



SORGIVA® • NATURAL POOL SYSTEM

SORGIVA® POOL SYSTEM • INSTALLATION TRAINING

Naturi Pools Installation Training Manual

A field-ready guide for approved installers covering excavation, plumbing, liner, the Sorgiva® diffusion system, finishing, start-up, and equipment care.

Purpose & Document Control

This manual is a professional training guide for authorized Naturi Pools installers. It explains the correct installation of the patented Sorgiva® pool system, outlines best practices, and defines the standards required to ensure long-term performance, durability, and water quality.



WARRANTY NOTICE

All procedures in this manual must be followed exactly. Deviations may compromise system performance and **will void the Sorgiva Pools warranty**. Only trained and authorized Naturi Pools installers may install the Sorgiva® system.

Effective 2026.08.05 · **Supersedes** Rev 2026.06.16 · Verify current revision with Naturi Technical Support.

REV Revision History

REVISION	CHANGE
2026.08.05	Fahrenheit (°F) edition — curing-table temperatures converted from the manufacturer's Celsius values and rounded. Added epoxy curing-time tables: ITAPOX 127 + ITAMID FL550S (PHR 50) to the Base Coat Epoxy reference sheet, Collaflex and Sorgiva® Primer sections; ITAPOX 970 + ITAMINE CA870 (PHR 38) to §10.5, §11.4 and Vertical Wall VW.15. Revised §4.2 entry-beach slope to 7:1 (14%) and added the Step Standards table with local-code caution. Clarified §10 finishing-layer cure step. Removed cooler-temperature note from §11.3.
2026.06.16	Added Annexes, Reference sheets & supplementary procedures to the contents; Vertical Wall, Sorgiva® Primer & Collaflex sections released.

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01 • SYSTEM WHAT YOU ARE INSTALLING

Overview of the Sorgiva® System

The Sorgiva® system is a patented, globally unique pool construction method used by Naturi Pools to create pools with a natural appearance and advanced water circulation.

1.1 Capillary Diffusion, Not Inlet Nozzles

Unlike traditional pools, the Sorgiva® system does not rely primarily on inlet nozzles for circulation. Instead, water is distributed through **capillary diffusion within the pool lining itself**. This is achieved using specially perforated diffusion pipes installed above the waterproof membrane and running throughout the entire pool.

1.2 What this design ensures

- Uniform water circulation throughout the pool
- Reduced risk of algae and bacterial growth
- Long-term structural and aesthetic stability



NOTE

Only trained and authorized Naturi Pools installers may install the Sorgiva® system. This manual is the canonical reference; supersedes any earlier handouts.

System at a Glance

METHOD	Capillary diffusion pool
STATUS	Patented, proprietary
LINER	EPDM over protective fabric
DIFFUSION	Perforated flex pipes above membrane
FINISH	Aggregate & resin, two-part resin system
INSTALLER	Approved by Naturi Pools



FIG 1.1 Cross-section of the Sorgiva® lining. From bottom to top: EPDM membrane, perforated diffusion pipe in aggregate, base resin layer, and finishing layer with embedded mesh.

Capillary diffusion is achieved across the full width of the lining, not at point-source nozzles.

02 · SAFETY REQUIRED BEFORE ANY WORK BEGINS

Safety & Authorization Requirements

Every Sorgiva® installation begins with verified training, complete PPE, and a clear understanding of which actions are — and are not — permitted on this system.

2.1 Mandatory Requirements

- ☐ All installers must complete Naturi Pools-approved Sorgiva® installation training.
- ☐ All legally required personal protective equipment (PPE) must be worn at all times.
- ☐ Unauthorized modifications to the system are strictly prohibited.
- ☐ Any unapproved changes will immediately void the Sorgiva Pools warranty.

2.2 Recommended PPE on Site

PPE	WHEN REQUIRED
Safety glasses	Drilling, mixing resin, sanding, all spray operations
Nitrile gloves	All resin handling and mixing
Respirator (organic vapor)	Final resin spray, butyl acetate work, sanding
Hearing protection	Mixer operation, masonry saw, compactor
Hard hat & steel-toe	Excavation, equipment lifts, structural work

**WARNING · WARRANTY VOIDING**

Substituting unapproved resins, aggregates, or diffusion components — or altering documented mix ratios — is an unauthorized modification. The warranty is void from the moment such a change occurs and cannot be restored after the fact.

**CAUTION**

Resin components A and B are reactive and exothermic when combined. Mix only the volume needed for the next lift, and only in the mixer specified for that resin.

03 · PRE-CONSTRUCTION BEFORE CONSTRUCTION BEGINS

Site Preparation

Confirm permits, plans, and storage before excavation. Each item below should be physically signed off by the lead installer prior to mobilization.

3.1 Pre-Construction Checklist

- ☐ Inspect the installation site.
- ☐ Obtain all required building permits and approvals.
- ☐ File a declaration of commencement of work where required.
- ☐ Approve a detailed project plan with the client, including pool shape and specifications.
- ☐ Confirm site access for equipment, vehicles, and materials.
- ☐ Designate a dry, protected storage area for materials.
- ☐ Verify soil conditions or obtain a soil analysis.

3.2 Material Storage Standards

SAND & QUARTZ	Must be protected from moisture. Store on pallets, under cover.
RESINS	Keep sealed, out of direct sun. Keep from freezing.
EPDM LINER	Stored flat or rolled — never folded. Keep clean.
DIFFUSION PIPE	Off the ground; protect from UV until install.

Recommended Site Walk Sign-off

Capture the following with the client present and document with photos before any excavation begins:

- Final pool shape, depth profile, beach extent
- Equipment pad location and access path
- Tree and utility clearance
- Drainage flow paths during construction



NOTE

Any design changes after this point should be approved and signed by both the client and installer (see §4.1).

04 • EXCAVATION & SHAPING DEFINES THE ENTIRE POOL

Excavation & Shaping

Excavation defines the final pool shape and is a critical phase of construction. Professional excavation crews experienced in rounded and sloped profiles are strongly recommended.

4.1 Layout

- Mark the excavation according to the approved project plan.
- Any design changes should be approved and signed by both the client and installer.

4.2 Excavation Standards

- Wall slopes must not exceed **42°** unless installing a vertical wall. See vert wall guide.
- Entry beaches should be no steeper than **7:1** (14% Slope).
- Pool depths should match approved plans.
- First and last treads may differ in size; angle each tread back slightly from front to rear.

STEP STANDARD	VALUE
Maximum riser height	12" (305 mm)
Minimum riser height	7" (178 mm)
Minimum tread depth (front to back)	10" (254 mm)
Minimum tread surface area	240 sq in (0.15 m ²)
Risers	Uniform throughout stairway
Treads	Uniform in depth
Slip resistance	Surfaces must be slip resistant



CAUTION

Some localities have more restrictive code. Be sure to check local codes.



FIG 4.1 Excavation in progress with rounded walls, sloped beach entry, and skimmer pocket cut to reference depths.



NOTE • DRAINAGE

Provide bottom drainage where required to allow safe pool emptying during maintenance.



CAUTION

This stage shapes your entire project. Re-cutting after the liner stage is not possible. Confirm levels twice before signing off.

04 • EXCAVATION & SHAPING VERIFICATION BEFORE PLUMBING

Excavation & Shaping — continued

4.3 Fill & Compaction

- Use stabilized fill material only.
- Compact material thoroughly to prevent settlement.
- Do not use soil or loose fill materials.

4.4 Reference Levels

REFERENCE	VALUE
Top band depth shoreline excavation	-2"
Top band width (minimum)	10-12"
Water level (below 0)	-6"
Maximum wall slope	42°

All depth measurements are taken from finished grade, "0".

4.5 Pre-Backfill / Pre-Interior Plumbing

- ☐ All plumbing pressure-tested and dry
- ☐ Conduits stubbed to lighting locations and capped
- ☐ Equipment pad routed and labelled
- ☐ Local electrical inspection complete (where required)



NOTE • CODES

All electrical work must comply with local codes (see also Chapter 12). When local code conflicts with this manual, local code prevails — but contact Naturi Pools Technical Support before proceeding.

05 • PLUMBING & STRUCTURAL DRAINS, SKIMMERS, MANIFOLDS

Plumbing & Structural Components

Plumbing and structural components are roughed-in before the protective fabric and EPDM liner are installed. Sequence and elevations are critical — they govern water level and perimeter height for the entire pool.

5.1 Main Drain & Delivery Pipes

- Install delivery pipes at the pool bottom.
- Install the main drain with **pressure-equalizing cap (hydrostat valves)** to prevent pool uplift during draining.
- It is highly recommended that compacted pea gravel or equal be used around spider receptacles and main drain basins.



FIG 5.1 Main drain housing with hydrostat valve and delivery pipes set at pool bottom prior to liner installation.

05 • PLUMBING & STRUCTURAL SKIMMERS, NOZZLES & MANIFOLDS

Plumbing & Structural Components — continued

5.2 Skimmers

(AquaStar Widemouth SKR36103. Verify skimmer dimensions against excavation references herein.)

- Position skimmers **8–13 inches back** from the slope edge to allow for slope of pool walls.
- Set, plumb, and encase the skimmer collar using **two 80 lb bags** of concrete.

EXCAVATION REFERENCE	DEPTH BELOW 0
Skimmer mouth	-14"
Skimmer base	-30"



FIG 5.2 Skimmer set 8–13" back from slope edge and leveled with delivery pipes attached (left); collar encased with two 80 lb bags of concrete (right).

5.3 Nozzles & Manifolds

- Nozzles and main drain must be **flush or slightly recessed**.
- Install the return manifold opposite the skimmers.
- Manifolds may be concealed in landscaping.
- Aero-therapy manifolds should be placed near benches or tanning ledges.



