

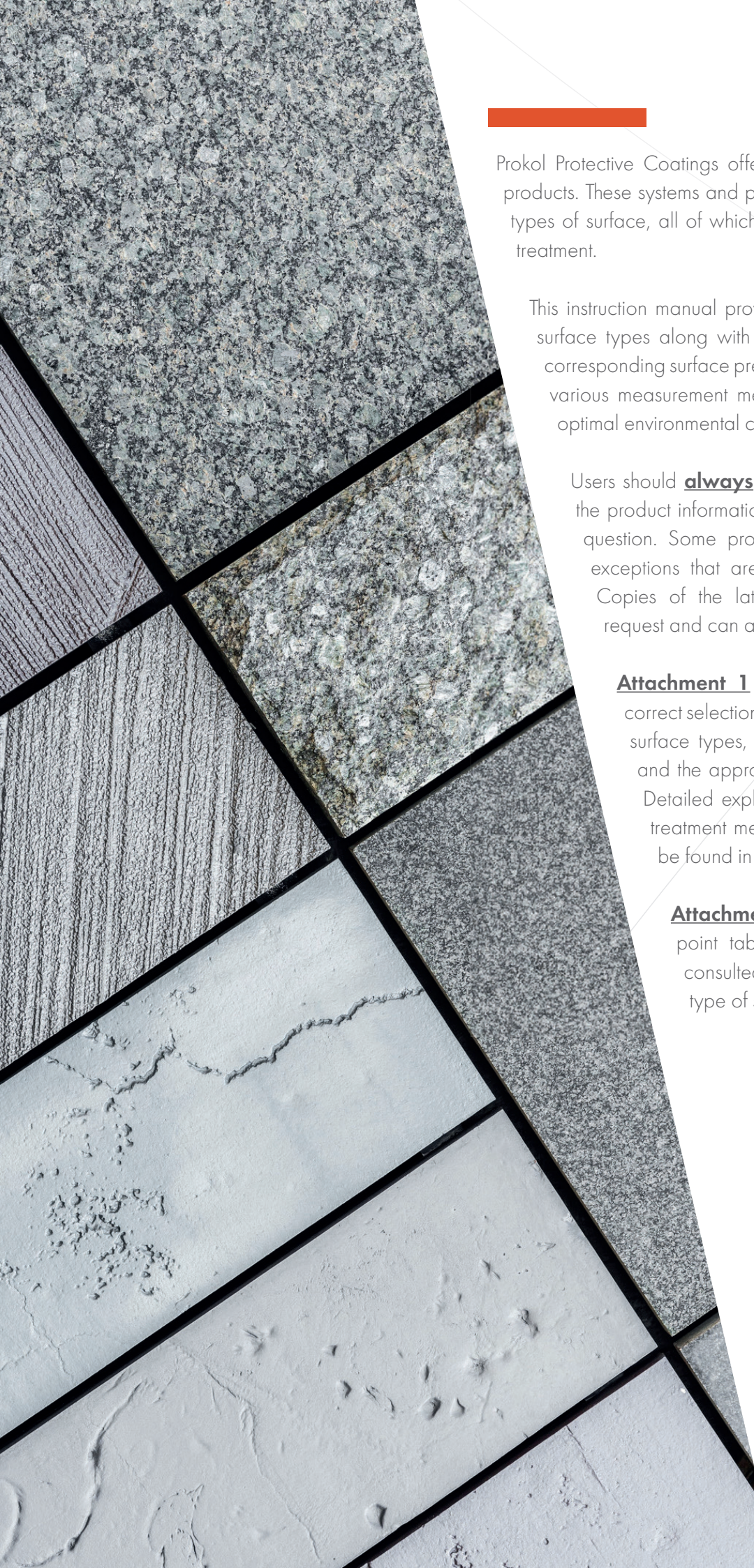
Prokol



Instruction manual: Surface pre-treatment

Versie 1.0 - 2025





Prokol Protective Coatings offers a wide range of systems and products. These systems and products can be applied to various types of surface, all of which require appropriate surface pre-treatment.

