

## HYBRI-FLEX® AC ONE

The following information is to be used as a guideline for the installation of the Hybri-Flex AC One flooring system. Contact the Sherwin-Williams Technical Service Department for assistance prior to application.

### APPLICATION INFORMATION — SURFACE PREP PROFILE CSP 3-4

VOC MIXED	APPLICATION STEP	MATERIAL	MIX RATIO	THEORETICAL COVERAGE PER COAT	PACKAGING
0 g/L	Primer	Poly-Crete TF	A, B & C unit	90 sq ft/unit	0.80 gal/unit
0 g/L 0	Base Coat	Poly-Crete SL 6750 - 1/4" Decorative Flake 6755 - 1/8" Decorative Flake	A, B & C unit To Excess	40-55 sq ft/unit 0.1 lbs/sq ft .15 lbs/sq ft	3.125 gal/unit 50 lbs 50 lbs
0 g/L 0	Second Broadcast	Resufloor Glaze 6750 Decorative Flake 6755 Decorative Flake	2:1 To Excess	150 sq ft/gal 0.1 lbs/sq ft .15 lbs/sq ft	3, 15 or 150 gals 50 lbs 50 lbs
<50 g/L	Grout	Accelera One	Varies by Temperature	100 sq ft/gal	1, 5 or 50 gals
<50 g/L	Topcoat	Accelera One	Varies by Temperature	200 sq ft/gal	1, 5 or 50 gals

For additional topcoat options, contact your Sherwin-Williams Representative.

### IMPORTANT!

Read these instructions carefully several days prior to starting your work. Seek answers to any questions you may have before you begin. Sherwin-Williams HPF maintains a technical staff that will be glad to answer your questions and give you advice pertaining to your particular installation.

### SYSTEM OVERVIEW

Hybri-Flex AC One is a 100% solids low odor decorative chip system composed of a 1/8" Poly-Crete® SL body coat with a decorative chip broadcast. It uses a Resufloor Glaze broadcast coat, and two Accelera® One topcoats yielding a total nominal system thickness of 3/16".

### SURFACE PREPARATION

Surface should be profiled, clean, dry, oil free and sound. Shot blasting is the preferred preparation method. Please refer to the master Surface Preparation Guide for more information. Never feather edge Hybri-Flex AC One, always terminate in a keyway groove at doorways, drains and exposed edges. No epoxy coatings should be applied unless surface temperature is a minimum of 5°F above dew point. See Dew Point Calculation Chart on our website for detailed instructions.

### MOISTURE CONCERNS

Please refer to the Floor Evaluation Guidelines in the Contractor's Center of our website for a step-by-step process to determine the condition of the concrete.

### MIXING AREA

Select a convenient mix area and protect the surface from spillage by covering with a sheet of plastic and a layer of cardboard. Be generous with the amount of space allocated for this function. The more comfortably your mixer works, the less likely you are to have a "mix error". Please refer to our Mix Station video on our website for more information.

### STORAGE CONDITIONS

**Poly-Crete SL must be stored dry. Exposure of the aggregate to moisture for an extended period will cause lumps. Do not allow resins to freeze. The shelf life is 6 months from the ship date in the original unopened container. Products must be stored in temperatures no less than 60°F and no greater than 85°F.**

### JOINT GUIDELINES

Refer to the Joint Guidelines for complete details on our website.

### APPLICATION METHOD

Proper planning is essential for satisfactory appearance of the finished floor. Lay out installation in sections to allow full width to be finished in 20 minutes (@70°F) or less to assure absence of placement lines.

**NOTE:** For each application of material and before mixing, mark your batches to ensure you achieve your spread rate targets. This is best accomplished by dividing your target spread rate by the width of the area being coated (or your planned wet edge). Example: If your spread rate is 100 square feet and your area is 20 feet wide, you would make a mark every 5 feet (100 divided by 20 = 5).

### DESIGNED TO PERFORM

[sherwin-williams.com/resin-flooring](http://sherwin-williams.com/resin-flooring)

## PRIMER

In most applications, Hybri-Flex AC One does not require a primer. However, very porous substrates should be primed first with Poly-Crete® TF.