NOTE • SEQUENCE

Skimmer placement governs water level and perimeter height for the entire pool. Do not pour skimmer collars until layout is verified against the approved plan.

06 • LINER SYSTEM FABRIC & EPDM

Protective Layers & Liner Installation

The protective fabric and EPDM liner together form the watertight envelope that the diffusion system, base layer, and finish are built upon.

6.1 Protective Fabric

- Install protective fabric (woven or recycled as required) across the entire pool surface.
- Weld seams using a heat gun or duct tape.
- Dress the fabric into wall slopes and beach transitions; it must conform to the excavated profile with no bridging.
- Trim flush at the perimeter once the EPDM liner is positioned.
- Stake fabric to prevent movement during EPDM install.



NOTE • WHY FABRIC FIRST

The protective fabric isolates the EPDM from any sharp aggregate or root fragments left in the substrate. Take time to inspect the floor and walls before laying it down — anything that can puncture the EPDM through the fabric must be removed.



FIG 6.1 Woven protective fabric being laid across the excavated pool surface and dressed into the wall slope before EPDM liner installation.

Continued on page 10 — EPDM liner installation, acceptance criteria, and caution before diffusion install.

06 • LINER SYSTEM EPDM & ACCEPTANCE

Protective Layers & Liner Installation — continued

6.2 EPDM Liner

- Install the EPDM liner above the protective fabric.
- Ensure proper flanging and watertight seals.
- Minimize folds and secure them with approved primer and EPDM tape.

6.3 Acceptance Criteria Before Diffusion Install

- ☐ Fabric covers entire pool surface; seams welded, no gaps
- ☐ EPDM laid flat, free of debris between layers
- ☐ All folds primed and taped; no loose edges
- ☐ All penetrations (skimmers, drain, nozzles) flanged and watertight



CAUTION

Do not allow foot traffic with abrasive footwear on the EPDM. Use clean soft-soled shoes or kneeling boards from this stage forward.



FIG 6.2 Crew positioning the EPDM liner over the protective fabric. Folds are walked out toward the perimeter, then primed and taped before flanging at penetrations.

07 · SORGIVA® CORE THE SYSTEM THAT DEFINES THE SYSTEM

Sorgiva® Diffusion System

The diffusion network is the heart of the Sorgiva® system. Spider-line geometry and drilled flex-pipe spacing govern flow uniformity across the entire pool surface.

7.1 Diffusers & Nozzles

- Glue Naturi Pools Sorgiva® diffusers to all nozzles.
- Install directional or radial nozzles as specified.
- Verify each diffuser is fully seated against the nozzle and that the spider-line T-junction is centered over the diffuser before taping.

7.2 Diffusion Pipes

- Drill provided flex pipes **every 12"** using a **5/16"** bit through both sides of pipe. **First and last hole should be 6" from both ends.**
- Secure pipes to the liner in a radial pattern using approved adhesive tape.
- T-connection must be equidistant to each distribution point.

SPIDER LINE SPEC	VALUE
Maximum length	15 ft
End of spider line below water level	-16"
Maximum T-spacing	9 ft
Drill bit / spacing	5/16" · 12"

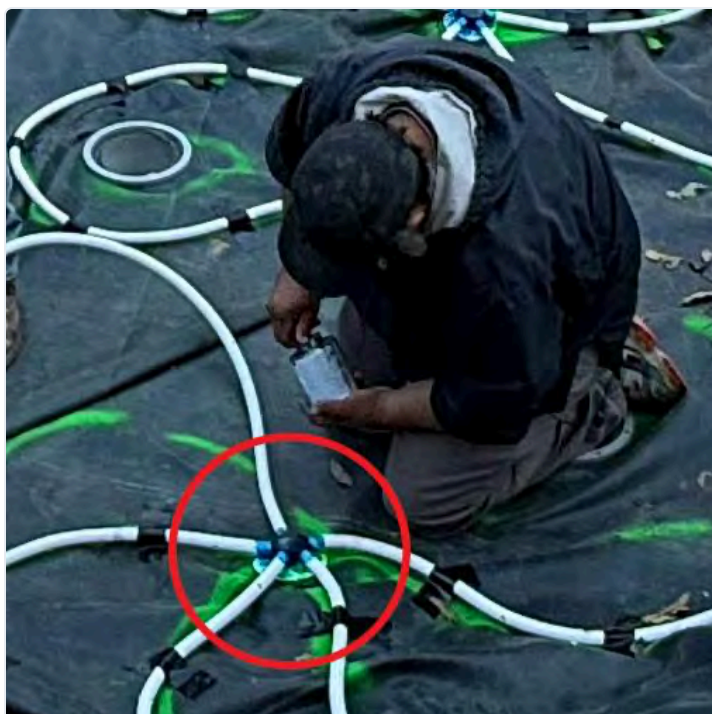


FIG 7.1 Diffuser detail (circled): Sorgiva® diffuser glued to the nozzle at the T-junction of the spider line, with chalked alignment marks on the EPDM.

07 • SORGIVA® CORE RETURN JETS & AERO-THERAPY

Sorgiva® Diffusion System — continued

7.3 Return Jets & Aero-Therapy

Return jets

- Positioned **12" below water level**.
- Direct water toward the skimmers, slightly angled toward the surface of the water.

Aero-therapy lines

- Used on benches and tanning ledges.
- Drill **3/16" hole every 8"**, through one side of pipe only.
- Includes emitter and micro tubing for each air hole.



FIG 7.3 Aero-therapy and return-jet lines laid over the EPDM liner. White ½" runs are taped down with chalk-marked routing; lines converge at the distribution box without crossing on open floor.

07 · SORGIVA® CORE (cont.) DISTRIBUTION BOX & LINE ROUTING

Distribution Box, Aero-Therapy & Top Returns

7.4 Distribution Box, Aero-Therapy & Top Returns

- **Distribution box.** Purchase the biggest irrigation box your local hardware store provides — we recommend a **15" × 22"** box. Create holes for your lines to run through the side of the box.
- **Aero-therapy lines.** Run your **½" lines** over the side of the pool to where you need them. Take care not to cross lines; if you must cross, do so where the wall meets the floor. Drill **3/16" hole, every 8"** on top of tubing, only in areas where aero-therapy is used.
- **Top water returns.** Run the lines along the beam and drop down **–12" below water line**. These lines must be directed toward the skimmer(s).



NOTE

Capillary diffusion only works when spider geometry is honored. Lines longer than 15 ft, or T's spaced more than 9 ft apart, will produce uneven flow and dead spots.

Filtration, Electrical & Features

8.1 Equipment Connections

- Connect all delivery and suction pipes to the filtration and disinfection system.
- Equipment sizing must comply with all regulations.
- Lay out and prepare conduits and recesses for lighting.

8.2 Chemical Injection



WARNING · CHEMICAL INJECTION

Chemical injection (chlorine, pH adjusters) must **only** occur through wall inlet nozzles and **never** beneath sand or aggregate layers. Injection beneath aggregate will damage the resin and void warranty.



NOTE · CODES

All electrical work must comply with local codes (see also Chapter 12). When local code conflicts with this manual, local code prevails — but contact Naturi Pools Technical Support before proceeding.

09 · BASE LAYER MESH, EPOXY 1, AGGREGATE

Reinforcement & Base Aggregate Layer

9.1 Fiberglass Mesh

- Protect the EPDM liner above and below any rocks or monoliths installed inside the pool.
- Lay fiberglass mesh across the entire surface.
- Overlap sheets by **2" (one square)**.
- Remove all wrinkles by cutting and overlapping mesh.

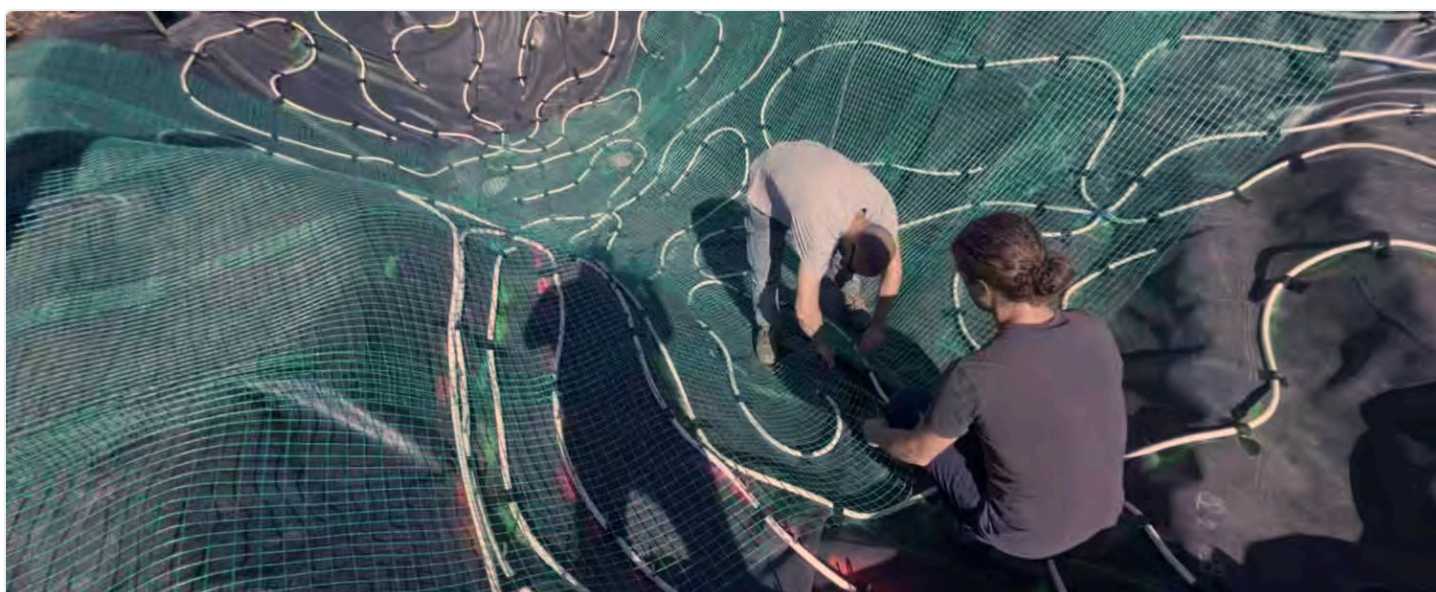


FIG 9.1 Fiberglass mesh laid across the EPDM liner over the spider lines. Sheets overlap by one square (2"); wrinkles are cut and overlapped flat before the base resin lift.