This instruction manual provides an overview of the different surface types along with step-by-step procedures for their corresponding surface pre-treatment. Additionally, it includes various measurement methods and information regarding optimal environmental conditions.

Users should **always** consult the most recent edition of the product information sheet for the specific product in question. Some products may have product-specific exceptions that are **not** included in this document. Copies of the latest editions are available upon request and can also be found at www.prokol.com.

Attachment 1 contains a primer table for the correct selection, presenting a clear overview of all surface types, the correct surface pre-treatment, and the appropriate primer(s) (where required). Detailed explanations of the surfaces and pre-treatment methods referenced in the table can be found in this instruction manual.

Attachment 2 provides a readable dew point table. This table should always be consulted, as it is inextricably linked to each type of surface and situation.

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1. Surface conditions & requirements

1.1 General information

For optimal results, surface pre-treatment is one of the most critical factors in ensuring a well-functioning Prokol system. This applies to all applications, from floors and roofs to pipelines and tank linings.

A surface must be dry, clean, and free of grease and substances that may reduce adhesion (including rust). It should be free from loose or hollow-sounding sections, roughened, and free from water or moisture films on the surface, as well as lateral or rising damp.

Any cracks or irregularities in the surface must be repaired or levelled using suitable materials, applied professionally—also with regard to the finishing layer.

The surface must be suitable for the intended purpose. Existing expansion joints in the surface must not be concealed but must retain their function. In some cases, the use of an expansion profile may be desirable.

The choice of primer depends on the surface. In such cases, consult the primer table in **attachement 1**. When in doubt, always contact your representative for advice.

The surface must comply with the prescribed flatness class. When applying self-levelling products, the slope must not exceed 0.5% (5 mm per meter) up to a maximum of 1% (10 mm per meter), depending on the type of coating.

If underfloor heating is present, the heating-up and cooling-down protocol, as prescribed by BA Guideline 2.1 of the Dutch Finishing Trades Organisation (Bedrijfschap Afbouw), must be completed before the synthetic system is applied.

Any drainage points must be watertight before the screed layer is installed.

1.2 Mineral surfaces

The surface must be pressure-resistant and stable, with a minimum compressive strength of 25 MPa (25 N/mm²) and a minimum adhesion strength of 1.5 MPa (1.5 N/mm²) for normally loaded areas, and 2 MPa (2 N/mm²) for heavily loaded areas (e.g. car parks).

Mineral and concrete surfaces must be at least 28 days old. Any cement skin or loose sand-cement layer must be removed. Smooth and dense monolithic surfaces should be roughened, for example, by dust-free blasting and/or diamond grinding. Afterwards, the surface must always be vacuumed using an industrial vacuum cleaner.

Contaminated surfaces must be treated by chemical cleaning, rinsing, drying, and subsequently sanding.

The residual moisture content of a mineral or concrete substrate must not exceed 4%. To determine the moisture content, carry out a test using one of the methods explained in the chapter “research & measurement methods”.



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For heavily loaded systems, such as parking decks and gas stations where torsional forces may occur, it may be desirable to lightly broadcast the primer layer with fire-dried quartz sand (0.3 – 0.8 mm). **Be aware:** do not fully saturate; a closed grain structure must be avoided.

A monolithic concrete floor must be installed in accordance with NEN 2743 and NEN 2747, with quality class C20/25 or C28/35.

A cement-bound screed must comply with NEN 2741, 2742, and 2747, with a quality class of Cw16.

Saw cuts (unless functioning as expansion joints) and defects such as pits/holes must be repaired with a suitable filler/mortar/paste (depending on the situation). **Be aware:** do not repair with epoxy.

Depending on surface porosity, a second primer layer may be required.

