

**NeverStrip**  
FLOOR COATINGS

Mixing and Application  
Instructions

# High Solids Urethane



## Mixing and Application Instructions NeverStrip High Solids Urethane (Gloss/Satin)

**Important Note:** NeverStrip High Solids Urethane Gloss and Satin have different part B formulations, do NOT interchange or cure problems will occur! NeverStrip High Solids Urethane Satin part B requires the Satin Additive or cure problems will occur (foaming, bubbling will result).

**Important Note:** This is a uniquely hard-wearing and low odor urethane. The Gloss formulation as a result of these features has a tendency to cause small “fish eyes” when applied over a smooth epoxy basecoat. It is advised to use some quantity of NeverStrip Resin Grip Aggregate and/or NeverStrip 320 Grip Aggregate, which helps to reduce this tendency. A suggested recommendation is 2-8 ounces by volume of Never Strip Resin Grip Aggregate or 8-20 ounces by volume of NeverStrip 320 Grip Aggregate.

**Important Note - Surface Preparation:** When NeverStrip High Solids Urethane is to be applied over a smooth epoxy basecoat; the epoxy should be thoroughly sanded/screened (complete removal of gloss). This should be done even when the epoxy has been applied the previous day and is within the standard recoat window. Sanding is also recommended when applying over NeverStrip Extreme Performance coating. Application over a prior coat of NeverStrip High Solids Urethane absolutely requires thorough sanding.

**Important Note - When Used as a Terrazzo Sealer:** When NeverStrip High Solids Urethane is to be applied over epoxy terrazzo or cement terrazzo, you MUST first prime with NeverStrip Off-Gassing Primer.

### A. Mixing

- 1 Thoroughly stir each component prior to combining.
- 2 Mix four (4) parts by volume of Part A with one (1) part by volume of Part B for three minutes with a low speed electric drill and mixing paddle (Jiffy Mixer). Do not thin material. Mix Part A and Part B for a minimum of 2 minutes before adding Satin Additive and continue mixing for 1-2 additional minutes.
- 3 **Satin Finish:** After mixing Part A and Part B as outlined above, add 1 gallon of Satin Additive to 1 gallon mixed NeverStrip High Solids Urethane, mixing for 2 minutes.

**THE SATIN ADDITIVE IS A FINE, LIGHT POWDER, WEAR AN APPROPRIATE FACE MASK DURING THE MIXING OF THE SATIN ADDITIVE INTO THE COATING.**

**Important:** Adding NeverStrip 320 Grip Aggregate to the High Solids Urethane Gloss Finish will reduce gloss to some degree. Do not mix more than a one-gallon batch of High Solids Urethane at a time when adding the 320 Grip Aggregate. Agitate the liquid, as needed, to keep grit suspended, particularly just prior to pouring into an application tub using the “dip and roll” procedure. Keep grit suspended in the application tub using the roller immediately before each application.

- 4 Do not mix more material than can be used in 1 hour.

## B. Application

- 1 To ensure proper application thickness and consistency, it is best to use a “dip and roll” procedure and apply at 450-500 sq. feet per gallon. High Solids Urethane will yield 3 mils dry film thickness. Apply in a “V” shape procedure, using aggressive pressure on the roller handle. Initially an “orange peel” texture will be evident if applying at correct thickness, which will slowly level out (Gloss only—Satin will remain orange peel).

**DO NOT** apply thicker than 3.5-4 mils DFT (350-400 ft<sup>2</sup>/gallon) or puddle coating, particularly when applied over a broadcasted system, as this may cause micro bubbles and a resulting white haze.

- 2 Immediately and slowly cross roll with a lint-free, short nap 3/16” or ¼” woven or mohair roller to even the surface texture of the coating, again using aggressive pressure on the roller handle. All cross rolling steps must be done immediately in sequence after initial application of coating. **DO NOT** re-roll isolated areas more than 5 minutes after completing final cross roll procedure, as roller marks may occur! Material must be very thoroughly rolled, particularly the Gloss formulation, or tiny “fish eyes” (i.e., material separation) may occur. Also, “aggressive” pressure does not mean rapid rolling, but rather to bear down on the roller handle with enough force that the handle bends slightly, to insure enough pressure is used, to help reduce material separation. Cross rolling is always recommended, do this immediately. If coating begins to “fish eye” or pull apart, immediately re-roll. With Gloss formulation, isolated areas can be re-rolled somewhat later than 5 minutes. Be sure to check areas already finished to confirm that fish eyes did not form. **DO NOT** rapidly roll the NeverStrip High Solids Urethane or micro bubbles may form from air entrainment. Important: Change roller cover every 45-60 minutes if a residue begins to build up on the ends of the roller or roller frame. Use a fresh application tub every 45-60 minutes.

Accumulated older resin may cause reaction with fresh material, resulting in shortened working time and/or micro bubbles. Apply material within the recommended thickness range and allow to cure tack free if top coating.

- 3 Allow material to cure completely hard (24 hours or more at 75°F, 50% RH) before applying a second coat. NeverStrip High Solids Urethane must be hard enough to aggressively sand (completely de-glossed) prior to application of a second topcoat or “fish eyes/crawling” may occur. Use diamond-impregnated buffer pad (100-150 grit is recommended), or resin-bond diamond plugs (100-150 grit), or 80-100 grit carborundum sand papers, or a black buffer pad. It is recommended that the installer test which method will work best for any particular project. If individual scratch marks are apparent, the surface has NOT been sanded thoroughly. Be sure to completely remove all residual dust with vacuum and auto scrubber before coating.

**Important:** NeverStrip High Solids Urethane is a moisture cure urethane; relative humidity will significantly affect cure speed. Relative humidity range must be 30%-90% RH, low RH will slow the cure rate. Note that very high humidity (90%+) may result in moisture condensation on the substrate, which can cause numerous small bubbles to form in the urethane.

- 4 Do not open to light foot traffic for 10-12 hours at 75°F, 50% RH. Do not open to vehicle traffic for 72+ hours at 75°F, 50% RH. Full chemical cure and maximum resistance are achieved in five to seven (5-7) days at 75°F, 50% RH.

## NeverStrip Off-Gassing Primer

(Used with NeverStrip High Solids Urethane when sealing Terrazzo)

### A. Mixing

- a. Stir each component prior to mixing.
- b. Mix two (2) parts by volume of Part A (Resin) with one (1) part by volume of Part B (Hardener) for three minutes with a low speed electric drill-mixing paddle.

### B. Application

- a. Apply in “dip & roll” procedure using a short nap (1/4”) roller at a spread rate of 250-300 ft, 2 per gallon. Pot Life is 3 hours.
- b. As water leaves the system, the coating will become clear. Do not allow thick applications or puddles where coating remains white.
- c. When surface becomes clear, a second coat may be applied if necessary. (This will be one to four hours depending on airflow and temperature).
- d. Allow curing 14-16 hours before applying NeverStrip High Solids Urethane topcoat.

**Do not exceed 36 hours or light sanding will be necessary.**



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