FOX DECO SYSTEM
FOX LYCIA CEMENT TERRAZZO
FLOOR COATING SYSTEM TECHNICAL SPECIFICATIONS

Cement Based Decorative Floor Coating System Specification Specially Designed with 20.0-22.0 mm Thick Aggregates

PART 1: GENERAL SCOPE

1.01 DEFINITIONS

- **FOX LYCIA CEMENT TERRAZZO:** Cement Based, 20.0-22.0 mm Thickness, Specially Designed with Aggregates, Decorative Floor Coating System
- **NTMA:** National Terrazzo and Mosaic Association, Inc. (National Terrazzo and Mosaic Association - It is the terrazzo association accepted by terrazzo resin producers and practitioners around the world.)
- **FOX EPOTHANE® PRIMER HB:** Epoxy-based, transparent primer set that creates a moisture-preventing layer.
- **FOX EPOTHANE® ISO CRACK MEMBRANE:** Epoxy Polyurethane based, flexible membrane. It provides 140-160% elongation by allowing horizontal surface movement.
- **FOX DOMINO® PLUS 20 TERRAZZO FD772:** It is a cement-based, early-setting, high-strength decorative binder/matrix material developed for terrazzo systems (25 kg bag).
- **FOX DOMINO® FILLER FD775:** Special filling material used for cement terrazzo system
- **FOX DOMINO® PU SEALER FD793:** It is a polyurethane-based, single-component, aliphatic, solvent-based, water-repellent, topcoat protection material.
- **FOX PURATHANE® TOPCOAT WB:** Modified polyurethane based, two-component, water-based, high abrasion resistance, containing aliphatic isocyanate, non-yellowing, UV resistant, antibacterial, top coat material.
- **FOX HARDTOP® SI PREMIUM FF844**: Silicate and Silane Based, liquid concrete surface hardener that provides dust resistance in new and old concrete, has water repellent properties, and reduces and prevents stain formation.
- **FOX HARDTOP® LI PREMIUM FF845:** Lithium Silicate Based, liquid concrete surface hardener that provides dust-resistance in new and old concrete.
- **FOX HARDTOP® LI GLOSS FF847:** It is a lithium silicate based, Silicone and Polymer Modified concrete sealer material that adds high gloss properties and provides stain and abrasion resistance.
- **AGGREGATE:** Mixture in accordance with the recipe recommended by the applicator and manufacturer used in the terrazzo system.
- **SEALER:** Final coat protection polish

1.02 APPROVAL/PRESENTATION MEETING

These are the meetings to be held by the architectural office, manufacturer officials, applicator officials and the employer to determine the product(s) to be used in the current project and the type of terrazzo to be covered and to discuss the suitability of the products to be used for the project.

1.03 APPROVED DOCUMENTS

A. Technical application procedures given by the implementer,
B. Witness samples of the terrazzo coating approved for the project, prepared for the benefit of the Architectural Office, the employer and the practitioner, and signed by at least 3 authorized persons,
C. Quality documents for the product,
D. Product technical documents (tds, sds information)

1.04 MANUFACTURER DOCUMENTATION

A. Manufacturer Certificates (Manufacturer company with sufficient production capacity to produce the necessary materials in epoxy resin production in accordance with NTMA standards and successful in-service performance, Factory Production Control Conformity Certificate, ISO Certificates, etc.)
B. Applicator Certificate (Terrazzo applicator: Declaration of the applicator company that meets the necessary conditions according to NTMA standards)
C. Aggregate Supply Distances (for LEED Certifications)
D. Mock up (Making Samples on Site)

1.05 STORAGE CONDITIONS

A. Materials will be delivered to the Project site in the supplier's original packaging and containers, labeled with the name of the source or manufacturer, the material or product brand and the batch number, if any.
B. Materials will be stored in their original, undamaged packaging and containers, in a place that will not be exposed to direct sunlight.
C. Epoxy-polyurethane and cement components will be stored in an area where the ambient temperature can be kept between 20°C and 25°C.