Suitable mineral surfaces

- Sand-cement
- Concrete

1.3 Calcium sulphate surfaces

The surface must be pressure-resistant and stable, with a minimum compressive strength of 25 MPa (25 N/mm²) and a minimum adhesion strength of 1.5 MPa (1.5 N/mm²) for normally loaded areas, and 2 MPa (2 N/mm²) for heavily loaded areas (e.g. car parks).

Calcium sulphate surfaces must be at least 28 days old. Any cement skin or loose sand-cement layer must be removed. Smooth and dense monolithic surfaces should be roughened by dust-free blasting and/or diamond grinding. Always vacuum the surface thoroughly with an industrial vacuum cleaner.

The residual moisture content must not exceed 0.5% (0.3% in combination with underfloor heating). To determine this, use the Calcium Carbide Method as explained in the chapter "research & measurement methods".

Floating screeds must always be loose from adjacent elements such as walls and columns using edge strips.

Timely sanding accelerates the drying process of the anhydrite screed.

Saw cuts (unless functioning as expansion joints) and defects such as pits/holes must be repaired with suitable filler/mortar/paste.

An anhydrite screed must be installed in accordance with CUR Recommendation 107 and NEN 2747 with a quality class of CW16 and Fw4.

Sand anhydrite floors and apply a deeply penetrating primer to strengthen the surface. Then apply a second primer



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layer to fully seal the surface.

If levelling is required, do not use a cement-based levelling compound without first applying a primer. The screed must not contain gypsum plaster.

Suitable calcium sulphate surfaces

- *Anhydrite*
- *Gypsum*

1.4 Metal surfaces

The surface must be clean and free of grease and any loose material. It should also be free from substances that may impair adhesion. If such substances are present, they must be removed using suitable methods.

Sanding: Mechanically and thoroughly roughen the surface to a matte finish. Then vacuum thoroughly. To choose a suitable primer, please consult the primer table in **attachement 1**.

Blasting: Sa 2.5, 75–100 microns, according to DIN EN ISO 12944. Then remove all dust and treat accordingly.

Zinc-based gutters must be exposed to the weather for at least six months before coating.

Suitable metal surfaces

- *Aluminium types*
- *Steel types (incl. stainless steel)*
- *Zinc types*
- *copper types*
- *Gavanised materials*

1.5 Wooden surfaces

The surface must be pressure-resistant, stable, permanently dry, clean, and free of cracks and any substances that could impair adhesion. The moisture content must not exceed 12%.

Wooden surfaces must be non-porous. Pressed materials are preferred due to their low moisture absorption. In some cases, a primer may be required. Consult the primer table in **attachement 1**. Always consult for advice if in doubt.

In the case of hardwood, it is essential to carry out an adhesion test.

Suitable wooden surfaces

- *Hardwood (beech, birch, oak, meranti, azobéé)*
- *Softwood (spruce, pine, Douglas)*
- *Sheet material (MDF, HDF, triplex, multiplex, plywood)*



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1.6 Synthetic surfaces

The surface must be pressure-resistant, dry, clean, crack-free, and free of adhesion-inhibiting substances. Synthetic surfaces must be non-porous.

Old 2-component layers must be thoroughly roughened by blasting or sanding and then primed with a suitable primer. Always check old coating layers for signs of delamination. When in doubt, apply a test area.

When applying primer to existing synthetic resin finishes, the existing coatings must be resistant to any solvents present in the primer. Consult the primer table in **attachment 1**. Always consult for advice if in doubt.

Extra attention should be paid to synthetic films, as algae growth may be a hidden risk on such surfaces.

Existing expansion joints must not be covered but must retain their function.

Cracks or gaps may need to be sealed in advance using MS- or polyurethane polymer sealants.

The load-bearing capacity of synthetic substrates depends on their compressive strength and cannot be compensated by a liquid synthetic system.

In the case of new EPDM or PVC, an adhesion test is **strongly recommended**.

Adhesion on synthetic roofing membranes varies by brand. An exception is **TPO roofing**; due to its composition, reliable adhesion is not possible.

