ACTFLEX 300.



Technical Data Sheet | **Polymer Primer and Bonding Additive for Cementitious Systems** | **Issue date: 12 August 2026**

Description

ACTFLEX 300 is a water-based polymer bonding primer and additive engineered for FORSPEC cementitious systems. As a primer, it prepares concrete for FORSPEC LEVELX and LEVELX PRO levelling compounds, is the general-use tack-coat primer beneath FORBUILD 100 and FORCRETE 100 repair mortars, and primes PVC panel walls ahead of ACTFLEX 5000 sheet membrane installation. As an additive, it gauges repair mortar and screed binder mixes and forms the polymer component of FORSPEC slurry bond coats, driving adhesion at the substrate interface and density through the mix body. Within the FORSPEC enhanced screed system with FIBRE X, it enables reduced screed thickness minimums under written FORSPEC approval.

Advantages

- Dual-role product — one liquid serves as primer, slurry polymer and mix additive across the FORSPEC cementitious range.
- Drives intimate adhesion at the substrate interface — mortars, levellers and screeds bond to the tack coat, not to dust.
- Upgrades mix density, workability and adhesion when gauged into repair mortars and screed binders.
- The polymer component of every FORSPEC slurry bond coat system.
- Primes PVC panel walls for ACTFLEX 5000 sheet membrane installation.
- Enables the FORSPEC enhanced screed system with FIBRE X — reduced thickness minimums under written approval.
- Water-based and low odour — water clean-up while wet.
- Simple site dosing — measured by the litre against each host product's TDS.

Uses

- Primer for FORSPEC LEVELX and LEVELX PRO on dry concrete substrates, including the double-prime method on rough or porous concrete.
- General-use tack-coat primer for FORBUILD 100 and FORCRETE 100 structural repair mortars on prepared concrete.
- Primer for PVC panel walls ahead of ACTFLEX 5000 sheet membrane installation, per the ACTFLEX 5000 TDS.
- Polymer component of FORSPEC slurry bond coats beneath screeds, levellers and repair mortars.
- Gauging additive in FORCEM SCREED BINDER mixes and the FORCRETE 100 enhanced mix.
- Component of the FORSPEC enhanced screed mix with FIBRE X for reduced-thickness bonded and unbonded screeds.

Compliance Status

No Australian Standard prescribes performance requirements for polymer bonding primers and additives of this type. System compliance is carried by the host products — FORSPEC screeds to EN 13813 and AS 3958.1, and FORSPEC repair mortars to the EN 1504-3 criteria — with ACTFLEX 300 dosed strictly per each host product's TDS. Hazard classification: NON-HAZARDOUS CHEMICAL, NON-DANGEROUS GOODS per the current SDS (Chemwatch 7913-05).

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Technical Data

PROPERTY	VALUE	BASIS
Form	Water-based polymer emulsion	—
Packaging	18 kg (approx. 18 L) and 15 kg (approx. 15 L) pails	—
Non-volatile content	Greater than 8%	*
pH	Greater than 7	*
Nominal density	Approx. 1.0 kg/L (1 kg ≈ 1 L for site dosing) †	*
Surface tack time — tack-coat use (at 25°C, 50% RH)	Approx. 90 minutes or longer, substrate-dependent	*
Primer dry time under repair mortars (at 25°C, 50% RH)	Approx. 1 hour	*
Tack-coat coverage	Approx. 3–5 m^2 per kg, porosity-dependent	*
Application temperature	5–35°C (ambient and substrate)	—
Clean up	Water, while wet	—
Hazard classification	Non-hazardous; non-dangerous goods	SDS — Chemwatch 7913-05
Shelf life	12 months, unopened, stored at 5–30°C	—

* Typical characteristic values determined by Forspec R&D on standard production material at 25°C and 50% relative humidity. Values are not to be relied upon for engineering design without written confirmation from FORSPEC Technical Services. † Volume equivalents are nominal pending R&D confirmation of relative density; dose by the batch label where stated.

Primer Applications

HOST SYSTEM	PRIMER PROCEDURE
FORSPEC LEVELX / LEVELX PRO (dry concrete, moisture 4.5% or less)	Prime with ACTFLEX 300. On rough or porous concrete use the double-prime method: first coat by roller, allowed to become tacky (not dry); second coat applied; leveller poured while the second coat is still tacky.
FORBUILD 100 (prepared concrete)	Apply evenly by brush or roller; on porous or highly absorbent substrates apply two coats, allowing the first to dry. Place the mortar while the coat is tacky — typical dry time approx. 1 hour at 25°C and 50% RH.
FORCRETE 100 (prepared concrete, general use)	Apply to all prepared concrete surfaces and place the mortar while the primer is tacky. If the primer dries, re-apply — never place mortar over dry or overly wet primer.
ACTFLEX 5000 (PVC panel walls)	Prime the PVC panel surface with ACTFLEX 300 before sheet membrane installation, in accordance with the ACTFLEX 5000 TDS.