1.06 PROJECT DETAILS

A. General The Contractor shall provide adequate water, temporary heat and light, and sufficient electrical power connected and distributed to appropriate receptacles for use within 100 feet of any work area.
B. General The Contractor shall provide temporary enclosures and other appropriate means to prevent adjacent areas from being damaged during installation.
C. Ensure that the ambient temperature in the area where the terrazzo will be taken is not less than 20°C.
D. Provide adequate ventilation in the area where the terrazzo will be taken.
E. Terrazzo Contractor shall protect other adjacent works from water and dust resulting from grinding operations.

1.07 WARRANTY CERTIFICATE

It is 1 (one) year from the completion date of the Terrazzo application.

1.08 MAINTENANCE PERIOD

It is every year from the completion date of the Terrazzo application. It must be renewed in accordance with the "Use, Maintenance and Cleaning" instructions given by the manufacturer.

PART 2: PRODUCTS AND APPLICATION DETAILS

1. SURFACE QUALITY

Concrete Criteria:

Before the concrete is poured, the soil or fill ground must be compressed with compactors until it reaches sufficient compression values and the necessary drainage systems must be installed. Since the water coming from the ground will cause the coating to lift and swell, polyethylene cover or covers should be laid between the compacted ground and the concrete to be poured, which will act as a water and moisture barrier. Additional water should never be added to the site to reduce the consistency of the concrete to be used. Excessive water in the concrete may evaporate and cause shrinkage cracks. Concrete leveling should be done using a vibrating screed and helicopter polishing. (Effective in epoxy consumption.) Dilatations and control joints in field concrete must be designed in accordance with the structural design of the building. Coatings to be applied to concrete floors where no dilatation and control joints are left; It becomes unusable due to subsequent fractures and collapses in the ground. At least 24 hours after concrete pouring, control joints are cut to be at least 1/3 of the concrete coating height.

2. Watch Points

Concrete surfaces on which floor coverings will be made must be at least 28 days old. Concrete compressive strength must be at least 25 N/mm^2 (C25 class) and breaking strength must be at least 2.0 N/mm^2. The amount of water and moisture in the 2cm concrete depth should be below 4%. Test method: C-Aquameter, CM-Device, Darr Method.

Additionally, there should be no moisture rising from all concrete floor coverings, old or new. Ground water rises and is carried to the surface due to the capillary feature of concrete. This causes the coatings applied to the floor to separate from the floor, lift and swell. This effect is detected by the simple polyethylene cover test. A transparent polyethylene (nylon) cover is adhered to the concrete surface with polyurethane mastic at the edges in a way that does not allow moisture to pass through. Moisture coming from the ground accumulates under the polyethylene cover and appears as droplets; floor coating should not be applied in these conditions. If no moisture is observed when the cover is checked 24 hours after it is adhered, it is appropriate to apply the coating.

The building's roof, walls, doors and windows must be made, and the ambient and surface temperature must be at least +10°C and at most +30°C. To increase the applicability of products in cold weather, packages should be kept at 20-25°C and made ready for use. Rain, dust, wind, animals and insects should be prevented from entering the building while the coating is fresh. Consumptions are given for conditions where the ambient and surface temperature is assumed to be 20°C. Actual consumptions may vary depending on the surface structure. It should not be forgotten that consumption will increase on damaged surfaces. During application, do not use solvents, thinners, etc. that are contrary to the instructions for use. Thinners should not be added to products. In resin-based systems, pot life and curing times are affected by ambient temperature, ground temperature and humidity in the air. Curing slows down at low temperatures, which extends pot life, coating time and working time. Curing accelerates at high temperatures, which shortens pot life, coating time and working time. In order for the product to fully cure, the ambient and ground temperature must not be lowered below the given minimum temperature levels. After completion of the application,

the coating should be protected from direct water contact for at least 24 hours. If there is water contact, the coating will soften and swell, which will cause the coating to lose its properties. If such a situation is encountered, the coating must be completely removed and reapplied.

