

# weberfloor industry rapid 4655

## Rapid drying self-smoothing industry screed & resin receiver

- Industrial areas
- Suitable for solid bonded substrates
- Ideal for receiving epoxy and polyurethane coatings

### About this product

**weberfloor industry rapid 4655** is a pump or hand applied, self-smoothing, rapid drying screed, which can level industrial substrates ready to receive epoxy or polyurethane coatings. The product is formulated from special cements, aggregates and chemical admixtures.

**weberfloor industry rapid 4655** is designed for the use in industrial areas allowing a much earlier overlay and a better performance compared to traditional screeds, concrete or anhydrite screeds.

### Features and benefits

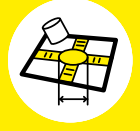
- For application depths between 4-15mm
- Pump or hand applied
- Rapid drying
- Foot traffic after 1-2 hours
- Final floor covering installed after 24 hours in normal conditions
- Flat and smooth finish minimises wear
- High durability towards mechanical stress - long lifetime
- Ideal as a resin coating receiver
- Low alkalinity
- Casein-free
- Low emissions



FOOT TRAFFIC



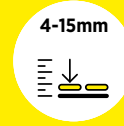
PUMP OR  
HAND APPLIED



FLOW TEST  
230-250 MM



1-2 DAYS  
FINAL  
COVERING TIME



4-15mm  
APPLICATION  
DEPTH



5L  
20%  
ADD WATER



RAPID SET



## Uses

For levelling solid bonded substrates:

- Concrete
- Base screeds
- Anhydrite screeds

Suitable for covering with:

- Epoxy resin coatings
- Polyurethane coatings

## Constraints

- Not to be left without a suitable floor covering.

## Preparation

The surface strength of the substrate must be greater than 1.5N/mm<sup>2</sup>.

It is essential the substrate is suitably prepared and primed with **weberfloor 4716 primer** prior to installing the Weber floor screed.

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.

Large irregularities in the substrate (>15mm) should be filled in with a application of **weberfloor base rapid 4360**, this should be allowed to harden and then primed before application of **weberfloor industry rapid 4655** can begin.

Holes and leaks in the substrate should be sealed. The substrate should be vacuum cleaned, prepared and primed with **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 industry rapid 4655** is mixed with clean water using an automatic screed mixer approved by Weber.

The material is mixed with 20% water, which corresponds to 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 230-250mm. 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 serrated spatula or spike roller should be used to assist the self-levelling process.

## Overlay

**weberfloor industry rapid 4655** is compatible with most epoxy and polyurethane resin coatings.

If the substrate is suitably dry **weberfloor industry rapid 4655** is ready to receive a resin coating after 24 hours.

It should not be left without a final floor finish.

## Drying time

The screed can receive foot traffic after a drying time of 1 - 2 hours at an ambient temperature of +20°C. If necessary, the surface can be ground after 1 days following application.

Floor covering can be installed after 24 hours depending on layer thickness and drying conditions.

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

## Packaging

**weberfloor industry rapid 4655** is packed in 25kg polythene-lined paper sacks.

## 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 <sup>2</sup>
Minimum thickness	4mm
Maximum thickness	15mm
Water demand	5 litres/ 25kg (20%)
Compressive strength	C 30
Flexural strength	F 8
Shrinkage (28 days)	< 0.07%
Weber flow rate	230 - 250mm
Approx. material consumption	1.7kg/ m <sup>2</sup> / mm
Hardening time (before foot traffic)	1-2 hours in normal conditions
Hardening time (before final covering)	24 hours depending on layer thickness and drying conditions
Pot life	20 min (after adding water)
Pendulum Test Value (dry)	66 - Low potential for slip*
Pendulum Test Value (wet)	45 - Low potential for slip*
Pendulum Test Value (oil)	22 - High potential for slip*

\* Whilst these results are typical of what we would expect, we would recommend that tests are also undertaken on site.

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