



Guide for Polishing DRYTEK® LEVELEX™ DL TDS 238D DRYTEK

To polish DRYTEK® LEVELEX™ DL self-leveling overlays (SLO) and other toppings there are several methods and techniques that can be used to achieve the same or similar results. It is important to note that each contractor will have their own process and sequence based on their experience with their own equipment and tooling. Additionally, diamond tooling and equipment manufacturers will have their own recommended tooling and sequence for self-leveling overlays. Some manufacturers have designed tooling specifically for grinding and polishing self-leveling toppings. Therefore LATICRETE always recommends consulting our Technical Service Department and with your tooling and equipment manufacturer prior to grinding and polishing SLO's.

In all cases a large mock-up (minimum 20'x20' (6.1x6.1m)) should be installed to determine the process, ensure the intended appearance and performance can be achieved, and set the client expectations. Smaller sized mock-ups may not allow enough space for large equipment to effectively produce realistic repeatable results.

Install DRYTEK LEVELEX DL

- Install DRYTEK LEVELEX DL per installation instructions using DRYTEK Epoxy Primer and sand broadcast. Pour depth 1/2" – 1 1/4" (12 – 32 mm)
 - Use a Gauge rake to set depth at a minimum of 1/2" (12 mm).
 - For deeper pours in excess of 1 1/4" (3.2 cm) contact LATICRETE Technical Services
 - Use a spike roller to break surface tension and help remove air bubbles. Use a spike roller with spikes longer than the pour depth.
 - Adding aggregate – Note that aggregate must be decided upon during mock up. Typically terrazzo aggregates size #2 - #4 can be used. Test these during mock up to determine what works best for your project.
 - Seed / Broadcast aggregate shortly after spike roller is used but before skin begins to form on the self-leveling.
 - Choose the correct size, large enough aggregate that will not sink too far below the surface of your self-leveling. If aggregate used sinks below the intended grind/cut depth it will not be exposed and visible after grinding.
 - When aggregate is broadcast into the surface or mixed integrally allow a minimum of 24 hours drying time prior to first grind. The extra cure time will allow more strength to develop and help prevent aggregate from rolling out during the grinding stage.
 - Typically the first grind can begin after approximately 12 hours after install depending on pour depth and drying conditions. Grinding can begin sooner when drying / curing conditions allow.
 - Note that a more aggressive diamond may be needed to cut the surface as strength develops. Also note that grinding too soon could cause damage to the surface.

Cut Joints

- Prior to cutting joints, allow DRYTEK LEVELEX DL to cure for a minimum of 3 hours, and surface is walkable. Joints should be installed prior to grinding.
- Trace previously marked substrate joints. Cut into the concrete substrate joint through the full depth of the DRYTEK LEVELEX DL

Fill Joints per L&M™ JOINT TITE 750™ installation instructions.

- Allow DRYTEK LEVELEX DL to dry for a minimum of 24 hours prior to filling joints.
- Vacuum/air blast to clean out new cut joints completely (Do not use water) leaving no loose dust or debris.
- Protect surface adjacent to the joint from staining caused by product overflow with stain protector.
- Install L&M™ JOINT TITE 750™ joint filler overfilling the joint slightly by approximately 1/16" (1.5 mm). Excessive overfill will waste product and may cause surface staining.
- After 45 minutes, trim excess joint filler using a new 8" (20 cm) razor scrapper to create a flat, smooth joint.

Grinding Stage: 40-100 Grit Metal Bond / 150 Hybrid

Removing the "skin".