- A. Poly-Crete TF is supplied in pre-measured units consisting of one pail of resin, one container of hardener and one bag of aggregate (powder). Pour the Poly-Crete TF Plus resin into a 2-gallon pail; scrape bottom and sides with a mix stick to assure that all material is transferred to the mix bucket. Use the Poly-Crete pail to scrape the mix stick; never scrape mix stick on the side of the mix pail. Measure 1/4 oz. of Poly-Crete HF Accelerator and add it to the mix bucket. Pour the entire Poly-Crete TF Plus hardener into the center of the mix bucket. Using a ½" 750 RPM drill with a 4" dispersion blade, mix the resin and hardener for 30 seconds. Slowly add the Poly-Crete TF Plus aggregate to the resin and hardener and mix at 750 RPM for 1 minute. **PRODUCT MUST BE MIXED WITH A 4" DISPERSION BLADE AND A ½" VARIABLE SPEED 750 RPM DRILL. \*DO NOT ADD HARDENER TO RESIN UNTIL BATCH IS READY FOR MIXING\*. \*FAILURE TO ADD ALL POLY-CRETE TF PLUS POWDER WILL RESULT IN IMPROPER CURE OF MATERIAL\***
- B. Pour the entire batch in two 4"-6" ribbons along the starting point.
- C. Using a 3" chip brush, cut in along edges, drains and doorways.
- D. Roll the material with an 18" 3/8" nap roller at 90 square feet/kit depending on substrate texture and porosity.
- E. Cross roll the material to remove any puddles and achieve a uniform thickness. Allow to cure for 4 hours @ 70°F before proceeding to the next application.

## BASE COAT

- A. Poly-Crete SL is supplied in pre-measured units consisting of one pail of resin, one container of hardener and one bag of aggregate (powder). Pour the Poly-Crete SL resin into a metal 5-gallon pail; scrape bottom and sides with a mix stick to assure that all material is transferred to the mix bucket. Use the Poly-Crete pail to scrape the mix stick and never scrape mix stick on the side of the mix pail. Pour all of the Poly-Crete SL hardener into the center of the mix bucket. (If using Poly-Crete Natural SL with pigment, add the pigment to the resin and hardener.) Next, using a ½" 850 RPM drill with a 4" dispersion blade, mix the resin and hardener for 30 seconds. Slowly add the Poly-Crete SL aggregate to the resin and hardener and mix at 850 RPM for 1 minute. **PRODUCT MUST BE MIXED WITH A 4" DISPERSION BLADE AND A ½" VARIABLE SPEED 850 RPM DRILL.**
- B. **DO NOT ADD HARDENER TO RESIN UNTIL BATCH IS READY FOR MIXING. FAILURE TO ADD ALL POLY-CRETE SL AGGREGATE WILL RESULT IN IMPROPER CURE OF MATERIAL.**
- C. Pour the entire batch onto the floor and spread with a ½" V-notched squeegee. Each kit of Poly-Crete SL will yield 55 square feet per kit. Check your squeegee every 1,000 square feet for wear. Have a new squeegee ready to avoid interruption in the process.
- D. To achieve 125 mil base coat application, replace the ½" V-notched squeegee with #2 CAM rake in step C.
- E. Use a flat trowel to cut in edges, drains and around equipment. For continuity of finish and to ensure that new batches of material are blended together without transition lines, use even pressure and trowel at a low angle using a sweeping motion.
- F. Immediately Loop Roll the material after it has been placed to remove squeegee lines and help the material level. The material should be rolled straight forward and back while picking up the roller with each pass; this will avoid leaving divots in the floor. After the squeegee lines have been removed, the floor should be cross rolled side to side along the entire wet edge. The final cross roll should be completed at 70°F within 12 minutes of mixing the product. Broadcasting at 70°F can begin 15 minutes after the Poly-Crete SL is mixed.
- G. Wear spiked shoes while broadcasting chips up into the air and letting them fall onto the floor. Broadcasting at 70°F can begin 15 minutes after the Poly-Crete SL is mixed. Make sure the broadcast is dispersed evenly over the entire floor area at a rate of 0.1 lbs. per square foot for macro chips and .15 lbs. per square foot for micro chip. Broadcasting needs to be completed within 30 minutes of mixing. Do not roll or walk back into areas that have been broadcast. Allow Poly-Crete SL to cure for a minimum of 6 hours @ 70°F.
- H. Use a stiff bristle broom and sweep off excess chips. Use a vacuum to remove chips around those edges and corners not accessible with a broom.
- I. Scrape the floor with a trowel or floor scraper. Sweep and vacuum the floor again.

