



1001 South Main Street, Euless, TX 76040 – 817-571-2438
www.roll-on.com

CONVERTING EXISTING CONCRETE FLOORS TO A ROLLER SKATING SURFACE

CLEANING

TESTING

To determine which preparation method to use, test several 2' x 2' sections in different areas of the floor. This will help determine which of the following cleaning or stripping systems is best for your floor. Use Muratic Acid solutions for testing as described below in the **ETCHING** section of these instructions on page 3.

GREASE AND OIL

Using strong detergent and abrasive stripping pads, scrub the surface with an automatic floor scrubber or rotary floor cleaner. Clean surface in small sections being certain to rinse and remove the dirty water before it has a chance to dry. A wet/dry vacuum cleaner should be used remove rinse water from the surface.

WAX

Remove all water-based wax or finish with an industrial strength wax strippers following manufacturer's instructions.

SEALER OR CURING COMPOUNDS

For curing compounds and sealers that cannot be removed with water-based strippers, the following procedures apply:

- Apply solvent-based stripper such as Multi-Clean Solvent Blend No.1 with a lamb's wool applicator, covering an area of 10' to 20' at a rate of 150 sq. ft. per gallon.
- Keep surface wet with this stripper and allow product to stand 15 to 20 minutes.
- Mix a powerful detergent such as Multi-Clean Butyl Plus 1 part detergent to 7 parts hot water.
- Flood the solvent treated area with detergent solution and scrub with a floor machine equipped with a poly-grit brush or black stripping pad.
- Pick up the residue with a wet/dry vacuum or automatic scrubber.
- Check area for spots and residue that may appear.
- With etching solution, test area in the manner described above. If fizzing occurs, then you have broken through the sealer or compound and may continue stripping the floor.

VARNISH OR PAINT

- Remove all water based wax or finish.
- Apply a Varnish Remover to a 10' x 20' area with a lamb's wool applicator. Let stand and work 15 minutes.
- Scrub stripper with a ploy grit brush or wire brush.
- Spread sawdust or oil absorbent material on the stripper solution.
- Sweep up the residue and dispose of properly.
- Scrub the floor with a powerful industrial strength detergent solution.
- Rinse with plenty of water.
- Test area with etching solution. Repeat stripping if little or no "fizzing" occurs.

EPOXIES

If you suspect that epoxy paint has been used as a floor coating, contact your Roll-On and Super Base Supplier. They will see to it that you are properly advised as to its removal.

ETCHING

IMPORTANT NOTE

All concrete surfaces must be properly and thoroughly etched with a MURIATIC ACID solution (often the label says, "30% Baume") or other concrete etching product before coating. Muriatic Acid is available in most hardware stores and is used commercially to clean swimming pools and stainless steel containers. Work with this product wearing rubber boots, rubber gloves and good protective eyewear. The common neutralizer for this product is white vinegar. Please consult labels on the product for proper protective measures and first-aid recommendations.

MIXING

Mix 1 part muriatic acid to 6 parts water in a large PLASTIC container or garbage can. DO NOT use metal or galvanized containers for this process.

TESTING

Apply a few drops of Muriatic acid or other etching solution to a few test areas throughout the skating surface. If the mixture "fizzes" the surface is clear of sealers or other coatings and the surface is ready to etch. The acid solutions should react the same in areas tested. If no "fizzing" occurs in one or more of the test areas, then a curing compound, sealer, varnish, or a wash coat is present and must be removed before the etching process can be started.

ETCHING – BROOM FINISH CONCRETE

Acid-etch the cured slab until it feels like 80 grit sand paper. If the broom finish already has that feel to it, you need only acid-etch the slab once.

Etch in 10' x 10' sections per gallon using a common plastic garden sprinkling can to apply the solution. This is the best way to control the spread of the solution. Allow the solution to "fizz" for about 10 to 15 minutes. During this time, scrub with a floor machine equipped with a wire brush or use a stiff bristled parking lot push broom to work the solution into the concrete. Using a 5-gallon plastic paint pale, flood the 10' x 10' area with 5 gallons of clear water, also working this in for a minute or two with the parking lot broom or scrubber. Remove the water in the 10' x 10' area with a water vacuum and move on to the next section.

ETCHING – SMOOTH FINISH CONCRETE

It may be necessary to etch smooth concrete two times to obtain a proper etch. A proper etch should have the feel of 80 grit sand paper. The first etch should be done with a mixture of 1 part Muriatic acid to 4 parts water. The second etch should use the standard Muriatic solution of 1 part Muriatic acid and 6 parts water.