Suitable synthetic surfaces

- Existing synthetic layers (coatings, cast-flooring etc.)
- Polymers (paint, hot-spray)
- Elastomers (rubber)
- Polyester
- EPDM
- PVC

1.7 Bituminous surfaces

Bituminous roofing must have been exposed to weather conditions for at least six months.

Bituminous surfaces must be clean, dry, and free of algae, grease, and other substances that could impair adhesion. Loose parts must be secured beforehand. In some cases, a primer may be required. Consult the primer table in **attachment 1**. Always consult for advice if in doubt.

Always pay extra attention to seams, upstands, and overlaps. It is recommended to reinforce these areas with a reinforcing fleece.

Bituminous surfaces may exhibit slight bleeding.



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Be aware: Asphalt parking decks are not suitable.

Suitable bituminous surfaces

- *Bitumen*
- *Asphalt*

1.8 Tiles

The surface must be dry, clean, and crack-free, and free of any substances that could impair adhesion.

In most cases, a primer is required. Consult the primer table in **attachment 1**. Always consult for advice if in doubt.

1.9 Glass

The surface must be dry, clean, and crack-free, and free of any substances that could impair adhesion.

In most cases, a primer is required. Consult the primer table in **attachment 1**. Always consult for advice if in doubt.



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2. Environmental conditions

When applying Prokol products and systems, ensure that the correct environmental conditions and site circumstances are maintained. Allow all products to acclimatise to local conditions for at least 24 hours prior to use. Avoid significant temperature differences between the product and the surface, as this may negatively affect the final result.

Ensure all materials are sorted and prepared in advance, and work carefully. It is not possible to extend or interrupt a product's curing time. Provide good working conditions, including adequate lighting, appropriate personal protective equipment (PPE), and a suitable mixing area.

Indoor areas must be fully enclosed and both water- and airtight. Ensure that sufficient ventilation is available.

2.1 Surface-, environment- and product temperature

For most products, the following applies:

- **Product temperature:** a minimum of +15 °C and a maximum of 25 °C
- **Surface temperature:** a minimum of +12 °C and maximum of 50 °C
- **Environment temperature:** a minimum of +12 °C and maximum of 35 °C

Be aware! Temperature values are product-dependent, and for some products, different limits may apply. Always consult the relevant product datasheet for your specific project — these values take precedence.

The optimal application temperature is between 18 °C and 20 °C. Curing will proceed more rapidly at higher temperatures and more slowly at lower temperatures. The pot life is also influenced by product temperature and relative humidity (RH).

Be aware: Do not leave the mixed product in its container. Excess material left in a container can cause smoke and odour nuisance due to the exothermic reaction. Avoid leftover material, or mix generously with sand and use immediately. Always store empty containers in a well-ventilated area.

2.2 Relative Humidity

For most products, application of (2-component) products should only take place when the relative humidity is below 85%.

For certain products, different values may apply. Always check the relevant product datasheet to determine what is applicable to your project — those values are leading.



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2.3 Dew point

The dew point is the temperature at which moisture begins to condense on a surface. When condensation is present, coatings cannot adhere properly.

The dew point can be determined based on the environment temperature and relative humidity. A dew point table (see **attachment 2**) can be used for this purpose. However, using a dew point meter is preferred. This device allows direct reading of the relative humidity, environment and surface temperatures, and the dew point itself.

Before and during application of a coating, as well as throughout the curing process, the surface temperature must be at least 3 °C above the dew point.



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3. Research & measurement methods

3.1 Moisture content

Before applying the product, measure both the moisture content of the surface and the relative humidity. Use these values to determine the dew point using the dew point table provided in **attachement 2**.

The moisture content in the surface can be measured using a Tramex moisture meter or by using one of the methods described below.

Method 1: Plastic sheet test

There must be no rising or residual moisture present in the substrate. To check for this, a plastic sheet test (in accordance with ASTM D 4263) can be performed. Follow these steps:

1. Cut a piece of plastic sheet (minimum 50 × 50 cm) and tape it airtight to the surface to be tested. Preferably select an area suspected to contain the highest moisture content.
2. Leave the sheet in place for 16 hours at a minimum of 15 °C.
3. After this period, inspect the inside of the sheet for condensation or check whether the surface appears darker.