3. APPLICATION PROCEDURE

Substrate Preparation

Concrete sub-surfaces to be applied should be prepared by using abrasive equipment (Shot Blasting, milling, diamond grinding, etc.) to remove the cement grout and obtain an open porous surface. Weak concrete pieces should be removed from the surface, small gaps and holes should be made completely open. The resulting dust should be cleaned with the help of an industrial vacuum cleaner. The gaps, cracks and broken concrete on the lower surface should be opened in a V-shape and then filled and the surface smoothness should be ensured. For surface repairs, filling the gaps and smoothing the surface, 60-70 Afs (0.1-0.3 mm) silica sand can be mixed with **FOX EPOTHANE® PRIMER HB primer** in (from 1/1 to 1/10) depending on the condition of the area to be repaired.) is used by mixing. After crack and gap repair, if there is undulation on the surfaces where TERRAZZO will be applied and if preferred, correction screed is applied.

3.2 "Fox Self Leveling Screed for Reparing Up to 5mm System" Application

A. Epoxy Primer Application

FOX EPOTHANE® PRIMER HB is an epoxy-based, two-component, moisture-preventing layer-forming, solvent-free, low-viscosity, 12:5 unit mixing ratio, transparent primer set.

Technical Properties

Density		1,03 gr/cm^3
Color		Transparent, Yellowish
Mortar Properties 14.3% with binder		
Compression Strength		~ 109 N/mm^2
Flexural Tensile Strength		~ 40 N/mm^2
Adhesion Strength	Concrete	>2 N/mm^2
Percentage of Total Solids		%100
Thinning		Not Thinning
Floor Temperature		+5°C /+30°C
Vapor Permeability	ISO 7783-2	4,1 gr/ m^2 day
Working Time		35-40 min

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

Mix component A **FOX EPOTHANE® PRIMER HB** with a suitable mixer for 1 minute without dragging air. Then pour component B onto component A. Mix continuously for 2 minutes until you obtain a homogeneous mixtureIf necessary, after components A and B are mixed, add 60-70 AFS (0.1-0.3 mm) quartz sand at a ratio of 1/1 depending on the surface condition. Mix for another 2 minutes until you obtain a homogeneous mixture. Avoid overmixing to minimize air entrainment. (Mixing tools: a 300-400 rpm electric mixer and epoxy/polyurethane resin mixing tip)
The prepared **FOX EPOTHANE® PRIMER HB** is applied with a roller with a consumption of approximately **0.30-0.35 kg/m²**. Approximately **2.0-2.5 kg/m²** of **15-25 AFS (0.7-1.2 mm)** quartz sand is sprinkled on the primed surface. Before applying **FOX ROCKTOP FF100** cement-based smoothing screed, the primer should be allowed to dry for a minimum of 12 hours (24 hours depending on weather conditions). Before applying the correction screed, the excess remaining on the surface should be scraped off with a scraper, and the non-adhesive sand should be cleaned with the help of an industrial vacuum cleaner.

Screed Primer Application

FOX PRIMERA® FL220 is a polymer dispersion-based, single-component primer material developed for all absorbent and weak surfaces.

Technical Properties

Material Structure	Liquid acrylic copolymer dispersion
Density	1 kg/lt
Density of mixture with water	1,3 gr/cm^3
Solid Matter	%17-20
Colour	Light blue
Drying Time	2 hours
Service Temperature	-20°C /+80°C
Floor Temperature	+5°C /+30°C
2nd coat Application Time	2 hours
Application to be Made on it	24 hours

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

FOX PRIMERA® FL220 is mixed with an electric mixer at **400-600** rpm, adding water in the amounts specified in the application method, until a homogeneous mixture is obtained. **FOX PRIMERA® FL220** is poured onto the cleaned and prepared surface. The material is applied homogeneously to the surface with a brush or roller. The application intensity should be adjusted according to the condition of the surface. Consumption should be increased on surfaces with high risk of adhesion. Pond formation on the surface should not be allowed.

In the 1st layer application, **FOX PRIMERA® FL220** is diluted 1/1 with water and applied with a brush or roller.
In the 2nd layer application, **FOX PRIMERA® FL220** is applied with a roller without diluting.
The prepared **FOX PRIMERA® FL220** is applied to the surface with a roller, with a consumption of approximately 0.25 kg/m².