High-moisture substrates (over 4.5%) and green concrete are outside ACTFLEX 300 priming — the host TDS specifies the ACTFLEX EP250 system for those conditions.

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Slurry Bond Coats

HOST SYSTEM	SLURRY MIX (BY PARTS)	RULE
FORSPEC SCREEDX	FORCEM SCREED BINDER : ACTFLEX 300 at 3 : 2 by weight	Always the FORCEM + ACTFLEX 300 slurry — never SCREEDX powder. Screed placed while the slurry is wet/tacky.
FORSPEC LEVELX	1 ACTFLEX 300 : 1 clean water : 2 LEVELX powder	Smooth, dense or burnished concrete; brushed firmly in; leveller poured while tacky.
FORSPEC LEVELX PRO	1 ACTFLEX 300 : 1 clean water : 2 LEVELX PRO powder	As for LEVELX — never after the slurry has dried.
FORBUILD 100	1 ACTFLEX 300 : 1 clean water : 3 FORBUILD 100 powder	Mixed to brushable consistency, brushed firmly into the substrate; mortar placed while tacky.

Every slurry is mixed lump-free and scrubbed into the saturated-surface-dry substrate with a stiff brush or broom. A slurry that dries is never wetted back — a fresh coat is applied.

Gauging and Enhanced Mixes

HOST SYSTEM	ACTFLEX 300 DOSE	RULE
FORCEM SCREED BINDER mixes	2 L (approx. 2 kg) per 20 kg bag	Deducted from the mixing water allowance — total liquid never exceeds the host TDS dose.
FORCRETE 100 enhanced mix	1.2 L (approx. 1.2 kg) per 20 kg bag, with 2.4 L water (2:1 water : ACTFLEX 300)	Replaces the standard 3.6 L water dose for enhanced bonding and moisture tolerance.
FORSPEC enhanced screed mix (with FIBRE X)	Per the project-specific FORSPEC specification	Enables 5 mm bonded and 35 mm unbonded screed minimums — only with written FORSPEC approval.

Coverage and Yield

PACK	GAUGING FORCEM (2 L/BAG)	FORCRETE ENHANCED (1.2 L/BAG)
15 kg (approx. 15 L) pail	Approx. 7 bags	Approx. 12 bags
18 kg (approx. 18 L) pail	Approx. 9 bags	Approx. 15 bags

Tack-coat priming: approx. 3–5 m² per kg — a 15 kg pail primes approximately 45–75 m² per coat, porosity-dependent. Slurry yields depend on the host powder dose.

Limitations

- Not a standalone waterproofing product, membrane, coating or wearing surface.
- Not a primer for FORSPEC butyl sheet membranes — ACTFLEX 900R is bonded with ACTFLEX 302 or ACTFLEX 301 Adhesive per its TDS.
- Dosages, dilutions and procedures are governed by the host product's TDS — this document consolidates them for reference.
- Toppings, levellers and mortars are always placed while the primer or slurry is tacky — a dried coat is re-applied fresh, never re-wetted.
- Not for high-moisture substrates (over 4.5%) or green concrete — the host TDS specifies the ACTFLEX EP250 system.
- Apply only between 5–35°C (ambient and substrate); never to frozen, frosted, saturated-glistening or contaminated substrates.
- Do not dilute beyond the dilutions specified in the host TDS.

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Limitations (continued)

- Protect from frost in storage and transport — a frozen emulsion is discarded.

Surface Preparation

- Substrates must be structurally sound, clean and free of laitance, dust, oil, grease, curing compounds, release agents, coatings and loose material — prepared per the host product's TDS.
- For slurry bond coats: bring the substrate to saturated surface dry (SSD) with no standing water.
- For tack-coat priming: the substrate condition and moisture limits of the host TDS apply.
- PVC panels for ACTFLEX 5000: clean, dry and free of release agents and plasticiser bloom, per the ACTFLEX 5000 TDS.