Etch in 10' x 10' sections per gallon using a common plastic garden sprinkling can to apply the solution. This is the best way to control the spread of the solution. Allow the solution to “fizz” for about 10 to 15 minutes. During this time, scrub with a floor machine equipped with a wire brush or use a stiff bristled parking lot push broom to work the solution into the concrete. Using a 5-gallon plastic paint pale, flood the 10' x 10' area with 5 gallons of clear water, also working this in for a minute or two with the parking lot broom or scrubber. Remove the water in the 10' x 10' area with a water vacuum and move on to the next section.

Once the concrete slab is etched, it must dry thoroughly before applying your skate floor coating.

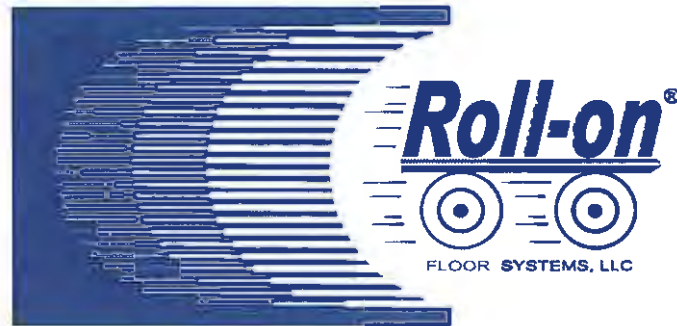
TEST FOR ELIMINATION OF MOISTURE IN THE SLAB

36 hours after completing the etching process, test for moisture by placing a few 6' X 6' plastic drop cloths (large plastic garbage can liners work well too) around the floor. Weight the corners of the plastic sheets down so they won't move with sudden air currents.

After 24 hours, lift a drop cloth. If the concrete is moist, the area under the plastic sheeting will be darker than the surrounding area. The surface is not ready for coating.

Return the drop cloth to its original position and test it again in a few hours. If the area under the drop cloth is dry, the surface is ready to coat. Once all test areas have dried, the skating surface is ready for coating.

If you are satisfied that the floor is “ROUGH, CLEAN, and CURED”, then refer to Roll-On Floor System's Publication regarding application of Super Base Two Part Epoxy.



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SUPER BASE TWO PART EPOXY SKATE FLOOR BASE COATING

ON ASPHALT, CONCRETE OR PARTICLE BOARD FLOORING

Before You Begin

Super Base Two-Part Epoxy was designed as a base coating to be used to smooth asphalt, concrete and particle board surfaces and **is not** intended to be used as a skate floor coating. *Roll-On* Skate Floor Finish over Super Base insures the best possible skating surface.

Storage

Store indoors only

Keep from freezing

In cold weather, keep all containers at room temperature for 48 hours prior to application

Preparation

NOTE: Shut down all sources of flame around the area where Super Base is to be used. Do not mix or apply near open flame or operating sparking system.

When mixing Super Base, it may be necessary to use an electric mixer.

1. Before combining Part A and Part B, stir each part with a mixing paddle for a minimum of 5 minutes or until all solids are thoroughly mixed.

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2. Wash a new **galvanized trash can completely with dish soap and warm water, rinse thoroughly and let dry.** Pour equal amounts of Part A and Part B into a 20 gallon (or larger) **GALVANIZED** trash container. **DO NOT USE RUBBER TRASH CONTAINERS.** Maximum amount to be mixed -- 10 gallons per container.
3. Stir mixture with a mixing paddle for a minimum of 5 minutes per container or until completely blended.
4. Allow mixture to cure in the 20 gallon container for **45 MINUTES** before applying. Once mixed, Super Base has a maximum pot life (the useful liquid life of the epoxy after it has been mixed) of 4 hours at 68 to 72 degrees (F). When mixing smaller quantities of Super Base, please call 1-800-227-8931.
5. During the 45-minute curing time, stir mixture briefly every 10 minutes.

Application with Squeegee

- **NOTE:** All surfaces must be properly prepared and cleaned as outlined in the current *Roll-On Floor Finish Data Publication* available from your nearest *Roll On* supplier.

RECOMMENDED COATING FOR UNCOATED SURFACES:

Concrete: 4 to 5 coats

Particle Board: 5 to 6 coats

Asphalt: 10 coats

1. Squeegee surface using normal squeegee technique.
2. Allow a minimum of 4 hours drying time between each coat. (All drying times are estimated and are based upon a recommended building temperature of 68 to 72 degrees (F).)
3. After the third coat, allow 12 hours drying time.
4. **LIGHTLY CLEAN AND SAND SUPER BASE SURFACE AS FOLLOWS:**
 - After third coat, sand surface by using No. 60 grit sand paper under one or more large floor polishers.

