

weberfloor industrial base 4600

Rapid setting self-smoothing industrial base screed

- For use in industrial areas
- For levelling highly irregular substrates
- Ideal for receiving **weberfloor industry pro top 4610** and **weberfloor industry rapid 4655**

About this product

weberfloor industrial base 4600 is designed for the use in industrial areas allowing a much earlier overlay for Weber industrial floor screeds compared to traditional sand/cement or concrete. It is ideal for the renovation of existing floors, particularly where there are large irregularities in the substrate.

Features and benefits

- For application depths between 5-30mm
- Pump or hand applied
- Rapid setting
- Foot traffic after 2-3 hours
- Ideal for correcting highly irregular substrates
- Low alkalinity
- Casein-free
- Low emissions

Uses

For levelling concrete substrates.

Suitable for covering with:

- **weberfloor industry pro top 4610**
- **weberfloor industry rapid 4655**



**RAPID
DRYING**



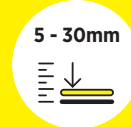
**PUMP OR
HAND APPLIED**



**FLOW TEST
180-210mm**



FOOT TRAFFIC



**5 - 30mm
APPLICATION
DEPTH**



**4.5L
18%
ADD WATER**



Constraints:

- Not a wearing screed and must be covered by **weberfloor industry pro top 4610** or **weberfloor industry rapid 4655**
- Must be used fully bonded in industrial areas

weberfloor industrial base 4600 must be allowed to dry for a minimum of 12-36 hours, prior to installation of **weberfloor industry pro top 4610** or **weberfloor industry rapid 4655**. Please see relevant datasheets for more details.

Preparation

The surface strength of the substrate must be greater than 1.5N/mm² in industrial areas.

It is essential the substrate is suitably prepared and primed with **weberfloor 4720 epoxy primer** or **weberfloor 4716 primer** prior to installing the weberfloor screed. **weberfloor 4720 epoxy primer** is an ideal choice for industrial construction and detailing applications providing bond strength and priming layer between the substrate and weberfloor screed. It is also efficient in large areas with coverage of approx. 3.lm² per kg per mixed components and can be suited for moisture-sensitive surfaces. **weberfloor 4716 primer** is a styrene acrylate dispersion which can be diluted with water, offering alkali resistance and adhesion properties.

The substrate should be clean, free from dust, grease and other impurities that might prevent adhesion.

Walls and any upstands (pillars, columns etc) should be isolated with 10 x 100mm foam.

For large irregularities in the substrate (>30mm) in isolated areas two applications of **weberfloor industrial base 4600** can be used. The first layer should be allowed to harden and then primed before the second application can begin. Alternatively in larger areas, **weberfloor 4360** is recommended.

Holes and leaks in the substrate should be sealed. The substrate should be vacuum cleaned, prepared and primed with **weberfloor 4720 epoxy primer** or

weberfloor 4716 primer according to the instructions on the data sheet.

Priming improves the screed's adhesion to the substrate and prevents the formation of air bubbles and de-watering of the screed. Priming also improves the flow properties of the screed. Dry and very porous substrates (cast-in-situ concrete floors) may need to be treated twice. If the screed is applied in more than one layer, each layer must be primed.

Mixing

weberfloor industrial base 4600 is mixed with clean water using an automatic screed mixer approved by Weber.

The material is mixed with 18% water, which corresponds to 4.5 litres per 25kg bag. It is important to add only the specified amount of water as excess water will reduce strength, increase shrinkage and encourage segregation. Whilst mixing, the water content should be checked continuously by the flow ring test to ensure that the material is correctly mixed and free from separation and lumps of powder.

The flow rate should be between 180-210mm. Conversely, reduced water content increases viscosity. The temperature of the mix should ideally be between +15°C and +20°C.

For manual mixing thoroughly mix using a slow speed electric mixer (500 rpm) for at least two minutes. Allow to stand for 2 minutes.

Application

Light ventilation in the working area is necessary but windows and door openings must be closed sufficiently to avoid draughts during and for 3 days after application.

During application, and for at least 1 week afterwards, the substrate and ambient temperature should not fall below +10°C or rise above +25°C. The relative humidity of the substrate must be <95%.

To achieve the best finish, the floor area should be divided into bays of 6 to 8 metres depending on pump capacity and application thickness. **weberfloor 4965 barrier foam** should be used to form bays and

stop ends. Pumping is carried out in sections so that a new section is pumped as quickly as possible and to maintain a wet edge. A wide flat spatula or wobble bar should be used to assist the self-levelling process.

Overlay

weberfloor industrial base 4600 is compatible with **weberfloor industry pro top 4610** or **weberfloor industry rapid 4655**.

weberfloor industrial base 4600 is ready to receive **weberfloor industrial top screeds** after 12 hours (in normal conditions). However **weberfloor industrial base 4600** must be allowed to dry for a minimum of 36 hours prior to the finishing coat of **weberfloor industry pro top 4610** or **weberfloor industry rapid 4655**. It should be ensured that the floor has reached the appropriate relative humidity, as defined by the relative British Standard, before the application of sealer or resins.

It should not be painted or used without a floor finish.

Drying time

The screed can receive foot traffic after a drying time of 2 - 3 hours at an ambient temperature of +20°C. If necessary, the surface can be ground after 2 days following application.

High humidity of the substrate and poor drying conditions prolong the setting time.

Packaging

weberfloor industrial base 4600 is packed in 25kg polythene-lined paper sacks, or large 1 tonne tote bags.

Storage and shelf-life

When stored unopened in a cool, dry place at temperatures above 5°C, shelf life is 12 months from date of manufacture.

Poor storage conditions may have an adverse impact on the levelling properties.

Health and safety

Please see latest material safety datasheet via our website for information.

Technical data

Application temperature	+10°C to +25°C
Minimum substrate strength	1.5N/mm ²
Minimum thickness	5mm
Maximum thickness	30mm
Water demand	4.5 litres/ 25kg (18%)
Compressive strength (BS EN 13892-2)	C 30
Flexural strength (BS EN 13892-2)	F 6
Shrinkage (28 days)	< 0.05%
Weber flow rate	180 - 210mm
Approx. material consumption	1.85kg/ m ² / mm
Hardening time (before foot traffic)	2-3 hours in normal conditions
Pot life at 20°C	20 min (after adding water)
Waiting time between layers	12 hours

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