Screed Application

FOX ROCKTOP FF100 is a cement and acrylic combination, steel fiber/fiber reinforced, two-component, high-strength and flexible industrial floor coating that can be applied between 3-10 mm.

Technical Properties

Material Structure	Component A		Special cement, steel fiber/fibrous mineral filler
	Component B		Copolymer acrylic dispersion
Density			2,00 kg/lt
Colour			Grey
Compressive Strength	7 days		≥13 N/mm²
	28 days		≥23,0 N/mm²
Flexural Strength	28 days		≥8,8 N/mm²
Breaking Strength	28 days		≥2,0 N/mm²
Abrasion Resistance	DIN 53754	CS 17 disc (weight loss)	245 mg
	Taber 1 kg 1000 rev	H22 disc (weight loss)	301 mg
Usage time			30 min
Full Curing			28 days
ApplicationThickness			Maks. 10 mm

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

Add **FOX ROCKTOP FF100 B** component to a clean mixing bucket. Add component A to component B slowly and mix with an electric mixer and appropriate mixing tip for 3-4 minutes until you obtain a homogeneous mixture. The steel fibers in the powder component should not be allowed to clump at the bottom of the bucket and these clumps should be dispersed. After waiting for approximately 2 minutes, mix for 1 more minute and make it ready for use.
Mixing tools: an electric mixer (400-600 rpm) and an epoxy/polyurethane resin mixing tip.

The prepared mixture is poured onto the surface and spread on the ground with a height-adjustable trowel. If the surface has been primed, this process should be done before the primer dries. A spiked roller should be applied to eliminate air bubbles that will form after a while after spreading. If the spiked roller application is delayed, roller traces may remain on the surface.
Therefore, it is necessary to complete the application process quickly. Solid application is recommended to obtain a smooth surface.

The prepared **FOX ROCKTOP FF100** is applied to the surface with a trowel, with a consumption of approximately 7.0-10.0 kg/m².

3.3. "Fox Iso-Crack Epoxy Membrane System" Application

A. Epoxy Primer Application

FOX EPOTHANE® PRIMER HB is an epoxy-based, two-component, moisture-preventing layer-forming, solvent-free, low-viscosity, 12:5 unit mixing ratio, transparent primer set.

Technical Properties

Density		1,03 gr/cm³
Colour		Transparent, Yellowish
Mortar Properties 14.3% with binder		
Compressive Strength		~109 N/mm²
Flexural Tensile Strength		~40 N/mm²
Adhesion Strength	Concrete	>2 N/mm²
Percentage of Total Solids		%100
Thinning		Not Thinning
Ground Temperature		+5°C /+30°C
Vapor Permeability	ISO 7783-2	4,1 gr/ m² days
Working Time		35-40 min

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

Mix component A **FOX EPOTHANE® PRIMER HB** with a suitable mixer for 1 minute without dragging air. Then pour component B onto component A. Mix continuously for 2 minutes until you obtain a homogeneous mixture. After components A and B are mixed, add 60-70 AFS (0.1-0.3 mm) quartz sand at a ratio of 1/1 depending on the surface condition. Mix for another 2 minutes until you obtain a homogeneous mixture. Avoid overmixing to minimize air entrainment. (Mixing tools: a 300-400 rpm electric mixer and epoxy/polyurethane resin mixing tip)

The prepared **FOX EPOTHANE® PRIMER HB** quartz sand mixture is applied with a trowel with a consumption of approximately 0.60-0.70 kg/m². Before applying **FOX EPOTHANE® ISO-CRACK EP-2K** epoxy-polyurethane based crack bridging membrane to the primed surface, the primer should be allowed to dry for a minimum of 12 hours (24 hours depending on weather conditions).

B. Crack Bridging Membrane Application

FOX EPOTHANE® ISO-CRACK EP-2K is a 100% solids, flexible epoxy-polyurethane membrane based on Epoxy Polyurethane, designed to prevent cracks reflected on the surface in Fox Bau Terrazzo coating systems. The resin's unique bonding and elongation properties provide outstanding crack bridging and are recommended for use on interior concrete surfaces prior to floor installation. Provides 140-160% extension allowing horizontal surface movement.