- Dry grind only. Wet grinding is not recommended.
- The Grinding stage will typically remove 1/16" – 1/4" (1.5 – 6 mm) of the surface. To polish the surface without removing the skin, skip the Grinding and Honing stages and proceed to Polishing.
- Prior to starting and stopping the machine, head pressure should be relieved to reduce the occurrence of deep start and stop scratches. These scratches can be difficult to remove later in the process.
- First attempt at cutting/grinding the surface will determine the diamond tool needed. Typically a 40 – 80 grit metal bond diamond will cut the surface within 24 hours of install. As the surface gains strength over time and/or if aggregate needs to be exposed, a more aggressive metal bond diamond may be needed to cut through the surface skin and expose the aggregate.
- Once the first grind diamond tooling has been determined, spend a large amount of time on grinding and cutting through the skin. Multiple passes should be done in a north to south then east to west fashion. Two or more passes will be needed to grind deep enough so that the surface skin, gauge rake/smoothen marks, low spots are removed, and the aggregates are exposed. Continue to grind until this has been achieved.
- Sweep/Vacuum clean and inspect to ensure that all previous scratches have been removed prior to each diamond grit change.
- Continue to grind with 100 – 120 Grit Metal Bond. This tool will remove scratches created by the previous step and begin to smooth the surface. A second pass at this grit may be needed to ensure all of the previous scratches are removed. Again, make multiple passes in a north to south then east to west fashion.

Grout / Skim Coat (if needed): There are several types of products and methods for grouting available including acrylic, resinous, cementitious, etc. Contact and follow instructions from the grout manufacturer that you are using.

Transition: 100 - 200 grit Hybrid or transitional

- 100 - 200 grit Hybrid or transitional tools are often used to remove metal diamond scratch patterns prior to switching to resin bonds.
- This will often require a single pass, however, multiple passes may be needed. Make multiple passes in a north to south then east to west fashion.
- When switching from hybrid or transitional to resin bond diamond tools, drop back one grit from the last metal used. For example when transitioning from 150 Hybrid, start with 100 grit Resin.

Honing Stage: 100-400 Grit Resin - Some tooling manufacturers design products that are specifically for grinding and polishing self-leveling products. Consult LATICRETE Technical Services or with your tooling manufacturer.

- Sweep/Vacuum clean and inspect to ensure that all previous scratches have been removed prior to each diamond grit change.
- Run your machine at a slower speed over self-leveling topping than you would over normal concrete slabs. Faster settings with resin bonds over self-leveling toppings could generate enough heat to burn the

polymers in the topping and cause some discoloration. Also, consider removing weight from machine. At this stage additional weight could generate excess heat.

- Begin honing using 100 grit Resin. If scratches remain after the first resin pass, drop back to hybrid or transitions to remove deep scratches. Then work your way back up.
- Continue to hone using 200 grit Resin.
- Sweep/Vacuum clean and inspect to ensure that all previous scratches have been removed.
- If using a Dye apply L&M™ VIVID DYE WB Plus™ prior to densifying per the data sheet instructions. Two coats are recommended however, this should be determined during the mockup.

Dye and/or Densify:

- Use dye prior to densifier when dye is specified.
- Apply a second coat of L&M VIVID DYE WB Plus, if desired or required, prior to densifying.
- Use L&M LION HARD® lithium silicate densifier. Apply to rejection per data sheet instructions at a rate of 400-600 ft²/gallon (9.8-14.7 m²/L) using a microfiber pad keeping the surface wet for 15-20 minutes. Do not allow to puddle. Allow to dry completely.
- Continue honing using 400 grit Resin.
- Sweep/Vacuum clean and inspect to ensure that all previous scratches have been removed

Polish: 800-3000 Grit Resin

- Polish using 800 grit Resin.
- Sweep/Vacuum clean then Densify again using L&M LION HARD lithium silicate densifier. Apply to rejection per manufacturer's instructions at a rate of 600-800 ft²/gallon (14.7-19.7 m²/L) using a microfiber pad keeping the surface wet for 15-20 minutes. Do not allow to puddle. Allow to dry. Remove any residue with next polishing step.
- Continue to polish using 1500 grit Resin.
- Sweep/vacuum floor.
 - In many cases this will be the highest grit used and the specified gloss has been achieved.
- Continue to polish using 3000 grit Resin. Sweep/vacuum floor.

Apply Guard (If specified)

- Once the specified gloss has been achieved use L&M PERMAGUARD SPS™ per manufacturer's instructions and burnish with a 2000 RPM burnisher and a soft white or soft natural hogs hair.

Technical Data Sheets are subject to change without notice. For latest revision, check our website at www.laticrete.com
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LATICRETE INTERNATIONAL, INC. ▪ 1 LATICRETE Park North ▪ Bethany, CT 06524-3423 USA
800.243.4788 ▪ support@laticrete.com ▪ www.laticrete.com

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