

APPLICATION GUIDE

PRE-FORM 100

Use **Pre-Form 100** for temperatures between 60° F (15° C) and 90° F (32° C)
Use **Pre-Form 100 FC** for temperatures between 50° F (10° C) and 70° F (21° C)

Pre-Form 100 seals and protects plywood form surfaces, creating an impact-resistant, glossy, seamless, smooth and long-lasting casting surface by eliminating concrete surface voids and other surface irregularities. Sealing plywood forms prevents wood grain transfer and protects concrete surfaces from sugar-related discoloration and staining.

EQUIPMENT REQUIRED

- Heavy-duty drill fitted with a flat-blade mixing paddle
- 3 buckets or suitable measuring and mixing vessels
- Notched squeegee or roller applicator
- 3/8 (1.0 cm) nap cover
- Spiked roller
- Wet Film Thickness Gauge
- Spiked Shoes for working on wet surface

FORM PREPARATION

New Plywood Forms: Clean and dry forms until they are free from dust, dirt and all foreign matter. Fasten down the wood substrate and fill any large imperfections, holes and joints.

Previously Sealed Plywood Forms: Sand with an orbital floor sanding machine using 100-grit sandpaper. Fill any large imperfections, holes and joints. Then scrub forms with Nox-Crete's Bio-Clean citrus based degreaser and rinse with water. Allow forms to dry prior to Pre-Form 100 application.

All Plywood Forms:

- Dam form edges to prevent Pre-Form 100 from dripping off the sides.
- Calculate the surface area to be coated with Pre-Form 100 and divide the total area into small batch quantities. Mark the form surface to indicate the areas that will be covered by each batch. SEE COVERAGE RATE [TABLE 3 ON PAGE 2](#)
 - » For example, if the area to be coated is 450 ft² with a heavy film thickness (32 mil) desired, mark off three 150 ft² sections, then mix and apply one 3 gallon batch at a time to allow for ample work time before product starts to cure and a consistent surface finish.

PRODUCT PREPARATION

The correct mixing ratio is 2 parts Component A (epoxy resin) to 1 part Component B (hardener). **Failure to properly mix components will negatively affect product performance.**

MEASURING

- To mix a pre-measured 4 gallon (15.1 L) kit, simply pour Component B into the Component A bucket and mix for 3-4 minutes.
- 1. To mix bulk product, use exact measurements to measure two (2) parts Component A and one (1) part Component B by volume in separate containers. SEE MIX RATIO [TABLE 1](#) AND [TABLE 2](#) ON PAGE 2
- 2. Pour the pre-measured components A and B into a third container, suitable for mixing.
- 3. *If applicable, measure and add .9 lb of red pigment OR 1.72 lb of white pigment per gallon to the mixture. SEE OPTIONAL MIX RATIO [TABLE 4](#) ON PAGE 2*

MIXING

- Mix properly measured Components A & B thoroughly for 3-4 minutes.
- Use a heavy-duty drill fitted with a flat-blade mixing paddle and mix at 400 rpm.
- Keep the paddle submerged in product at all times to minimize air incorporation.
- Move the mixer up and down throughout the liquid to ensure proper mixture.
- Immediately (within 5 minutes) apply Pre-Form 100 after mixing, following Application Instructions on Page 2.

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- Do not apply in direct sunlight. Apply in shade or when sun is at low angle.
- Do not leave mixed product in bucket. This generates heat, causing product to quickly thicken and cure.
- Do not scrape sides of mixing bucket when pouring as this may lead to uncured product on the form surface.
- Do not overwork applied product.
- The typical application rate on standard horizontal plywood forms is **50-100 sf/gal** (1.25 -2.5 sm/L) or 16-32 mil (400-800 u).

Previously Sealed Plywood Forms: Generally, only one application of Pre-Form 100 is required for plywood forms that have been previously sealed and prepped according to Form Preparation instructions.