9.2 Resin & Aggregate Base — Mix Card

EPOXY — YELLOW CONTAINERS

Component A	3.2 kg
Component B	1.92 kg
Crushed quartz	4 Bags
Mix time	≤ 4 min

01 Combine A & B

Mix Components A and B thoroughly.

02 Add quartz

Add 4 Bags crushed quartz and mix in mixer.

03 Apply in lifts

Apply in 12–24" lifts depending on temperature and slope.

09 · BASE LAYER (cont.) APPLICATION & CURE

Base Layer Application & Cure

9.3 Application & Cure

- Allow approximately **1 hour between lifts**.
- Apply using a full stainless steel trowel to a thickness of **1½"**.
- If fiberglass mesh becomes visible, trim and remove it before the final coat.
- Must be troweled smooth and scraped before the top coat is applied.



FIG 9.2 Troweling the base resin and crushed-quartz mix over the fiberglass mesh. Aim for a uniform 1½" thickness; if mesh shows through, trim before the next lift.



WARNING · MOISTURE

Cover the surface to prevent moisture until it is fully dry. **DO NOT PROCEED if surface is wet.** It must be dry to move on to the finishing layer.

10 • FINISHING CONTROL JOINTS & FINISHING MIX

Finishing Layer & Consolidation

10.1 Lay Out Control Joints

Mark control joints approximately every **380 sf** of pool lining, depending on the size and shape of the pool. Control joints are only as thick as the final coat.

i NOTE • JOINT GEOMETRY
Keep joint areas clear with clean edges. Mask if necessary so the finishing mix does not bridge them.

10.2 Finishing Mix — Resin 2

RESIN 2 — BLUE CONTAINERS

Component A	6 kg
Component B	2 kg
Quartz / marble sand	4 Bags
Mix time	1 min 15 s

It is imperative resin dosages be applied strictly.
Mix Components A and B thoroughly, then add sand and mix in mixer.



FIG 10.1 Troweling the finishing layer up to a control joint. Maintain clean joint edges and uniform thickness as the layer is consolidated.

10 • FINISHING (cont.) APPLICATION, SANDING, EXPANSION JOINTS

Application, Cure & Expansion Joints

10.3 Application & Cure

01 Apply finishing mix

Apply evenly to a $\frac{1}{4}$ " thickness with a maximum thickness of $\frac{3}{8}$ " using a trowel. Leave joint areas clear with clean edges.

02 Cure 48 hours

After 48 hours, if the surface is completely hardened, you may proceed to step 3.

03 Sand & clean

Sand and clean the surface. Rinse sanded areas to remove dust and debris.

10.4 Expansion Joints

EXPANSION JOINT MIX

Pebbles	4 Bags
Blue Label — Part A	3.6 kg
Blue Label — Part B	1.2 kg

- Mix pebbles with Blue Label.
- Fill joint spaces.



CAUTION • SITE PROTECTION

Fence off the pool area for at least **30 hours** to prevent damage from pets or accidents occurring on curing resin.



FIG 10.2 Placing finishing-layer aggregate at the work face. Keep batches consistent and place wet-on-wet to avoid cold joints across the lining.



NOTE

Surfaces must be clean and dust-free before any sealer (Chapter 11). Re-rinse after sanding if needed and let dry fully.

10.5 Curing Times

System **ITAPOX 970 + ITAMINE CA870 • PHR 38** • Thickness **1–8 mm** • Method **ISO 868**

CURING TEMPERATURE	CURING TIME
< 50°F	Not recommended
50 – 60°F	8–9 days
60 – 68°F	6–7 days
> 68°F	4–5 days

Times are the period required to reach at least **80% of maximum hardness** per ISO 868. Do not apply below 50°F. Temperatures converted from the manufacturer's Celsius values and rounded.

11 · FINAL SEALER SPRAY-APPLIED FINISHING KIT

Final Resin Application

11.1 Mix & Coverage

FINISHING KIT — RED CONTAINERS

Component A	3 kg
Component B	1 kg
Butyl acetate	+ 2 L
Coverage per kit	~30 m ² (322 sf)
Re-coat interval	24 h between coats

11.2 Application Steps

01 Mix components

Mix together Components A and B of the finishing kit (red containers), then add 2 liters of butyl acetate.

02 Confirm clean, dry surface

Surface must be clean and dry — no dust from sanding on surface.

03 Spray evenly

Pour mixture into pump sprayer and apply evenly over the pool surface.

04 Re-coat as required

Multiple coats may be applied with 24 hours between coats.

11.3 Cure

— Minimum curing time: **48 hours at 77°F.**



FIG 11.1 Pump-spray application of the final resin sealer over a fully cured, sanded, and dust-free surface. Maintain even passes; avoid pooling on flats.



CAUTION · WET SURFACES

Any moisture on the surface during sealer application will cause the final coat to fail. Pause the spray and let the surface dry completely if conditions change.

11.4 Curing Times

System ITAPOX 970 + ITAMINE CA870 · PHR 38 · Thickness 1-8 mm · Method ISO 868

CURING TEMPERATURE	RECOMMENDED CURING TIME
< 50°F	Not recommended
50 – 60°F	8-9 days
60 – 68°F	6-7 days
> 68°F	4-5 days

Times are the period required to reach at least **80% of maximum hardness** per ISO 868. Do not apply below 50°F. Temperatures converted from the manufacturer's Celsius values and rounded.

12 · START-UP FINAL CHECKS BEFORE FILL

Start-Up & Final Warnings

12.1 Temperature & Fill

- Do not apply resin below 50°F.
- Once fully cured, fill the pool and start filtration.

12.2 Important Warnings



WARNING · CURE & MIXING

- Prevent water contact during resin curing.
- Mix resins thoroughly for **no more than 4 minutes**.
- Follow all specified ratios exactly.
- Contact Naturi Pools Technical Support in the event of unexpected weather.

12.3 Pre-Fill Final Checklist

- ☐ Final resin coat fully cured (48 h @ 77°F minimum)
- ☐ No surface moisture, residue, or visible dust
- ☐ Skimmers, drain, and returns clear of debris
- ☐ Filtration / disinfection system pressure-tested and primed
- ☐ Electrical signed off and bonded per local code



NOTE

All electrical work must comply with local codes. Naturi Pools reserves the right to update this manual at any time; always confirm you are working from the current revision.

13 • EQUIPMENT CARE COLOR CONSISTENCY DEPENDS ON THIS

Mixer Cleaning Procedure

Clean mixers regularly to prevent resin buildup and color variation. Excess resin build-up **will** cause color variations in the final coat.

13.1 Cleaning Cadence

WHEN	ACTION
General cadence	Every 2–3 mixes
Bottom coat (Epoxy)	Clean when buildup is visible
Final coat (Resin 2)	Clean every 3 batches
End of day	Clean with acetone

13.2 Cleaning Steps

- 01 Scrape**
Scrape buildup from mixer surfaces and discard.
- 02 Wipe**
Wipe with denatured alcohol.
- 03 Dry & resume**
Dry thoroughly and resume mixing.



CAUTION • HARDENED BUILDUP

Hardened buildup may be carefully burned off and scraped clean. Use appropriate fire-safe practices and PPE.



FIG 13.1 Collomix TMX 1000 mixer at the cleaning station. Maintaining a clean drum directly affects color uniformity in the final coat.

A · QUICK REFERENCE TEAR-OUT CARD FOR THE FIELD

Resin & Specification Quick Reference

A.1 Resin Mix Cards

RESIN	COLOR	COMPONENT A	COMPONENT B	AGGREGATE	USE
Epoxy	Yellow	3.2 kg	1.92 kg	4 Bags crushed quartz	Base layer (Ch. 9)
Resin 2	Blue	6 kg	2 kg	4 Bags sand / 2 kg resin	Finishing layer (Ch. 10)
Resin 2 (joints)	Blue	3.6 kg	1.2 kg	4 Bags pebbles	Expansion joints (Ch. 10)
Finishing Kit	Red	3 kg A · 1 kg B		+ 2 L butyl acetate	Final sealer (Ch. 11)

A.2 Critical Dimensions

Wall slope (max)	42°
Top band depth · width	-2" · 10-12"
Water level	-6" below 0
Skimmer offset from slope	8-13"
Skimmer mouth · base	-14" · -30"
Spider line max length	15 ft
Spider line depth	-16"
T-spacing (max)	9 ft
Diffusion drill / spacing	5/16" · 12"
Aero-therapy drill spacing	3/16" · 8"
Return jet depth	-12"

A.3 Cure & Temperature

Min. resin temperature	≥ 50°F
Mix time (any resin)	≤ 4 min
Base layer between lifts	~ 1 h
Base layer thickness	1½"
Finishing layer thickness	≥ 3/8"
Finishing cure (sand-ready)	48 h
Sealer re-coat interval	24 h
Sealer cure	48 h @ 77°F
Pet/site fence (after pour)	≥ 30 h

B · WELCOME CLOSING THE MANUAL

Welcome to the Naturi Pools Family

We are excited to partner with you and support your growth as an approved installer. Our team is committed to being available whenever needed to ensure your success and the highest quality of standards.

