blending the components. The mixing time depends on the intensity of the mixer and should take approx. 1 - 2 minutes. If quartz sand is added for filling large holes, this is done after the addition of powder component B.

Additive recommendations:

For layers up to 15 mm:

Without adding sand

For layers 15 to 30 mm:

10 - 12 kg of dried quartz sand (3 - 5 mm)
for each 25 kg unit of **AC 357**.

For layers 30 to 50 mm:

4 - 4.5 kg dried quartz sand (3 - 5 mm) and
8 - 9 kg quartz sand (5 - 8 mm)
for each 25 kg unit of **AC 358**.

Apply immediately after mixing.

Processing

Distribute the fresh mixture in small quantities on the floor and smooth out with a squeegee or trowel. For larger surfaces, it is recommended that the mortar is drawn off and smoothed in with gauges. However, the areas must then be limited because of the rapid curing. Maximum processing time is 10 minutes. Processing may also be carried out at lower temperatures down to 0 °C / 32 °F.

Floor and air temperature must not fall below 0 °C / 32 °F. If a dew-point situation arises, regular curing will not be possible with hardening problems to occur. The specified curing times apply for 20 °C / 68 °F; temperatures below this require longer processing and curing times, while higher temperatures require shorter times.

Cleaning

To remove fresh contamination and to clean tools, use thinner **VR 119** immediately. Hardened material can only be removed mechanically.

Storage

Store in dry and at frost-free conditions. Ideal storage temperature is between 10 - 20 °C / 50 - 68 °F. Bring to a suitable working temperature before application. Tightly re-seal opened containers and use the content as soon as possible.

Special remarks

The product is regulated by the German Ordinance on Hazardous Substances (GefStoffV), the German Ordinance on Industrial Safety and Health (BetrSichV), and transport regulations for hazardous goods. The necessary information is contained in the DIN Safety Data Sheet. Observe all identification information on the container label!

GISCODE: RMA 20

Indication of VOC-content:

(EG-Regulation 2004/42) Maximum Permissible Value 500 g/l (2010,II,j/lb): Ready-for-use product contains < 500 g/l VOC.

CE marking

	
KLB Kötztal Lacke + Beschichtungen GmbH Günztalstraße 25 FRG-89335 Ichenhausen	
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AC357-V1-022013	
DIN EN 13813:2003-01	
Synthetic resin screed mortar DIN EN 13813: SR-B1.5-AR0.5-IR4	
Fire behaviour	E _f -s1
Emission of corrosive substances	SR
Wear resistance to BCA	AR 0.5
Adhesive tensile strength	B 1.5
Impact resistance	IR 4



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