1. Pour Pre-Form 100 out in ribbons on the form within 5 minutes after mixing. Once poured, there is a 40-minute working time for maximum performance.
2. Using a notched squeegee or roller applicator equipped with a 3/8 inch (1.0 cm) nap cover, spread the product evenly to desired film thickness.
3. For larger areas, use Nox-Crete's 18-inch (45 cm) wide roller applicator with a 12-foot (3.6 m) extension pole handle.
4. Quickly back roll applied product to achieve a uniform film thickness.
5. Check thickness with a wet film thickness gauge.
6. Use a spiked roller to eliminate air bubbles and spread the product, if necessary.

New Plywood Forms: If this is the first application on a new plywood form, two coats of Pre-Form 100 are required to mask raised wood fibers.

1. Using the tools and methods described previously, apply a light, seal coat.
2. Allow product to cure undisturbed and protected for 6-24 hours, depending on curing temperatures.
3. Once fully cured, power sand surface with an orbital floor sanding machine to smooth any imperfections or bubbles.
4. Remove dust or debris caused by sanding.
5. Apply a second, light coat.

AFTER APPLICATION

- Always allow product to cure undisturbed and protected for 6-24 hours, depending on curing temperatures.
- Sand surface with an orbital floor sanding machine and remove dust and debris before concrete application.
- Do not return unused material to original container.
- Clean application equipment immediately with Nox-Crete Solvent B.

TABLE 1. MIX RATIO BY VOLUME

Mixing Component	Mixed Volume Created		
	1 Gallon (3.8 L)	3 Gallons (11.4 L)	5 Gallons (19 L)
Component A 2 Parts	85.33 oz (2.53 L)	256 oz (7.6 L)	426.67 oz (12.65 L)
Component B 1 Part	42.67 oz (1.27 L)	128 oz (3.8 L)	213.33 oz (6.35 L)

TABLE 2. MIX RATIO BY WEIGHT

Mixing Component	Mixed Volume Created		
	1 Gallon (3.8 L)	3 Gallons (11.4 L)	5 Gallons (19 L)
Component A 67.6%	6.250 lb (2.835 kg)	18.750 lb (8.505 kg)	31.250 lb (14.175 kg)
Component B 31.4%	2.905 lb (1.318 kg)	8.715 lb (3.953 kg)	14.525 lb (6.588 kg)
Total Combined Weight	9.115 lb (4.153 kg)	27.465 lb (12.458 kg)	45.775 lb (20.763 kg)

TABLE 3. COVERAGE RATE (AFTER MIXED)

Wet Film Thickness		Area Covered			
		1 Gallon (3.8 L)	3 Gallons (11.4 L)	5 Gallons (19 L)	10 Gallons (38 L)
Maximum	125 mil (3.3 mm)	13 ft ² (0.32 m ²)	39 ft ² (0.96 m ²)	65 ft ² (1.6 m ²)	130 ft ² (3.19 m ²)
Heavy	32 mil (800 μ)	50 ft ² (1.23 m ²)	150 ft ² (3.68 m ²)	250 ft ² (6.14 m ²)	500 ft ² (12.27 m ²)
Light	16 mil (400 μ)	100 ft ² (2.45 m ²)	300 ft ² (7.36 m ²)	500 ft ² (12.27 m ²)	1000 ft ² (24.54 m ²)

TABLE 4. OPTIONAL MIXING RATIO FOR PIGMENT

Pigment Color	Mixed Volume Created		
	1 Gallon (3.8 L)	3 Gallons (11.4 L)	5 Gallons (19 L)
Red Pigment	0.9 lb (0.408 kg)	2.7 lb (1.225 kg)	4.5 lb (2.041 kg)
White Pigment	1.72 lb (.780 kg)	5.16 lb (2.340 kg)	8.6 lb (3.900 kg)

Note: Proper mixing of Pre-Form 100 White will result in additional volume per mixed gallon.

See **Product Data Sheet & Troubleshooting Guide** for more information.