A NOTE FROM THE TEAM

Build well. Call us early.

Most issues we troubleshoot in the field would have been a five-minute phone call before a pour. If conditions, materials, or schedule deviate from this manual — call us first. Photos help. We would rather pause a job for an hour than redo a pool.

B.1 Technical Support

SUPPORT	Naturi Pools Technical Support — for unexpected weather, deviations, or product questions.
PHONE	631-753-0004
EMAIL	info@naturipools.com
HOURS	8 AM – 8 PM Eastern

Sorgiva® System — Materials List

The Sorgiva® System is Naturi Pools' proprietary approach to natural water movement, structural integrity, and refined aquatic design. This annex outlines all required materials, consumables, and equipment for proper system implementation.



PROVISIONING LEGEND

Items marked **provided** ship in the Naturi Pools kit. Items without that note are sourced by the installer per project conditions.

01 Base Kit — Core System Components

Required for every installation.

Structural & Waterproofing

Engineered for long-term performance and environmental resilience.

- **60 mil EPDM liner** (standard specification) — provided
- **Protective geotextile underlayment** — provided
- EPDM primer and seam tape

Diffusion System (Patented Technology)

The signature element of the Sorgiva® experience.

- **Naturi Sorgiva® diffusers** — provided
- **Flexible diffusion piping network** — provided
- **Top water returns** — provided
- Radial return nozzles (large-scale applications only)
- **Aero-therapy manifolds** (integrated seating / ledge designs) — provided if in design

Reinforcement System

Subsurface stabilization and structural continuity.

- **Full-coverage fiberglass mesh** — provided

Border & Perimeter

Architectural finishing and edge definition.

- **Structural quartz border material** — provided
- Landscape edging or other borders used as desired

Materials List — continued

02 Consumables — Project-Specific Materials

Calculated by square footage. Items marked **provided** ship in the Naturi Pools kit.

RESIN SYSTEMS

BASE LAYER SYSTEM (Yellow Resin)		EXPANSION JOINT SYSTEM (Blue Resin)	
EPOX 1A — provided	3.2 kg / batch	Resin 2A — provided	3.6 kg / batch
EPOX 1B — provided	1.92 kg / batch	Resin 2B — provided	1.2 kg / batch
Base coat pebble — provided	4 bags (100 kg)	Finish coat pebble — provided	4 bags (100 kg)
FINISH LAYER SYSTEM (Blue Resin)		FINAL SEAL COAT (Red Resin System)	
Resin 2A — provided	6 kg / batch	FINITURA A — provided	3 kg / batch
Resin 2B — provided	2 kg / batch	FINITURA B — provided	1 kg / batch
Quartz sand — provided	4 bags (100 kg)	Butyl acetate — provided	2 cans

OTHER CONSUMABLES

Plumbing Consumables

- PVC glue and primer
- 2" Schedule 40 PVC piping
- T-fittings, couplings, and elbows, female adapters
- **Hydrostatic valve / main drain assembly** — provided
- **Skimmers** — provided
- Concrete — 160 lbs per skimmer collar

General Installation Materials

- Industrial-grade tape — Gorilla Tape recommended
- Acetone (surface prep and cleaning)
- Denatured alcohol
- Drill bits (5/16")
- Drill bits (3/16")
- PPE

Materials List — continued

03 Equipment

Mechanical systems & installation tools.

Pool Equipment

- Filtration system (properly sized)
- Pump system
- Disinfection system
- Integrated lighting & transformer
- Electrical conduit

Installation Equipment — required, not provided

- Collomix TMX 1000 paddle mixer recommended
- Drill with mixing paddle — 2 paddles recommended
- Pump sprayer
- 100% stainless steel finishing trowels — not stainless-steel coated
- Heat gun (underlayment seam application)
- Plate compactor
- Laser level or transit
- Excavator and operator with experience

04 System Summary

CATEGORY	FUNCTION
Base Kit	Core patented and structural system components.
Consumables	Project-calculated materials used during installation.
Equipment	Mechanical systems and reusable installation tools.



FIELD REMINDER

Confirm provided-vs-installer-sourced items against the project's signed plan before mobilization. Substitutions to provided components must be approved by Naturi Pools Technical Support.

Mix Designs

This annex specifies every wet-mix recipe used on a Sorgiva® installation — base-coat epoxy, finish-coat aggregate mixes, and pebble finishes. All ratios are by mass; quantities are per batch.



ANNEX CONTENTS

- Part 1 — Base Coat Epoxy:** standardized batch ratios for the bonding base coat.
- Part 2 — Sorgiva Finish Mixes:** seven aggregate recipes (Caraibi, Adige, Panama, Corsica, Capri, Grigio, Hawaii).
- Part 3 — Pebble Mixes:** six pebble finishes (Rosa, Botticino, Lavisca, Grigio Pebbles, Arabescato, Mille Fiore).

P1 Base Coat Epoxy — Mix Specification

Standardized batch ratios and resin requirements. Standard batch reference: **100 kg**.

BATCH SIZE	PART A EPOXY	PART B EPOXY	AGGREGATE
1 (full)	3.200 kg	1.920 kg	4 bags · 100 kg
3/4	2.400 kg	1.440 kg	3 bags · 75 kg
1/2	1.600 kg	0.960 kg	2 bags · 50 kg
1/4	0.800 kg	0.480 kg	1 bag · 25 kg

MIXING NOTES & REQUIREMENTS

- Ensure thorough blending of resin **before** introducing aggregate materials.
- When pouring the blended mix into the mixer, **scrape the bucket** to ensure all of the epoxy is transferred.
- Maintain consistent measurement units (**kilograms**) for all batching operations.

Sorgiva® Finish Mixes

Each Sorgiva® finish color is produced from a specific blend of quartz and pigmented aggregates combined with the standard two-part resin binder. This part specifies the recipe, batch size, and mixing procedure for each available mix.



HOW TO READ EACH MIX CARD

Quantities are **per batch**. The Aggregate Mix table specifies the dry materials (kg + bags). The Resin System table specifies Part A (6kg) and Part B (2kg) of the binder, totaling 8 kg per batch across all mixes.

SOP

Standard Mixing Procedure

All mix designs in this annex follow the same procedure. Quantities below produce **one batch**; scale per project.

01 Verify materials

Verify all aggregate colors and weights before combining.

02 Mix Part A & B

Mix the required amounts of Part A and Part B thoroughly using the resin amounts shown for the selected mix.

03 Blend & mix

Add resin mixture into aggregate all at once, scrape resin bucket clean. From the time resin first touches aggregate, mix **1 min 15 sec**.

04 Stop the mixer

Turn the mixer off after mixing to ensure the material does not turn black.

05 Transfer

Empty into buckets or a wheelbarrow and transport to the installation site.



CRITICAL

Do not leave the mixer running after blending is complete — over-mixing causes the material to turn black and ruins the batch.

Mix Designs — continued

B.1 Caraibi			1 BATCH
AGGREGATE MIX			
INGREDIENT	AMOUNT	BAG(S)	
Bianco Quarzo	75.0 kg	3	
Blu	25.0 kg	1	
Total aggregate	100.0 kg	4	
RESIN SYSTEM (BINDER)			
COMPONENT	AMOUNT		
Part A (6%)	6.0 kg		
Part B (2%)	2.0 kg		

B.2 Adige			1 BATCH
AGGREGATE MIX			
INGREDIENT	AMOUNT	BAG(S)	
Botticino	25.0 kg	1	
Bianco Sporco	25.0 kg	1	
Bianco Quarzo	25.0 kg	1	
Grigio	25.0 kg	1	
Negro (Black)	2.0 kg	—	
Total aggregate	102.0 kg	4	
RESIN SYSTEM (BINDER)			
COMPONENT	AMOUNT		
Part A (6%)	6.0 kg		
Part B (2%)	2.0 kg		

B.3 Panama			1 BATCH
AGGREGATE MIX			
INGREDIENT	AMOUNT	BAG(S)	
Bianco Quarzo	50.0 kg	2	
Giallo Quarzo	50.0 kg	2	
Total aggregate	100.0 kg	4	
RESIN SYSTEM (BINDER)			
COMPONENT	AMOUNT		
Part A (6%)	6.0 kg		
Part B (2%)	2.0 kg		

B.4 Corsica			1 BATCH
AGGREGATE MIX			
INGREDIENT	AMOUNT	BAG(S)	
Giallo Quarzo	25.0 kg	1	
Bianco Quarzo	75.0 kg	3	
Total aggregate	100.0 kg	4	
RESIN SYSTEM (BINDER)			
COMPONENT	AMOUNT		
Part A (6%)	6.0 kg		
Part B (2%)	2.0 kg		

Mix Designs — continued

B.5 Capri			1 BATCH		
AGGREGATE MIX					
INGREDIENT	AMOUNT	BAG(S)			
Grigio	50.0 kg	2			
Bianco Quarzo	50.0 kg	2			
Total aggregate	100.0 kg	4			
RESIN SYSTEM (BINDER)					
COMPONENT	AMOUNT				
Part A (6%)	6.0 kg				
Part B (2%)	2.0 kg				

B.6 Grigio			1 BATCH		
AGGREGATE MIX					
INGREDIENT	AMOUNT	BAG(S)			
Grigio Quarzo	100.0 kg	4			
Total aggregate	100.0 kg	4			
RESIN SYSTEM (BINDER)					
COMPONENT	AMOUNT				
Part A (6%)	6.0 kg				
Part B (2%)	2.0 kg				

B.7 Hawaii			1 BATCH		
AGGREGATE MIX					
INGREDIENT	AMOUNT	BAG(S)			
Verde Quarzo	50.0 kg	2			
Bianco Quarzo	50.0 kg	2			
Total aggregate	100.0 kg	4			
RESIN SYSTEM (BINDER)					
COMPONENT	AMOUNT				
Part A (6%)	6.0 kg				
Part B (2%)	2.0 kg				

Pebble Mixes

Pebble finishes use the same two-part resin binder as the Sorgiva® finish mixes, scaled to a **100 kg** batch (Part A 3.6 kg, Part B 1.2 kg). All five pebble mixes share the procedure below.