If condensation is present after 16 hours, this indicates rising or residual moisture, and the surface requires more drying time before proceeding with the project.

If the underside of the sheet remains dry, there is no indication of rising or residual moisture, and you may continue with the project.

Method 2: Calcium Carbide

The Calcium Carbide Method is used in combination with a CM (Carbide Method) testing device. Follow these steps:

1. Take a sample of the surface and crush it into the smallest possible particles.
2. Place the pre-weighed sample, steel balls, and the calcium carbide ampoule into a sealed steel pressure vessel.
3. Close the vessel securely.
4. Shake the vessel thoroughly for several minutes.
5. The carbide reacts with any moisture in the sample, producing gas and increasing the pressure inside the vessel. The resulting pressure (measured with a manometer) corresponds to the moisture content, which can be read using a reference chart.



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3.2 Adhesion & compressive strength

The adhesion strength of the surface can be measured using an adhesion tester. Compressive strength can be measured using a Schmidt Hammer. Follow the steps below:

1. Remove the hammer from its case and press the tip of the steel plunger against a hard surface to release it from the locked position.
2. Position the hammer vertically and place the tip of the plunger against the concrete.
3. Apply gradual pressure until the hammer rebounds.
4. While the hammer is still pressed against the concrete, read the rebound value. The compressive strength of the concrete can be determined using the calibration chart on the hammer.



To determine compressive strength with greater accuracy, core samples must be taken and tested using a compression testing machine.

3.3 Flatness of the surface

A self-levelling floor, floor coating, or other synthetic finish will follow the surface precisely and will not improve surface flatness. Therefore, before applying any (synthetic) flooring system, it is essential to assess the flatness of the surface so that corrective measures, such as grinding or levelling, can be carried out if necessary.

Flatness can be easily assessed using a straightedge (preferably 2 to 3 metres long, aluminium or steel) and a wedge gauge or feeler gauge. Follow these steps:

1. Place the straightedge at various random locations on the surface, ensuring it makes full and firm contact with the surface.
2. Check for visible gaps between the straightedge and the surface.
3. Use a wedge or feeler gauge to measure the size of the gaps.
4. Record the variations in height and compare the values with the relevant standards and tolerances, such as NEN 2747.

Perform measurements in multiple places and directions (lengthwise, widthwise, and diagonally) to gain a complete picture of the surface flatness.



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3.4 Surface roughness depth

The average surface roughness of a horizontal surface can be determined using the sand patch method. To ensure sufficient total system thickness (including primer or primer/screed), the maximum surface roughness (Sr) must not exceed 1.5 mm. If the surface roughness is greater than 1.5 mm, a levelling layer must be applied. Surface roughness must be assessed after surface preparation.

The average surface roughness (Sr) is defined as the height of a theoretical cylinder with a known diameter (d) and sand volume (V). Follow these steps for the sand patch method:

Required materials

- Measured volume $V = 50 \text{ cm}^3$
- Oven-dried quartz sand (grain size 0.1 – 0.3 mm)
- Circular wooden disc (Ø 50 mm, thickness 10 mm)
- Ruler or tape measure



A defined volume of sand (volume V) must be distributed over the surface in a circular manner, ensuring that all surface indentations are completely filled with quartz sand.



Measure the diameter afterwards

$$\text{Formule } S_r = \frac{V \times 4}{\pi \times d^2} \times 10$$

Calculation of surface roughness depending on the size of the circle:

Diameter circle (cm)	10	15	20	25	30	35	40	45
Surface roughness (mm)	6.40	2.83	1.59	1.02	0.71	0.52	0.40	0.31



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3.5 Profiling of a concrete surface

The International Concrete Repair Institute (ICRI) defines nine surface profiles for proper surface preparation and has developed reference sample chips to give users a visual guide. These reference chips are available from ICRI. Each profile is designated with a CSP (Concrete Surface Profile) number, ranging from 1 (nearly smooth) to 9 (very rough).