- After sanding, drag the surface carefully by soaking a large terrycloth towel in a bucket of **CLEAR WATER**.
- **(DO NOT USE MINERAL SPIRITS, DETERGENTS, OR SOLVENTS.)**
- Wring out and wrap the towel around a 24" or 36" push broom. Push the towel across the width of the skating surface (not the length). Upon reaching the other side, turn the towel over so that the clean wet side is face down on the surface and push it back to the other side. Overlap a little for a cleaner surface.

REPEAT THIS PROCESS UNTIL THE FLOOR IS DUST- FREE.

5. Squeegee additional coats until the remaining product has been used. (**NOTE:** For asphalt, additional sanding and cleaning is required after coat No. 6 and coat No. 9.)
6. After final application of Super Base, allow a minimum of 12 hours drying time before sanding and cleaning the surface.
7. Before applying *Roll-On* skate floor finish, obtain the current Data Publication (*Roll-On* Floor Finish over Coated Floors) from your supplier.

Application with Airless Spray

NOTE: Minimum of two spray coats required.

1. Pour mixture into a thoroughly cleaned airless sprayer container.
2. Using 15/1000 orifice, spray entire skating surface at a controlled rate of 200 square feet per gallon. **ESTIMATED TIME OF APPLICATION:** 2 hours per 10,000 square feet.
3. Once spray application begins, it must continue until the entire surface has been coated.
4. Allow the first coat to dry a minimum of 18 hours, keeping the room at a temperature of 68 to 70 degrees (F) with good building ventilation during this time.
5. Once the floor is dry, lightly sand and clean Super Base surfaces as follows:
 - **SANDING:** Sand surface by using 60 grit sand paper under one or more large floor polishers.

- **CLEANING:** After sanding, drag the surface carefully by soaking a large terrycloth towel in a bucket of **CLEAN WATER**.
- **DO NOT USE MINERAL SPIRITS, DETERGENTS, OR SOLVENTS.**
- Wring out and wrap the towel around a 24" or 36" push broom. Push the towel across the width of the skating surface (not the length). Upon reaching the other side, turn the towel over so that the clean wet side is face down on the surface and push it back to the other side. Overlap a little for a cleaner surface.

**REPEAT THIS PROCESS
UNTIL THE FLOOR IS COMPLETELY DUST-FREE.**

6. Apply a second spray coat of Super Base Epoxy. (**NOTE:** To determine if additional coats are necessary, refer to the "Estimated Gallons Used...")
7. After each application of Super Base, allow 18 hours drying time.
8. Sand and clean between each airless spray application as described above.
9. Before applying *Roll-On* skate floor finish, obtain the current Data Publication (*Roll-On* Floor Finish Over Coated Floors) from your supplier.

Helpful Hints

- Clean equipment and hands immediately with warm water and mild detergent.
- When sanding between coats, change sand paper every 500 square feet or less.
- Always store sanded material in a sealed metal container.
- When spraying, use available building markings to help control coverage (i.e. wall joints, beams or posts).
- A controlled floor temperature of 68 to 72 degrees (F) is essential during the application and curing of Super Base Epoxy.



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Trouble-Shooting Super Base Applications

**CAUTION –
PROTECTIVE GLOVES, GOGGLES, PAINTER’S RESPIRATORS ARE TO BE
WORN WHEN USING HAND TOOLS, SANDERS, SCRAPERS OR OTHER
APPARATUS WHEN TRYING TO AFFECT REPAIRS OUTLINED BELOW.**

**NOTE THAT CONCRETE, CONCRETE PATCHES, PORTLAND CEMENT, CEMENT OF ANY
TYPE IS NEVER DISCUSSED IN THIS TROUBLE SHOOTING SUMMARY AND MUST NEVER
BE USED TO FILL, CAP OR FEATHER ANY REPAIR OF YOUR CONCRETE SKATE FLOOR.
THERE ARE RELIABLE SPECIALIZED PRODUCTS TO ACCOMPLISH MORE SEVERE
FILLING OR FEATHERING ISSUES. PLEASE CONSULT OUR TECHNICAL SUPPORT OR
HAVE A QUALIFIED LICENSED CONTRACTOR CONTACT US BEFORE COMMENCING ANY
WORK OTHER THAN THAT OUTLINED IN THIS SUMMARY.**

1. Pooling, Excessive Thickness, failure to dry:

- a. **PROBLEM:** Excessive thickness of the product can result in slow or “no” drying. The symptoms are:
 - i. The product may be tacky or may come up easily by wiping across it.
 - ii. The product, after some time, may appear “alligator-skinned” with random cracking on its surface from shrinkage due to thickness.
 - iii. The product, when cut into with a knife, may be “spongy” or may be easily compressed. It may have small sponge-holes, often layered below a smooth or shiny surface.
- b. **SOLUTION:** Remove the product from the concrete slab.
 - i. The product must be removed to the concrete base using common “ice scrapers” or the smaller hand-scrapers often used to remove paint or varnish from finished wood. In the worst possible cases, a hand-held power grinder has been employed, but normally the product will yield easily to hand-held scrapers.