**HOW TO READ EACH MIX CARD**

Quantities are **per 100 kg batch**. The Aggregate Mix table specifies the dry materials (kg + bags). The Resin System table specifies Part A (3.6 kg) and Part B (1.2 kg) of the binder.

SOP

Pebble Mixing Procedure

All pebble mix designs follow the same procedure. Quantities below produce **one batch (100 kg)**; scale per project.

- 01

Pre-measure all materials

Confirm aggregate type, weight, and bag count before opening any container.
- 02

Mix Part A and Part B thoroughly

Combine the resin components and mix for **2–3 minutes** until fully homogeneous.
- 03

Combine resin with aggregates

Pour the blended resin into the aggregate, scraping the bucket clean.
- 04

Mix until evenly coated

Continue mixing until every pebble is uniformly wetted.
- 05

Apply immediately and finish surface

Transfer to the installation site and finish per the standard troweling procedure.

Pebble Mixes — continued

B.1 Rosa			1 BATCH · 100 KG		
AGGREGATE MIX					
INGREDIENT	AMOUNT	BAG(S)			
Rosa	100.0 kg	4			
Total aggregate	100.0 kg	4			
RESIN SYSTEM (BINDER)					
COMPONENT	AMOUNT				
Part A	3.6 kg				
Part B	1.2 kg				

B.2 Botticino			1 BATCH · 100 KG		
AGGREGATE MIX					
INGREDIENT	AMOUNT	BAG(S)			
Botticino	100.0 kg	4			
Total aggregate	100.0 kg	4			
RESIN SYSTEM (BINDER)					
COMPONENT	AMOUNT				
Part A	3.6 kg				
Part B	1.2 kg				

B.3 Lavisca			1 BATCH · 100 KG		
AGGREGATE MIX					
INGREDIENT	AMOUNT	BAG(S)			
Arabescato	50.0 kg	2			
Mille Fiore	50.0 kg	2			
Total aggregate	100.0 kg	4			
RESIN SYSTEM (BINDER)					
COMPONENT	AMOUNT				
Part A	3.6 kg				
Part B	1.2 kg				

B.4 Grigio Pebbles			1 BATCH · 100 KG		
AGGREGATE MIX					
INGREDIENT	AMOUNT	BAG(S)			
Grigio Pebbles	100.0 kg	4			
Total aggregate	100.0 kg	4			
RESIN SYSTEM (BINDER)					
COMPONENT	AMOUNT				
Part A	3.6 kg				
Part B	1.2 kg				

Pebble Mixes — continued

B.5 Arabescato		1 BATCH · 100 KG	
AGGREGATE MIX			
INGREDIENT	AMOUNT	BAG(S)	
Arabescato	100.0 kg	4	
Total aggregate	100.0 kg	4	
RESIN SYSTEM (BINDER)			
COMPONENT	AMOUNT		
Part A	3.6 kg		
Part B	1.2 kg		

B.6 Mille Fiore		1 BATCH · 100 KG	
AGGREGATE MIX			
INGREDIENT	AMOUNT	BAG(S)	
Mille Fiore	100.0 kg	4	
Total aggregate	100.0 kg	4	
RESIN SYSTEM (BINDER)			
COMPONENT	AMOUNT		
Part A	3.6 kg		
Part B	1.2 kg		

REF · BASE COAT STANDARDIZED BATCH RATIOS & RESIN REQUIREMENTS

Base Coat Epoxy — Mix Specification

Use this specification to scale base-coat epoxy batches by area. The full **1-batch** reference is **100 kg** of finished material; sub-batches are derived as exact fractions to keep Part A / Part B / aggregate proportions identical at every scale.

1 Preset Batch Configurations

BATCH SIZE	PART A EPOXY	PART B EPOXY	AGGREGATE
1 (full)	3.200 kg	1.920 kg	4 bags · 100 kg
3/4	2.400 kg	1.440 kg	3 bags · 75 kg
1/2	1.600 kg	0.960 kg	2 bags · 50 kg
1/4	0.800 kg	0.480 kg	1 bag · 25 kg

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STANDARD BATCH REFERENCE
100 kg per full batch. Always select the batch size that matches the area you can install before pot-life expires — never scale up from a sub-batch by adding more later.

2 Mixing Notes & Requirements

- 1
- Ensure thorough blending of resin **before** introducing aggregate materials.
- 2
- When pouring the blended mix into the mixer, **scrape the bucket** to ensure all of the epoxy is transferred.
- 3
- Maintain consistent measurement units (**kilograms**) for all batching operations.

DO NOT IMPROVISE RATIOS
Substitutions or proportional drift between Part A, Part B, and aggregate compromise cure quality and bond strength. If the required quantity falls between presets, run two consecutive sub-batches at the closest preset sizes — do not interpolate.

3 Curing Times

System ITAPOX 127 + ITAMID FL550S PHR 50

Thickness 1–8 mm Method ISO 868

CURING TEMPERATURE	RECOMMENDED CURING TIME
< 50°F	Not recommended
50 – 60°F	3–4 days
60 – 68°F	2–3 days
> 68°F	1.5–2.5 days

HOW THESE TIMES ARE DEFINED
Times indicate the period required for the epoxy system to reach at least **80% of maximum hardness**, measured per ISO 868. Do not apply below 50°F. Where the system is further formulated for a specific application, verify curing times by dedicated testing.

This document is intended for internal and client reference to ensure consistency in material preparation and application.

F.01 · 2-AGGREGATE BLEND

Caraibi

Bianco Quarzo with Blu accent. Combine the two aggregates dry, then add the activated resin and mix until evenly coated.

BLEND Bianco Quarzo 75% · Blu 25%

RESIN 6% A · 2% B (8 kg per 100 kg)

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Bianco Quarzo	75 kg
Blu	25 kg
RESIN · BINDER	
Part A (6%)	6.0 kg
Part B (2%)	2.0 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Bianco Quarzo	56.25 kg
Blu	18.75 kg
RESIN · BINDER	
Part A (6%)	4.5 kg
Part B (2%)	1.5 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Bianco Quarzo	37.5 kg
Blu	12.5 kg
RESIN · BINDER	
Part A (6%)	3.0 kg
Part B (2%)	1.0 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Bianco Quarzo	18.75 kg
Blu	6.25 kg
RESIN · BINDER	
Part A (6%)	1.5 kg
Part B (2%)	0.5 kg

SOP · 5 STEPS

Mixing Procedure

- 1 Pre-measure all aggregates and resin components.
- 2 Dry-blend aggregates until uniform.
- 3 Mix Part A + Part B thoroughly (2–3 min).
- 4 Combine activated resin with aggregate blend.
- 5 Mix until evenly coated; apply immediately.

F.02 · 5-AGGREGATE BLEND

Adige

Four equal parts plus Black accent. Pre-blend the four base aggregates, dose the Black last, then add resin.

BLEND 4× 25% bases + Black accent

RESIN 6% A · 2% B (8 kg per 100 kg)

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Botticino	25 kg
Bianco Sporco	25 kg
Bianco Quarzo	25 kg
Grigio	25 kg
Black	2 kg
RESIN · BINDER	
Part A (6%)	6.0 kg
Part B (2%)	2.0 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Botticino	18.75 kg
Bianco Sporco	18.75 kg
Bianco Quarzo	18.75 kg
Grigio	18.75 kg
Black	1.5 kg
RESIN · BINDER	
Part A (6%)	4.5 kg
Part B (2%)	1.5 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Botticino	12.5 kg
Bianco Sporco	12.5 kg
Bianco Quarzo	12.5 kg
Grigio	12.5 kg
Black	1 kg
RESIN · BINDER	
Part A (6%)	3.0 kg
Part B (2%)	1.0 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Botticino	6.25 kg
Bianco Sporco	6.25 kg
Bianco Quarzo	6.25 kg
Grigio	6.25 kg
Black	0.5 kg
RESIN · BINDER	
Part A (6%)	1.5 kg
Part B (2%)	0.5 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all aggregates and resin components.

2

Dry-blend aggregates until uniform.

3

Mix Part A + Part B thoroughly (2–3 min).

4

Combine activated resin with aggregate blend.

5

Mix until evenly coated; apply immediately.

F.03 · 50/50 BLEND

Panama

Equal parts Bianco Quarzo and Giallo Quarzo. Dry-blend before adding resin so the two stones disperse evenly.

BLEND Bianco Quarzo 50% · Giallo Quarzo 50%

RESIN 6% A · 2% B (8 kg per 100 kg)

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Bianco Quarzo	50 kg
Giallo Quarzo	50 kg
RESIN · BINDER	
Part A (6%)	6.0 kg
Part B (2%)	2.0 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Bianco Quarzo	37.5 kg
Giallo Quarzo	37.5 kg
RESIN · BINDER	
Part A (6%)	4.5 kg
Part B (2%)	1.5 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Bianco Quarzo	25 kg
Giallo Quarzo	25 kg
RESIN · BINDER	
Part A (6%)	3.0 kg
Part B (2%)	1.0 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Bianco Quarzo	12.5 kg
Giallo Quarzo	12.5 kg
RESIN · BINDER	
Part A (6%)	1.5 kg
Part B (2%)	0.5 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all aggregates and resin components.