Technical Properties

Density		1,10±0,05 gr/cm³
Colour		Cream
Tensile Strength	DIN 53504	+23°C ≥ 10 N/mm²
Adhesion Strength	concrete	1,83 N/ mm²
Adhesion Strength	concrete	2,95 N/ mm² (Epothane® Primer Primed surface)
Adhesion Strength	steel	1,00 N/ mm²
Adhesion Strength	steel	1,57 N/ mm² (Epothane® Primer Primed surface)
Percentage of Total Solids		%100
Thinning		Not Thinning
Shore A Hardness	7 days	65
Shore D Hardness	7 days	19
Thermal Resistance	24 hours (-23°C/+25°C)	No Crack
Breaking Elongation	DIN 53504	+23°C ≥ %140-160
Application time		45-50 min

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

A component contains **FOX EPOTHANE® ISO-CRACK EP 2K** pigment and filler. Mix the A component product thoroughly using an electric mixer and a suitable mixing tip until a homogeneous color is obtained and you make sure that there is no product left on the bottom or edges of the container.
After completely adding the B component product into the A component product, wait 3-4 minutes until you obtain a homogeneous mixture. Stir continuously throughout. Avoid overmixing to minimize air entrainment.
Mixing tools: (300 rpm - 400 rpm) an electric mixer and epoxy/polyurethane resin mixing tip.

The prepared **FOX EPOTHANE® ISO-CRACK EP 2K** mixture is applied evenly on FOX GLASS TEXTILE NET 160 gr/m2 net with a consumption of approximately 1.5-2.0 kg/m². Approximately 1.0-1.5 kg/m² of 20-30 AFS (0.3-1.0 mm) quartz sand is sprinkled on the applied surface.

The excess sand sprinkled is cleaned. Joints are opened every 5 meters. 8 mm aluminum profiles are glued to the opened joints with polyurethane mastic. Every 20 meters, 8 mm aluminum profiles are glued back to back for control joint purposes and the gaps between the profiles are glued with polyurethane mastic. The profiles used can be used for both joint and pattern (motif) application.

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1. "Fox Lycia Cement Standard Terrazzo Flooring System" Application

A. Cement Terrazzo Coating Application

FOX DOMINO® TERRAZZO +20 FD772 is a cement-based, high-strength, fast-applicable, early-setting binder specially developed for the **FOX LYCIA CEMENT TERRAZZO** system.

Technical Properties

Density		2,20±0,05 gr/cm^3
Colour		In Ral Colors
Compressive Strength	EN 12190 28 days	≥60 N/mm²
Flexural Strength	EN 12190 28 days	≥6 N/mm²
Adhesion Strength	concrete	≥1,5 N/mm^2
Percentage of Total Solids		%100
Floor Temperature		+10°C /+30°C
Shore D Hardness	28 days	≥60
Working Time		25-30 min
Fire Class	EN 13501-1	A1

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

Before starting the mixing, make sure that the product temperatures are between +20°C and +25°C. For 25 kg of **FOX DOMINO® TERRAZZO +20 FD772** mixture, 37.5 kg of aggregate is mixed with 5.00±0.25 liters of water in a mortar machine. Avoid overmixing to minimize air entrainment.

The prepared **FOX LYCIA CEMENT TERRAZZO** mixture is placed into 20 mm aluminum profiles at approximately 55.00-62.50 kg/m² (22.0-25.0 kg **FOX DOMINO® TERRAZZO +20 FD772**; 33.0-37.5 kg 1-3 mm/3-6 mm/6-9 mm aggregate mixture) is applied evenly with a trowel and compacted.

At least 48 hours after the application, the cast terrazzo layer is wiped with 30, 50, 120 grit using a grinder machine suitable for terrazo and sequential diamonds, respectively, to reveal the desired aggregate texture. After revealing the aggregates, the smooth terrazzo layer should be completed by polishing with 50, 100, 200, 400, 800, 1,500, 3,000 diamond resin pads and Shine Pro Buff in order to remove traces of diamond polishing and polishing the coating.
800,1500,3000 diamond resin pad and Shine Pro Buff polishing should be continued according to the desired shine surface.)