The concrete surface must be properly pre-treated — clean, free of laitance and contamination — by means of blasting or similar mechanical surface pre-treatment methods. A CSP-3 to CSP-4 finish is typically required, depending on the thickness of the coating system.

CSP-1	-	Acid etching*
CSP-2	-	Grinding
CSP-3	-	Light blasting
CSP-4	-	Light milling
CSP-5	-	Medium blasting
CSP-6	-	Medium milling
CSP-7	-	Heavy blasting
CSP-8	-	Scarifying
CSP-9	-	Heavy milling



CSP-reference chips

* Acid etching involves the use of chemicals such as hydrochloric acid, phosphoric acid, or sulfamic acid to roughen the surface. However, acid etching is not recommended due to the risk of insufficient neutralisation and concerns related to health, safety, and environmental impact.



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4. Surface pre-treatment

4.1 Cleaning & degreasing

The surface must be clean and free of grease, loose particles, and any substances that may impair adhesion. If such contaminants are present, they must first be removed using appropriate methods and products.

Contaminated and greasy surfaces (e.g. oil and grease) should preferably be cleaned using a steam cleaner in combination with suitable cleaning agents.

If cleaning does not result in a sound, load-bearing surface, the surface should be prepared by (flame) blasting, and in some cases milling. After grinding or sanding, the surface must be thoroughly vacuumed using an industrial vacuum cleaner. Be aware that sanding can clog the pores of the surface with fine dust, which may impair adhesion.

4.2 Grinding & dust removal

Grinding or roughening the surface is carried out using a diamond grinding machine. These machines are commonly used for grinding floors, removing old coatings, or levelling surfaces.

A diamond grinding machine is an electric tool used for grinding and polishing hard materials such as concrete, stone, ceramics, and old coatings. It uses diamond-impregnated pads or discs due to diamond's hardness, enabling fast and effective material removal. Diamond grinding can be performed entirely dust-free.

Be aware: Do not grind monolithically finished floors with abrasive discs containing hard grits such as aluminium oxide (corundum) or silicon carbide (carborundum). These will polish rather than roughen the concrete surface, negatively affecting adhesion.

4.3 Blasting & dust removal

Blasting or shot blasting is a method of surface preparation using abrasive materials such as sand, metal shot, or glass beads. This method can be carried out completely dust-free.

Dust-free blasting is performed using a specialised machine that collects and filters dust during the process, keeping the working environment clean. The abrasive medium is reused within a closed-loop system, preventing dust dispersion.

4.4 Milling and dust removal

Milling involves the use of a rotating cutting tool (the mill) to treat the surface of the floor. This process removes irregularities, old coatings, or contaminants, leaving behind a clean, even surface that promotes good adhesion.



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Be aware: Milling may cause microcracks or damage to the surface. It is therefore advisable to follow milling with blasting to properly prepare the surface for further treatment.



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5. Important information

5.1 Health & safety

Always observe the appropriate safety precautions when using Prokol products and systems, and wear the specified personal protective equipment (PPE). Always consult the relevant safety data sheets (SDS) before application, and keep them, along with the original packaging, readily available in case of accidents.

5.2 Legal notification

The information and, in particular, the recommendations concerning the application and final use of Prokol products is issued in good faith based on Prokol's current knowledge and experience of products that are correctly stored, handled and applied under normal conditions.

In practice, the differences in materials, surfaces and local conditions are such that no guarantee can be given concerning the marketability or suitability for a certain objective, nor can any liability arise from any legal relationship based on this information, nor from any written recommendations or other advice that is given. The property rights of third parties must be respected.

Prokol guarantees that its products are free from manufacturing faults. Multi-component products are a finished product once the components have been mixed and processed. When mixed and processed correctly, the product will achieve the specifications given. Prokol can only guarantee the product when surfaces are processed and pre-treated correctly.