2

Dry-blend aggregates until uniform.

3

Mix Part A + Part B thoroughly (2–3 min).

4

Combine activated resin with aggregate blend.

5

Mix until evenly coated; apply immediately.

F.04 · 2-AGGREGATE BLEND

Corsica

Bianco Quarzo with Giallo Quarzo accent at a 3:1 ratio. Dry-blend before adding resin.

BLEND Bianco Quarzo 75% · Giallo Quarzo 25%

RESIN 6% A · 2% B (8 kg per 100 kg)

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Giallo Quarzo	25 kg
Bianco Quarzo	75 kg
RESIN · BINDER	
Part A (6%)	6.0 kg
Part B (2%)	2.0 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Giallo Quarzo	18.75 kg
Bianco Quarzo	56.25 kg
RESIN · BINDER	
Part A (6%)	4.5 kg
Part B (2%)	1.5 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Giallo Quarzo	12.5 kg
Bianco Quarzo	37.5 kg
RESIN · BINDER	
Part A (6%)	3.0 kg
Part B (2%)	1.0 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Giallo Quarzo	6.25 kg
Bianco Quarzo	18.75 kg
RESIN · BINDER	
Part A (6%)	1.5 kg
Part B (2%)	0.5 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all aggregates and resin components.

2

Dry-blend aggregates until uniform.

3

Mix Part A + Part B thoroughly (2–3 min).

4

Combine activated resin with aggregate blend.

5

Mix until evenly coated; apply immediately.

F.05 · 50/50 BLEND

Capri

Equal parts Grigio and Bianco Quarzo. Dry-blend thoroughly before adding the activated resin.

BLEND Grigio 50% · Bianco Quarzo 50%

RESIN 6% A · 2% B (8 kg per 100 kg)

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Grigio	50 kg
Bianco Quarzo	50 kg
RESIN · BINDER	
Part A (6%)	6.0 kg
Part B (2%)	2.0 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Grigio	37.5 kg
Bianco Quarzo	37.5 kg
RESIN · BINDER	
Part A (6%)	4.5 kg
Part B (2%)	1.5 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Grigio	25 kg
Bianco Quarzo	25 kg
RESIN · BINDER	
Part A (6%)	3.0 kg
Part B (2%)	1.0 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Grigio	12.5 kg
Bianco Quarzo	12.5 kg
RESIN · BINDER	
Part A (6%)	1.5 kg
Part B (2%)	0.5 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all aggregates and resin components.

2

Dry-blend aggregates until uniform.

3

Mix Part A + Part B thoroughly (2–3 min).

4

Combine activated resin with aggregate blend.

5

Mix until evenly coated; apply immediately.

F.06 · SINGLE AGGREGATE

Grigio

Single-aggregate Quarzo Grigio finish. Pre-measure all materials before activating resin.

BLEND Quarzo Grigio 100%

RESIN 6% A · 2% B (8 kg per 100 kg)

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Quarzo Grigio	100 kg
RESIN · BINDER	
Part A (6%)	6.0 kg
Part B (2%)	2.0 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Quarzo Grigio	75 kg
RESIN · BINDER	
Part A (6%)	4.5 kg
Part B (2%)	1.5 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Quarzo Grigio	50 kg
RESIN · BINDER	
Part A (6%)	3.0 kg
Part B (2%)	1.0 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Quarzo Grigio	25 kg
RESIN · BINDER	
Part A (6%)	1.5 kg
Part B (2%)	0.5 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all aggregates and resin components.

2

Dry-blend aggregates until uniform.

3

Mix Part A + Part B thoroughly (2–3 min).

4

Combine activated resin with aggregate blend.

5

Mix until evenly coated; apply immediately.

F.07 · 50/50 BLEND

Hawaii

Equal parts Verde Quarzo and Bianco Quarzo. Dry-blend before adding the activated resin.

BLEND Verde Quarzo 50% · Bianco Quarzo 50%

RESIN 6% A · 2% B (8 kg per 100 kg)

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Verde Quarzo	50 kg
Bianco Quarzo	50 kg
RESIN · BINDER	
Part A (6%)	6.0 kg
Part B (2%)	2.0 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Verde Quarzo	37.5 kg
Bianco Quarzo	37.5 kg
RESIN · BINDER	
Part A (6%)	4.5 kg
Part B (2%)	1.5 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Verde Quarzo	25 kg
Bianco Quarzo	25 kg
RESIN · BINDER	
Part A (6%)	3.0 kg
Part B (2%)	1.0 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Verde Quarzo	12.5 kg
Bianco Quarzo	12.5 kg
RESIN · BINDER	
Part A (6%)	1.5 kg
Part B (2%)	0.5 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all aggregates and resin components.

2

Dry-blend aggregates until uniform.

3

Mix Part A + Part B thoroughly (2–3 min).

4

Combine activated resin with aggregate blend.

5

Mix until evenly coated; apply immediately.

M.01 · SINGLE AGGREGATE

Rosa

Single-aggregate pebble mix. Pre-measure all materials before mixing. Apply immediately after combining — pot life is short.

RESIN 3.6 kg A · 1.2 kg B per 100 kg

BAG 25 kg

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Rosa	100 kg
	4 bags
RESIN	
Part A	3.6 kg
Part B	1.2 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Rosa	75 kg
	3 bags
RESIN	
Part A	2.7 kg
Part B	0.9 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Rosa	50 kg
	2 bags
RESIN	
Part A	1.8 kg
Part B	0.6 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Rosa	25 kg
	1 bag
RESIN	
Part A	0.9 kg
Part B	0.3 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all materials.

2

Mix Part A + Part B thoroughly (2–3 min).

3

Combine resin with aggregates.

4

Mix until evenly coated.

5

Apply immediately and finish surface.

M.02 · SINGLE AGGREGATE

Botticino

Single-aggregate pebble mix. Pre-measure all materials before mixing. Apply immediately after combining — pot life is short.

RESIN 3.6 kg A · 1.2 kg B per 100 kg

BAG 25 kg

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Botticino	100 kg
	4 bags
RESIN	
Part A	3.6 kg
Part B	1.2 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Botticino	75 kg
	3 bags
RESIN	
Part A	2.7 kg
Part B	0.9 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Botticino	50 kg
	2 bags
RESIN	
Part A	1.8 kg
Part B	0.6 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Botticino	25 kg
	1 bag
RESIN	
Part A	0.9 kg
Part B	0.3 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all materials.

2

Mix Part A + Part B thoroughly (2–3 min).

3

Combine resin with aggregates.

4

Mix until evenly coated.

5

Apply immediately and finish surface.

M.03 · 50 / 50 BLEND

Lavisca

Equal-parts blend of Arabescato and Mille Fiore. Combine aggregates in the dry pail before adding resin so the blend coats evenly.

BLEND Arabescato 50% · Mille Fiore 50%

RESIN 3.6 kg A · 1.2 kg B per 100 kg

1 / 1

FULL BATCH · 100 KG

AGGREGATE	
Arabescato	50 kg
Mille Fiore	50 kg
2 + 2 bags	
RESIN	
Part A	3.6 kg
Part B	1.2 kg

3 / 4

THREE-QUARTER · 75 KG

AGGREGATE	
Arabescato	37.5 kg
Mille Fiore	37.5 kg
scoop from open bag	
RESIN	
Part A	2.7 kg
Part B	0.9 kg

1 / 2

HALF BATCH · 50 KG

AGGREGATE	
Arabescato	25 kg
Mille Fiore	25 kg
1 + 1 bag	
RESIN	
Part A	1.8 kg
Part B	0.6 kg

1 / 4

QUARTER · 25 KG

AGGREGATE	
Arabescato	12.5 kg
Mille Fiore	12.5 kg
scoop from open bag	
RESIN	
Part A	0.9 kg
Part B	0.3 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all materials.

2

Mix Part A + Part B thoroughly (2–3 min).

3

Combine resin with aggregates.

4

Mix until evenly coated.

5

Apply immediately and finish surface.

M.04 · SINGLE AGGREGATE

Grigio Pebbles

Single-aggregate pebble mix. Pre-measure all materials before mixing. Apply immediately after combining — pot life is short.

RESIN 3.6 kg A · 1.2 kg B per 100 kg

BAG 25 kg

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Grigio Pebbles	100 kg
	4 bags
RESIN	
Part A	3.6 kg
Part B	1.2 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Grigio Pebbles	75 kg
	3 bags
RESIN	
Part A	2.7 kg
Part B	0.9 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Grigio Pebbles	50 kg
	2 bags
RESIN	
Part A	1.8 kg
Part B	0.6 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Grigio Pebbles	25 kg
	1 bag
RESIN	
Part A	0.9 kg
Part B	0.3 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all materials.

2

Mix Part A + Part B thoroughly (2–3 min).

3

Combine resin with aggregates.

4

Mix until evenly coated.

5

Apply immediately and finish surface.

M.05 · SINGLE AGGREGATE

Arabescato

Single-aggregate pebble mix. Pre-measure all materials before mixing. Apply immediately after combining — pot life is short.

RESIN 3.6 kg A · 1.2 kg B per 100 kg

BAG 25 kg

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Arabescato	100 kg
	4 bags
RESIN	
Part A	3.6 kg
Part B	1.2 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Arabescato	75 kg
	3 bags
RESIN	
Part A	2.7 kg
Part B	0.9 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Arabescato	50 kg
	2 bags
RESIN	
Part A	1.8 kg
Part B	0.6 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Arabescato	25 kg
	1 bag
RESIN	
Part A	0.9 kg
Part B	0.3 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all materials.

2

Mix Part A + Part B thoroughly (2–3 min).