Note: If pores are seen on the surface after wiping with 50 resin pads, the terrazzo surface should be cured with **FOX DOMINO® FILLER FD775** mixture at a consumption of approximately 0.10-0.15 kg/m². The cured surface should be polished with 50, 100, 200, 400, 800, 1,500, 3,000 diamond resin pads and Shine Pro Buff, respectively, and the smooth terrazzo layer should be completed.

(800,1500,3000 diamond resin pad and Shine Pro Buff polishing should be continued according to the desired shine surface.)

B. Cement Terrazzo Curing Application

FOX DOMINO® FILLER FD775 is a cement-based, high-strength, fast-applicable, early-setting grouting material specially developed for the **FOX LYCIA CEMENT TERRAZZO** system.

Technical Properties

Density		2,25±0,05 gr/cm^3
Adhesion Strength	concrete	≥1,5 N/mm^2
Percentage of Total Solids		%100
Floor Temperature		+10°C /+30°C
Working Time		20-30 min

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

Before starting the mixing, make sure that the product temperatures are between +20°C and +25°C. 20 kg **FOX DOMINO® FILLER FD775** is mixed with 6.40±0.20 liters of water. Avoid overmixing to minimize air entrainment.

FOX DOMINO® FILLER FD775 grouting mixture is applied by scraping method over the cement-based **FOX LYCIA CEMENT TERRAZZO** coating. The cured surface should be polished with 50, 100, 200, 400, 800, 1,500, 3,000 diamond resin pads and Shine Pro Buff, respectively, and the smooth terrazzo layer should be completed.

(800,1500,3000 diamond resin pad and Shine Pro Buff polishing should be continued according to the desired shine surface.)

3.5. Top Coat Protection Primer Application:

FOX DOMINO® PU SEALER FD793 is a polyurethane-based, single-component, aliphatic, solvent-based, water-repellent, topcoat protection material**.**

Technical Properties

Density	0,96 gr/cm^3
Colour	Transparent
Percentage of Total Solids	%56
Thinning	Not Thinning
Floor Temperature	+10°C /+35°C
Drying Time	2-3 hours
Walkable Time	7-8 hours
Time to Show Effect	24-48 hours

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application:

Apply **FOX DOMINO® PU SEALER FD793** to the surface in two layers with a short pile velvet roller, consuming approximately 100-150 gr/m².

3.6. Topcoat Application:

FOX PURATHANE® TOPCOAT WB is a modified polyurethane-based, two-component, water-based, high abrasion resistance, aliphatic isocyanate-containing, non-yellowing, UV resistant, antibacterial, top coat coating material.

Technical Properties

Density		1,10 gr/cm^3
Colour		Transparent
Working Time		60 min
Solids Percentage		%40-50
Thinning		NOT Thinning
Water Vapor Permeability		16000µ
Pendulum Hardness	König ISO 1522	86s
Taber Abrasion Test	1kg.CS 10,1000 d	40 mg
Operating temperature		+10°C /+30°C
Full Curing		7 days

The above values are given for +23°C and 50% relative humidity. High temperatures shorten the time, low temperatures lengthen the time.

Application

Mix the A component product thoroughly using an electric mixer and a suitable mixing tip until it is homogeneous and there is no product left on the bottom or edges of the container. After completely adding the B component product into the A component product, mix for at least 3 minutes until you obtain a homogeneous mixture. Avoid overmixing to minimize air entrainment. (Mixing tools: a 300-400 rpm electric mixer and epoxy/polyurethane resin mixing tip.)

FOX PURATHANE® TOPCOAT WB should be applied to the surface in two layers using a short-pile velvet roller, with a consumption of approximately 100-150 gr/m². In order to minimize roll marks, care must be taken to ensure that successive layers are wet. Application should be made along the short edge and each new application should be made right next to the previous one. The material should be passed over again with a second roller to ensure that the material is distributed homogeneously and that no roller marks remain.

Primer and consumptions in the systems are given as predictions. Depending on the ground condition and environmental conditions; Primer and consumables may vary. Consumption calculation was made based on 23°C ambient and material temperature. Consumption may increase in hot and cold weather.