Users must always refer to the most recent product safety information sheet and product information sheet for the product concerned. Copies of the most recent editions are provided upon request and are available at www.prokol.com.

All our deliveries, acceptance of assignments, communications, advice, and agreements are subject to our general terms and conditions of delivery, filed with the Chamber of Commerce in Eindhoven under number 52327159. Any other terms and conditions are hereby expressly rejected.

The publication of this manual surface pre-treatment (version 1.0 - 2025) makes all previous versions invalid.



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A large, dark gray, textured surface, likely concrete, with a prominent vertical crack running down the left side. The surface is slightly uneven with some small pits and discolorations.

Attachments

Attachment 1: Primer table

Attachment 2: Dew point table

Attachement 1: Primer table

		Pre-treatment								Primer type											
	More information on page:	Degrease, remove loose particles & let dry	Roughen & dedusting	(Diamond)Sanding & dedusting	Remove top layer & dedusting	Blasting(steel Sa 2,5/90) & dedusting	Wet cleaning, degreasing & let it dry	TX Adhesion Promotor	Mandatory adhesion test	Rocapox Primer GV-M	Rocapox Primer GV-M TX	Rocapox Primer ELT	Rocapox Resin 100	Rocapox Resin 100-TX	Rocapox Epoxy Gel	Rocapox Screed	Rocathaan Primer SG4	Rocathaan Primer UNI	Rocathaan Primer UNI-RW	Rocathaan Primer OV	ProFast Primer RW
Surface																					
Anhydrite	6			①						Opt		✓	Opt								
Asphalt	8					①	①													✓	
Aluminium new	7	①		②				③										✓			✓
Aluminium corroded	7	①						②										✓			✓
Concrete	5					①				✓			✓		Opt	Opt					✓
Plywood with melamine coating	8	①			②					✓			✓								
Bitumen (+6 months old)	8	①																✓			
EPDM	8								①												
Glass	9							①			✓			✓				✓			✓
Hardwood	7								①				✓								
Sheet material	7	①															✓				
Soft wood	7	①															✓				
Excisting synthetic layers	8		①	②														✓			✓
Copper neww nieuw	7		①				②			✓			✓					✓			✓
Copper corroded	7	①								✓			✓					✓			✓
Polyester	8		①							✓			✓					✓			✓
PVC*	8								①												
Stainless steel	7		①					②					✓								
Steel	7					①		②											✓		✓
Tiles glazed	9			①				②					✓								Opt
Tiles unglazed	9	①						②						✓							
Electrolytically galvanised steel	7	①	②					③										✓			
Hot-dip galvanised steel	7	①	②					③										✓			
Corroded galvanised steel	7	①								✓			✓					✓			✓
Sand cement	5			①						✓			✓			Opt					✓
Zinc new	7	①	②					③		✓			✓					✓			✓
Zinc corroded	7	①						②		✓			✓					✓			✓

Explanation

- ① First pre-treatment
- ② Second pre-treatment
- ③ Third pre-treatment
- Opt Optional second when necessary
- ✓ Suitable primer. Choice depending on situation

Basic conditions:

The surface needs to be always clean, dry, without loose parts and free of grease. Check always the compatibility with cleaning products. This table is only a guide. No right can be claimed based in this. In case of doubt please contact your contact person.

* As long as a UV filter is present, only limited adhesion will occur.