3

Combine resin with aggregates.

4

Mix until evenly coated.

5

Apply immediately and finish surface.

M.06 · SINGLE AGGREGATE

Mille Fiore

Single-aggregate pebble mix. Pre-measure all materials before mixing. Apply immediately after combining — pot life is short.

RESIN 3.6 kg A · 1.2 kg B per 100 kg

BAG 25 kg

1 / 1	
FULL BATCH · 100 KG	
AGGREGATE	
Mille Fiore	100 kg
	4 bags
RESIN	
Part A	3.6 kg
Part B	1.2 kg

3 / 4	
THREE-QUARTER · 75 KG	
AGGREGATE	
Mille Fiore	75 kg
	3 bags
RESIN	
Part A	2.7 kg
Part B	0.9 kg

1 / 2	
HALF BATCH · 50 KG	
AGGREGATE	
Mille Fiore	50 kg
	2 bags
RESIN	
Part A	1.8 kg
Part B	0.6 kg

1 / 4	
QUARTER · 25 KG	
AGGREGATE	
Mille Fiore	25 kg
	1 bag
RESIN	
Part A	0.9 kg
Part B	0.3 kg

SOP · 5 STEPS

Mixing Procedure

1

Pre-measure all materials.

2

Mix Part A + Part B thoroughly (2–3 min).

3

Combine resin with aggregates.

4

Mix until evenly coated.

5

Apply immediately and finish surface.

NOTE See Annex B for mix designs. These samples represent finished surface appearance only — refer to the manual for batch ratios, aggregate composition, and mixing procedure.

PART 1 · SORGIVA FINISHES

7 samples

Sorgiva Top Coats



Caraibi

F.01 · SORGIVA



Adige

F.02 · SORGIVA



Panama

F.03 · SORGIVA



Corsica

F.04 · SORGIVA



Capri

F.05 · SORGIVA



Grigio

F.06 · SORGIVA



Hawaii

F.07 · SORGIVA

NOTE See Annex B for mix designs. These samples represent finished surface appearance only — refer to the manual for batch ratios, aggregate composition, and mixing procedure.

PART 2 · PEBBLE MIXES

6 samples

Pebble Mixes



Rosa Corallo

M.01 · PEBBLE



Botticino

M.02 · PEBBLE



Lavisca

M.03 · PEBBLE



Grigio Bardiglio

M.04 · PEBBLE



Arabescato

M.05 · PEBBLE



Mille Fiore

M.06 · PEBBLE

Sorgiva Primer — Mixing, Coverage & Application

This guide outlines the proper component quantities, mixing sequence, estimated coverage, and pump-sprayer application method for Sorgiva Primer when decking over concrete.

PR.1 Component Mixing Requirements

COMPONENT	AMOUNT	NOTES
Part A	2.0 kg	Resin component
Part B	1.0 kg	Hardener component
Butyl acetate Acetato di butile	2.0 L	Solvent / thinner — added after A & B are mixed together

PR.2 Coverage Reference

MIXED PRIMER BATCH	COVERAGE
2.0 kg Part A + 1.0 kg Part B + 2.0 L butyl acetate	≈ 30 sqm

Approximate usage rate: **0.100 kg** resin components per sqm, before solvent addition.

PR.3 Mixing Procedure

- 01 Pour Part A**
Pour 2.0 kg of Sorgiva Primer Part A into a clean mixing container.
- 02 Add Part B**
Add 1.0 kg of Sorgiva Primer Part B into Part A.
- 03 Mix A + B fully**
Mix Part A and Part B thoroughly first — the same as when mixing for the final coat spray — until both components are fully blended and uniform.
- 04 Add solvent**
Once A and B are completely combined, add 2.0 L of acetato di butile / butyl acetate.
- 05 Mix again**
Mix again until the primer has a consistent appearance.
- 06 Transfer**
Transfer the mixed primer into clean pump sprayers.



IMPORTANT · MIXING SEQUENCE

Part A and Part B must be fully mixed together **before** adding the acetato di butile / butyl acetate. Do not add the solvent before the resin and hardener have been properly combined.

Application, Surface Prep & Safety

PR.4 Application Instructions

- Apply the primer evenly across the prepared surface using the pump sprayer.
- One mixed batch is designed to cover **≈ 30 sqm**.
- Maintain consistent coverage across the entire surface area.
- Avoid puddling, heavy build-up, or missed areas.
- Keep the pump sprayer clean and functioning properly throughout application.

PR.5 Surface Preparation

- Surface must be **clean, dry, and free of dust, dirt, oils, loose material, or contaminants** before primer is applied.
- Use only clean containers, mixing equipment, and pump sprayers.
- Apply primer only under suitable jobsite conditions as directed by the project specification or product requirements.

PR.7 Curing Times

System **ITAPOX 127 + ITAMID FL550S · PHR 50** · Thickness **1–8 mm** · Method **ISO 868**

CURING TEMPERATURE	RECOMMENDED CURING TIME
< 50°F	Not recommended
50 – 60°F	3–4 days
60 – 68°F	2–3 days
> 68°F	1.5–2.5 days

Times are the period required to reach at least **80% of maximum hardness** per ISO 868. Do not apply below 50°F. Temperatures converted from the manufacturer's Celsius values and rounded.

PR.6 Safety



WARNING · SOLVENT — BUTYL ACETATE

Butyl acetate is a flammable solvent. Use proper ventilation and appropriate PPE — gloves, eye protection, and respiratory protection when required. Keep away from sparks, open flames, and ignition sources.

- Always follow the applicable **SDS** and all project safety requirements.

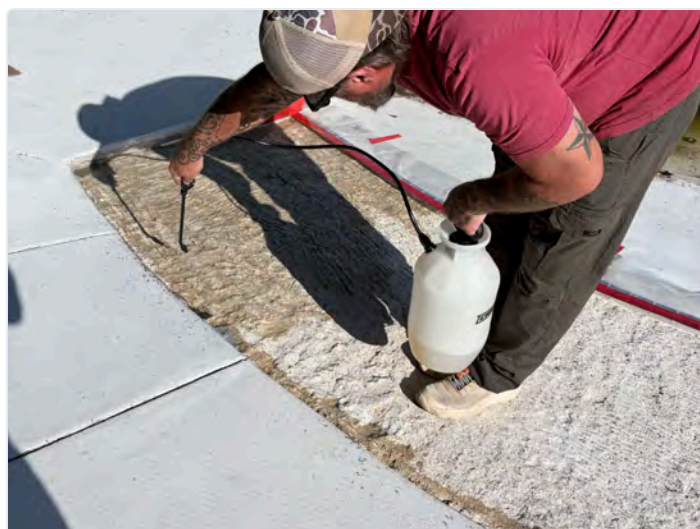


FIG PR.1 Applying primer with a pump sprayer. Note the darker tone of the freshly sprayed surface versus the dry concrete — use the color change to track full, even coverage.

Vertical Wall Installation

Vertical wall construction is the exception to the 42° maximum wall slope in Chapter 04. Use this procedure wherever the design calls for a true vertical face — a bench riser, tanning ledge, or perimeter wall.

VW.1 Kit Contents (forthcoming)

Reserved for the Vertical Wall Kit Contents reference — EPDM liner stock, JetBond, seam tape, reinforced corner tape, resin allocations, sand/aggregate, consumables.

VW.2 Wall Preparation

Surface must be smooth, with no holes or voids — any imperfection telegraphs through the liner.

- **Concrete or block walls.** Flash with mortar to fill honeycombing from the pour. Strike flush and cure before lining.
- **Vinyl-liner / metal panel walls.** Apply panel filler between panels to bridge gaps; scrape proud beads flush.
- **All wall types.** Confirm dry, dust-free, and free of form-release agents or sealers before glue-up.



WARNING · PREP IS NON-NEGOTIABLE

Gluing the liner over honeycombing or proud beads will cause a failure point under load. Re-prep before continuing — do not bridge a defect with adhesive.

When to use this section

USE CASE	Any wall above 42° / fully vertical face
TYPICAL	Bench & tanning ledge risers, perimeter walls
SUBSTRATE	Concrete, block, or vinyl-panel
ADHESIVE	JetBond — both wall & liner



FIG VW.1 Concrete wall after mortar flashing of honeycombing.

VW · VERTICAL WALL SIZING THE LINER AND ESTABLISHING REFERENCE LINES

Cut, Test Fit & Mark

Every vertical-wall piece is cut oversize and dry-fit before adhesive is opened. The sharpie reference line made during dry-fit is what keeps the top edge straight once JetBond is wet.

VW.3 Cut & Overlap

Leave **8" – 10"** of overlap on both the top and bottom edges of every liner piece to allow for top-edge seaming and the floor-to-wall transition.

WALL HEIGHT	CUT LENGTH	TOTAL OVERLAP
42"	58" – 60"	16" – 18"
36"	52" – 54"	16" – 18"
24"	40" – 42"	16" – 18"
Custom	wall + 16-20"	8-10" each end

VW.4 Test Fit & Mark

01 Gather extra hands

Bring 2–3 helpers to hold the liner against the wall. A single installer cannot hold a level top edge.

02 Dry-fit the piece

Hold the liner flat against the wall with the top overlap projecting above the wall edge.

03 Mark a reference line

Using a sharpie, mark a continuous line along the **top edge of the wall** on the face of the liner. This becomes the alignment reference during glue-up.



FIG VW.2 Dry-fit with the top overlap projecting above the wall edge. The sharpie line along the wall top becomes the alignment reference for glue-up.



NOTE · SEQUENCING

See §VW.13 — base coat in adjoining flat areas should be installed *before* the vertical wall finish, with a pebble line at the meeting plane.