## SECOND BROADCAST

- A. Measure out 1 part Resuflor Glaze Regular or FAST hardener, and 2 parts Resuflor Glaze Resin. First add the hardener into a separate mixing pail and then add the resin. Scrape the bottom and sides with a mix stick to ensure that all material is transferred to the mix bucket. Use the measuring pail to scrape the mix stick, and never scrape the mix stick on the side of the mix pail.
- B. Using a ½" 450 RPM drill with a Jiffiler blade, mix the resin and hardener for 2 minutes. **\*DO NOT ADD RESIN TO HARDENER UNTIL BATCH IS READY FOR MIXING\***
- C. Pour a 4" to 6" ribbon along the starting area. Use a 3" chip brush to cut in along edges, doorways and drains.
- D. Using a 12" flat soft rubber window squeegee, pull the material from side to side overlapping passes every 6". Be careful not to leave any puddles. Resuflor Glaze is applied at 150 square feet/gallon over the decorative chips.
- E. While wearing spiked shoes, back roll the material against the squeegee lines with a high quality 3/8" nap roller.
- F. Cross roll the material from side to side while overlapping the previous pass with half the roller width.
- G. Broadcast chips up into the air and let them fall to the floor. Make sure the broadcast is dispersed evenly over the entire floor area at a rate of 0.1 lbs. per square foot using macro chip, and .15 lbs. per square foot using micro chip. Do not roll or walk back into areas that have been broadcast. Allow Resuflor Glaze to cure for 4 hours @ 70°F.
- H. Use a vacuum to remove excess chips.
- I. Scrape the floor with a trowel or floor scraper. Sweep and vacuum the floor again.

## GROUT COAT & TOPCOAT

**Grout Coat Spread Rate:** 100 square feet/gallon @ 16 mils over Micro and Macro chips.

**Topcoat Spread Rate:** 200 square feet/gallon over Micro and Macro chips.

MIX AND APPLY ONE BATCH AT A TIME - DO NOT MIX HARDENER AND RESIN TOGETHER UNTIL BATCH IS READY FOR IMMEDIATE APPLICATION. ACCLIMATE MATERIAL TO JOBSITE CONDITIONS BEFORE STARTING.

- A. Measure the amount of hardener according to the mix ratio chart provided above. Pour the hardener into the resin container; scrape bottom and sides with a mix stick to assure that all material is transferred to the resin bucket. Use the hardener pail to scrape the mix stick and never scrape mix stick on the side of the mix pail. Using a 750 RPM drill with a 3" Jiffler blade, mix the resin and hardener for 30 seconds. Material should be clear and no streaks should be present. Use a 5" Jiffler blade for larger mixes.
- B. Pour the entire batch onto the floor in a 4" to 6" ribbon. Use a flat squeegee over broadcast surfaces to spread the material evenly. Spread rate will vary depending on substrate, broadcast media and finish texture desired.
- C. Cross roll the material, pushing a 3/8" nap roller in the same direction immediately after the squeegee to ensure there are no puddles. All rolling should be completed within 15 minutes. Allow to cure for 2 hours (@ 70°F/50% RH).

**NOTE:** This product is best suited for application in temperatures between 60°F and 85°F. Full chemical and abrasion resistance occurs in 7 days at 70°F. At lower temperatures, these properties will be attained more slowly. Protect floor from chemical exposure and abrasive wear during this time.

### IMPORTANT!

Before using Sherwin-Williams High Performance Flooring products, read and understand their accompanying Safety Data Sheet.

STANDARD TERMS AND CONDITIONS OF SALE, INCLUDING STANDARD WARRANTY APPLY - VISIT [industrial.sherwin-williams.com/na/us/en/resin-flooring](https://industrial.sherwin-williams.com/na/us/en/resin-flooring) FOR THE LATEST VERSION.

**CAUTION!** As with all chemical products, individuals may have different reactions to exposure to specific products. This is dependent upon many factors, including the individual's personal characteristics, the size of the installation, the ventilation available, the intensity of the exposure or the length of the exposure. Individuals may experience discomfort during the installation process of one product, but not another.

In some cases this is experienced as a skin irritation and in others it is experienced as an inhalant irritation. Typically, it disappears once the exposure is eliminated. In some cases people can become "sensitized" to a product and experience the discomfort every time there is exposure without Personal Protective Equipment ("PPE").

To protect yourself from various exposures or discomfort during the mixing and application of our products, we recommend covering exposed skin including using gloves, long sleeves, safety glasses and a respirator such as the 3M 8577 P95 Universal Disposable Carbon Respirator or a cartridge respirator.

Use only as directed. KEEP OUT OF REACH OF CHILDREN.

Do not reseal moisture-contaminated hardener. This will result in carbon dioxide generation or possible violent rupture of container.

## THE SHERWIN-WILLIAMS DIFFERENCE

Sherwin-Williams High Performance Flooring delivers world-class industry subject matter expertise, unparalleled technical and specification service, and unmatched regional commercial team support to our customers around the globe.

### United States & Canada

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