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Attachment 2: Dew point table

Air temperature	Dew point temperature in °C at a relative humidity of										
	45%	50%	55%	60%	65%	70%	75%	80%	85%	90%	95%
2 °C	-7,77	-6,56	-5,43	4,40	-3,16	-2,48	-1,77	-0,98	-0,26	0,47	1,20
4 °C	-6,11	-4,88	-3,69	-2,61	-1,79	-0,88	-0,09	0,78	1,62	2,44	3,20
6 °C	-4,49	-3,07	-2,10	-1,05	-0,08	0,85	1,86	2,72	3,62	4,48	5,38
8 °C	-2,69	-1,61	-0,44	0,67	1,80	2,83	3,82	4,77	5,66	6,48	7,32
10 °C	-1,26	0,02	1,31	2,53	3,74	4,79	5,82	6,79	7,65	8,45	9,31
11 °C	-0,40	1,00	2,30	3,50	4,70	5,80	6,70	7,70	8,60	9,40	10,20
12 °C	0,35	1,84	3,19	4,46	5,63	6,74	7,75	8,69	9,60	10,48	11,33
14 °C	2,20	3,76	5,10	6,40	7,58	8,67	9,70	10,71	11,64	12,55	13,36
15 °C	3,12	4,65	6,07	7,36	8,52	9,63	10,70	11,69	12,62	13,52	14,42
16 °C	4,07	5,59	6,98	8,29	9,47	10,61	11,68	12,66	13,63	14,58	15,54
17 °C	5,00	6,48	7,92	9,18	10,39	11,48	12,54	13,57	14,50	15,36	16,19
18 °C	5,90	7,43	8,83	10,12	11,33	12,44	13,48	14,56	15,41	16,31	17,25
19 °C	6,80	8,33	9,75	11,09	12,26	13,37	14,49	15,47	16,40	17,37	18,22
20 °C	7,73	9,30	10,72	12,00	13,22	14,40	15,48	16,46	17,44	18,36	19,18
21 °C	8,60	10,22	11,59	12,92	14,21	15,36	16,40	17,44	18,41	19,27	20,19
22 °C	9,54	11,16	12,52	13,89	15,19	16,27	17,41	18,42	19,39	20,28	21,22
23 °C	10,44	12,02	13,47	14,87	16,04	17,29	18,37	19,37	20,37	21,34	22,23
24 °C	11,34	12,93	14,44	15,73	17,06	18,21	19,22	20,33	21,37	22,32	23,18
25 °C	12,20	13,83	15,37	16,69	17,99	19,11	20,24	21,35	22,27	23,30	24,22
26 °C	13,15	14,84	16,26	17,67	18,90	20,09	21,29	22,32	23,32	24,31	25,16
27 °C	14,08	15,68	17,24	18,57	19,83	21,11	22,23	23,31	24,32	25,22	26,10
28 °C	14,96	16,61	18,14	19,38	20,86	22,07	23,18	24,28	25,25	26,20	27,18
29 °C	15,85	17,58	19,04	20,48	21,83	22,97	24,20	25,23	26,21	27,26	28,18
30 °C	16,79	18,44	19,96	21,44	23,71	23,94	25,11	26,10	27,21	28,19	29,09
32 °C	18,62	20,28	21,90	23,26	24,65	25,79	27,08	28,24	29,23	30,16	31,17
34 °C	20,42	22,19	23,77	25,19	26,54	27,85	28,94	30,09	31,19	32,13	33,11
36 °C	22,23	24,08	25,50	27,00	28,41	29,65	30,88	31,97	33,05	34,23	35,06
38 °C	23,97	25,74	27,44	28,87	30,31	31,62	32,78	33,96	35,01	36,05	37,03
40 °C	25,79	27,66	29,22	30,81	32,16	33,48	34,69	35,86	36,98	38,05	39,11
45 °C	30,29	32,17	33,86	35,38	36,85	38,24	39,54	40,74	41,87	42,97	44,03
50 °C	34,76	36,63	38,46	40,09	41,58	42,99	44,33	45,55	46,75	47,90	48,98

The dew point shows at which temperature condensation starts forming on the substrate depending on the air temperature and the relative humidity of air.

Example: With an air temperature of 20°C and 70 % relative humidity of air, condensation starts when the substrate temperature is 14,40°C. If the contact thermometer shows a value below 17,4°C (14,40° + 3° safety factor), application of coatings should not be carried out.

Take into account the minimum and maximum application temperatures of the product you are using. These will vary depending on the type of product.



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