- ii. Once the concrete is revealed and the material becomes harder to remove from the surface, a floor polisher, equipped with a sand-paper driver and using 60 grit disc papers, will smooth out and finish the work. The objective is to reveal as much of the concrete as possible, but pigment will often remain in the “pores” of the concrete. This uneven salt-and-pepper appearance is normal and should be sufficient to permit recoating.
- iii. In small areas – say, no greater than 8’ x 10’ (although there is no hard and fast rule to the size) a half gallon (1 quart of Part A mixed with 1 quart of Part B) total quantity of Super Base may be applied over the clean and dried area using a ¼” nap common paint roller. The goal is to mix and use sufficient quantities to apply a thin, but color rich coating using the roller.
- iv. Super Base is a high-solid, *non-self-leveling* epoxy. (Where it lays, it stays.) The deckles and dimples that the roller leaves behind will have to be sanded. Again, utilizing the speed and weight of the Floor Polisher, this time with 80 grit paper, smooth and feather the rolled Super Base patch.

2. Divots (not holes) or Chunks or Gouges in the slab.

- a. **PROBLEM:** Small depressions (up to 1 inch thick and not greater than the diameter of a baseball), “chunks” or “gouges” (not holes or cracks) have been filled to an unknown thickness with a squeegee coat of Super Base and depression(s) are visible, remaining below the level of the slab.
 - i. Test the depressions with a hard pointed tool such as a knife or slotted screw driver. If the product has cured for over 24 hours and a knife blade or screw driver tip can be pressed into the depression without much resistance (it should be VERY difficult to penetrate through the surface of the product), then the product should be removed from the divot.
 - ii. There is painter’s gouging hand tools made for this, stone chisels and blades may also be used. The goal is to remove any quantity of product than will release from within the walls of depression.
 - iii. Auto body filler is an epoxy that grips to itself and concrete. It may be used to build up the depression 1/8” to ¼” at a time while course sanding between applications – one layer to the next. Please read instructions accompanying the auto body filler you choose. This is a slow and process, but, when done right the first time, results in a long term patch. Sand all patches before coating.
 - iv. Super Base and Roll-on adheres very well to auto body filler epoxies and, depending on the area(s) patched, Roll-on can be directly applied to the filler, however, a second coat of Roll-on is usually needed to return a gloss to the patch while the high gloss of Roll-on occurs in one application over Super Base. If larger areas are being patched through out the floor, it’s best to complete the patches with a Super Base coating unless the patches are so few and so small that mixing the Super Base becomes wasteful.

3. Seams (butt-joints) or Open Cracks in the slab

- a. **PROBLEM:** Slab has been poured in sections and the section joints (commonly called butt-joints) are open and need filling or there are open cracks in the slab wider than 1/8" of undetermined depth.
 - i. Butt-joints must NEVER be filled with concrete or cement materials or auto body filler. Any unidentified fillers or materials – especially if cracking is visible within the material – should be removed using tools that are appropriate for the job.
 - ii. Super Base should be used to fill all butt-joints and cracks in the slab. Again, if Super Base is applied in an excess thickness – over 1/4" – then it should be tested for compression as in the suggestions for divots or gouges. If the material is spongy, it should be removed.
 - iii. For Butt-joints or cracks of undetermined depth, and to reduce shrinkage when cured, mix silica sand or clean masonry sand up to 1:1 with the completed Super Base mixture. (Example: Mix one measured quart of sand with one total measured quart of Super Base Pt. A and Pt. B, yielding two measured quarts). Pour this mixture along the butt-joint or crack smoothing with a trowel or wall knife. CAUTION: Mixture should be AT OR BELOW the level of the floor when finished. DO NOT MOUND THE MIXTURE ABOVE THE LEVEL OF THE FLOOR. The sand and epoxy mixture is resistant to sand paper and will have to be ground back to level using a grinding stone if cured above the level of the slab. It is best to bring the mixture to within 1/8" of the surface level of the slab and finish with a rolled coat or two of Super Base that can be sanded smooth with 80 grit sandpaper.