VW · VERTICAL WALL BONDING THE LINER TO THE WALL

JetBond Glue-Up

JetBond is applied to **both** the wall and the back of the liner. Partial coverage on either side will fail. Work in bands — the first 12" – 18" at the top, then 10 sqft at a time down the wall.

VW.5 First Pass — Top Edge

01 Pull back 12" – 18"

With the liner still held to the wall, pull back the first 12" – 18" from the top.

02 Apply JetBond — both sides

Spray JetBond on **both the wall and the liner**. Both surfaces must be fully covered.

03 Set to mark

With a helper holding the top edge, align the sharpie reference to the top of the wall and press the liner firmly to the wall.

04 Work out bubbles

Press from the center outward, working all trapped air out toward the edges.



WARNING · BUBBLES

Any air trapped behind the liner will flex once sand is installed and crack the finish. Press every bubble out before moving on; if a section cannot lay flat, pull back and re-bond.



CAUTION · COVERAGE

Both surfaces must be fully sprayed. A dry patch on either the wall *or* the liner becomes a delamination point.

VW.6 Continuing Glue-Up

- Pull the next section of liner back and bond **10 sqft at a time**.
- Stay on the top-edge sharpie line — re-check alignment with every band.
- Confirm full contact across every square inch before moving on.

Seams, Corners & Water Test

VW.7 Vertical Seams

Where two liner pieces meet on a vertical wall, the seam is taped — not adhered with JetBond.

01 Plan 3" overlap

Leave at least a **3" overlap** between adjacent pieces for the seam tape footprint.

02 Glue piece #1 fully flat

Confirm piece #1 is bonded flat across the full seam area first.

03 Mask the seam zone

Before spraying JetBond on piece #2, cover the seam-tape footprint with **duct tape**. Any JetBond in this area prevents the primer from bonding.

04 Glue piece #2

Spray JetBond outside the masked area on both wall and liner; press flat per §VW.5–VW.6.

05 Pull mask, apply seam tape

Remove duct tape, prime, and lay seam tape across the full 3" overlap.



CAUTION · JETBOND CONTAMINATION

If JetBond contacts the seam-tape zone, primer and tape will not adhere. Clean off and re-mask, or re-cut piece #2.

VW.8 Corners & Reinforcement

- All corners and seam overlaps receive seam tape with a **3" overlap**.
- Apply **additional reinforced tape** over corners and any location with multiple overlapping seams.
- Inside corners are the most common failure point — reinforce generously.

VW.9 Water Test — non-negotiable

01 Fill above the highest seam

Fill to at least **10" above the highest vertical-wall seam**.

02 Mark & hold overnight

Mark the water level at the wall and let stand overnight.

03 Compare in the morning

Confirm the mark has not dropped. Investigate any drop before proceeding to resin.



WARNING · NO SHORTCUTS

The water test is mandatory. A leak found after sand application requires the wall to be stripped and re-built.

VW · VERTICAL WALL RESIN MIX DESIGN, BOND COAT PREPARATION

Resin Mix & Bond Coat

The vertical-wall resin uses the same A/B chemistry as the base and finishing layers, on a fixed ratio. **Do not alter A:B.** Mix only what your crew can place while the bond coat is still tacky.

VW.10 Mix Design — by Kit Size

KIT	SAND / AGGREGATE	PART A	PART B	TOTAL RESIN	COVERAGE
1 bag	25 kg	1.980 kg	0.600 kg	2.580 kg	30 sqft
2 bag	50 kg	3.960 kg	1.200 kg	5.160 kg	60 sqft
4 bag	100 kg	7.920 kg	2.400 kg	10.320 kg	120 sqft

Ratio: Part A 76.7% / Part B 23.3% of total resin. Scale linearly with sand.

VW.11 Mixing & Bond Coat

01 Combine resin

Combine Part A with Part B until uniform in color and consistency — about the consistency of Crisco.

02 Pull bond-coat portion

Remove ~5% of total resin for the wall bond coat. For a 50 kg kit, that is **1.25 – 1.50 kg**; scale proportionally for other kit sizes.

03 Trowel the bond coat

Mark out the wall area to be covered (30 sqft per 25 kg sand). Trowel the bond coat in a **thin, even glaze** — no heavy build-up.

04 Charge aggregate

Add the remaining resin to the sand in a top-load mixer; mix until evenly coated.

05 Decant

Dump the mixed aggregate into a bucket or mixing tray ready for the wall.



CAUTION · BOND COAT BUILD-UP

A heavy bond-coat layer disrupts curing. Keep it to a light glaze. Apply the sand-and-resin charge **while the bond coat is still active / tacky** — see §VW.12.

VW · VERTICAL WALL APPLICATION, SEQUENCING WITH FLAT AREAS, CURE

Wall Application, Sequencing & Cure

VW.12 Wall Application

01 Top-down

Apply **while the bond coat is still tacky**. Start at the top of the wall and trowel the sand-and-resin mixture into the bond coat with firm pressure.

02 Work side to side

Work the top edge across the wall, then progress down. Use material that falls during the application to finish the bottom of the wall.

03 Keep the trowel clean

Wipe the trowel down regularly with a rag and **denatured alcohol** to prevent dragging and provide a smooth finish.

04 Repeat

Repeat the mix-and-apply cycle until the full wall is covered.



FIG VW.3 Troweling the sand-and-resin charge into the tacky bond coat — top of wall, working downward.

VW.14 Cure & Notes

FULL CURE	≈ 33 hours
WORKING TIME	Apply while bond coat is tacky
A : B RATIO	Do not alter — kit-specific
SURFACE	Clean, dry, primed per §VW.2
PPE	Per Ch. 02



NOTE · SCALING

A 4-bag (100 kg) mix takes 7.92 kg Part A + 2.40 kg Part B and covers ≈ 130 sqft. Mix only what the crew can place in the bond-coat window.

VW.13 Sequencing with Flat Areas

- Install **all base-coat material in flat areas first**, before applying the finish-sand layer on a vertical wall.
- Wherever base-coat material meets the vertical wall, install a **pebble line** at the joint for expansion.
- For a vertical wall *below* a flat area (bench or tanning ledge face), install the upper-flat base coat first; this lets you carry the vertical-wall sand-and-resin mix up onto the face of the flat in one continuous skin.

VW.15 Curing Times — ITAPOX 970 + ITAMINE CA870 · PHR 38 · Thickness 1–8 mm · Method ISO 868

CURING TEMPERATURE	< 50°F	50 – 60°F	60 – 68°F	> 68°F
Recommended curing time	Not recommended	8–9 days	6–7 days	4–5 days

Times are the period required to reach at least **80% of maximum hardness** per ISO 868. Do not apply below 50°F. Temperatures converted from the manufacturer's Celsius values and rounded.

Collaflex — Mixing & Coverage

Collaflex is the resin used to **resurface a pool that has been damaged, or to resurface an older pool**. This reference covers batch quantities, coverage, and the mixing and application sequence.

CF.1 Batch Summary

ITEM	VALUE
Product	Collaflex
Part A	7.420 kg
Part B	4.200 kg
Total mixed Collaflex	11.620 kg
Coverage rate	139.93 sq ft

CF.2 Estimated Usage Rate

MEASUREMENT	APPROX. RATE
Per square meter	0.894 kg/sqm
Per square foot	0.083 kg/sq ft

Coverage may vary with surface condition, substrate profile, application thickness, and jobsite conditions.

CF.3 Mixing & Application

- 01 Measure Part A**
Measure 7.420 kg of Collaflex Part A into a clean mixing container.
- 02 Add Part B**
Measure 4.200 kg of Collaflex Part B and add it to Part A.
- 03 Mix until uniform**
Mix thoroughly until both components are fully blended and the material is uniform.
- 04 Apply**
Apply the mixed Collaflex to the prepared surface at the specified coverage rate.
- 05 Batch coverage**
One full mixed batch is designed to cover approximately **13 sqm (≈ 139.93 sq ft)**.
- 06 Broadcast silica sand**
A layer of #20 silica filter sand should be broadcast onto the Collaflex while it is still wet to ensure a good mechanical bond between the Collaflex layer and the finish layer of sand.
- 07 Sand-cover**
After Collaflex is applied, it must be covered with sand **within 24 hours** — see §CF.4.



IMPORTANT · RATIO

Do not split or alter the Part A : Part B ratio unless directed by the product manufacturer or technical representative.

Sand-Cover Window & Customer Notes

CF.4 Sand-Cover & Re-Prime Window

Collaflex must be covered with sand **within 24 hours** of application.



WARNING · 24-HOUR WINDOW

If Collaflex is **not** sand-covered within 24 hours, spray the surface with primer and allow it to dry before proceeding.



FIG CF.1 Spreading mixed Collaflex across the prepared surface with a trowel. Maintain an even film at the specified coverage rate.

CF.5 Customer Notes

- Surface should be **clean, dry, stable, and properly prepared** prior to application.
- Coverage may vary depending on surface condition, substrate profile, application thickness, and jobsite conditions.
- Do not split or alter the Part A / Part B ratio unless directed by the manufacturer or technical representative.



CAUTION · WEATHER / WORKABILITY

In hot temperatures or direct sunlight, mixed Collaflex may dry quickly. Depending on temperature and sun exposure, **mix only ½ batch at a time** to maintain workability and reduce waste.

CF.6 Curing Times

System ITAPOX 127 + ITAMID FL550S · PHR 50 · Thickness 1-8 mm · Method ISO 868

CURING TEMPERATURE	RECOMMENDED CURING TIME
< 50°F	Not recommended
50 - 60°F	3-4 days
60 - 68°F	2-3 days
> 68°F	1.5-2.5 days

Times are the period required to reach at least **80% of maximum hardness** per ISO 868. Do not apply below 50°F. Temperatures converted from the manufacturer's Celsius values and rounded.