Application

- Stir thoroughly before use to a uniform consistency — the emulsion settles in storage.
- Primer coats: apply evenly by brush or roller without pooling or ponding at low points; excessive film build impairs bond.
- Slurries: mix lump-free and scrub firmly into the SSD substrate with a stiff brush or broom; place the topping while the slurry is wet or tacky.
- Gauging: measure the dose exactly and deduct it from the host product's mixing water allowance.
- Observe the tack windows — tacky means firm finger touch with no wet transfer; dried coats are re-applied.
- Protect fresh coats from rain, condensation and contamination until covered.

Drying, Curing and Testing Times

All times below are measured at 25°C and 50% RH. Low temperature, high humidity, poor ventilation and increased thickness extend every stage — verify on site before proceeding.

STAGE (AT 25°C, 50% RH)	TIME
Primer dry time under repair mortars	Approx. 1 hour *
Surface tack time — tack-coat use	Approx. 90 minutes or longer, substrate-dependent *
Placement window — tack-coat use	While the coat is still tacky — re-coat if it has dried *
Second primer coat on porous substrates	Once the first coat has dried *
Slurry bond coat — placement window	Wet-on-wet, before the slurry skins *

* Typical R&D characteristic values, not for engineering design without written FORSPEC confirmation.

Clean Up

Clean tools and equipment with water immediately while the product is wet. Dried ACTFLEX 300 can only be removed mechanically. Allow wash water to settle, decant, and dispose of residues in accordance with the relevant State or Territory environment protection legislation — never into drains, sewers or waterways.

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Container and Waste Disposal

Allow residues to dry before disposal in accordance with local council requirements. Empty pails are recycled where facilities accept them. Do not seal or stopper drums being decontaminated. Refer to Section 13 of the SDS for detailed disposal requirements.

Quality Records

Record the batch numbers of all ACTFLEX 300 and host products used, the role in which it was used (primer, slurry, gauging), dosages and dilutions, substrate moisture readings, application dates and conditions, as part of the project quality assurance records. Batch numbers are printed on the pail and provide full manufacturing traceability.

Storage

Store sealed in original packaging in cool, dry, ventilated conditions between 5°C and 30°C, protected from direct sunlight and frost — the emulsion must never freeze. Keep containers sealed when not in use. Shelf life: 12 months from the date of manufacture when stored as specified.

Safety Precautions and First Aid

ACTFLEX 300 is classified NON-HAZARDOUS CHEMICAL and NON-DANGEROUS GOODS under its current Safety Data Sheet (Chemwatch 7913-05), with all Chemwatch hazard ratings at zero. Observe good industrial hygiene: wear gloves and eye protection when handling, avoid prolonged skin contact, change soiled clothing and wash hands before breaks and after work. Prevent release to drains, soil and waterways.

First aid — Eyes: wash out immediately with water; seek medical attention if irritation continues. Skin: flush with running water and soap. Inhaled: remove to fresh air; further measures are usually unnecessary. Swallowed: give a glass of water; first aid is not generally required — if in doubt, contact a doctor. POISONS INFORMATION CENTRE: 13 11 26 (Australia-wide, 24 hours). In an emergency, dial 000. KEEP OUT OF REACH OF CHILDREN. Read the Safety Data Sheet (SDS) before use — available at www.forspec.com.au.

Warranty

Standard Product and Performance Warranty: Forspec Protective Coatings Pty Ltd as Trustee for Forspec Protective Coatings (ABN 11 204 033 631) warrants that ACTFLEX 300 will be free from manufacturing defects and will not fail under normal usage for a period of ten (10) years from the date of purchase, when installed and used strictly in accordance with this Technical Data Sheet and Forspec's written instructions. This warranty covers the supply of the product only; it does not cover installation, application or workmanship. Remedies are limited, at Forspec's discretion, to replacement of the defective product (or defective portion) or a refund of the purchase price. The full terms, conditions and exclusions are set out in the Forspec Standard Product and Performance Warranty, available at www.forspec.com.au — key conditions include application by a suitably qualified and, where required by law, licensed applicator; use within shelf life; and installation as part of a Forspec approved system without non-approved third-party products.

Project and system warranties: extended project-specific warranties are available at the request of the applicator and must be applied for using the Forspec Warranty Request Form prior to commencement of works. Issue is subject to Forspec approval and is conditional on the use of the complete specified FORSPEC system, application in strict accordance with the current TDS by suitably qualified applicators, and completion of the project quality records described above. The warranty period and terms are as stated in the issued warranty certificate.

Claims: notify Forspec in writing within thirty (30) days of discovery of the alleged defect and within the warranty period, by post to 22/872 Canterbury Road, Roselands NSW 2196 or by email to info@forspec.com.au, including proof of purchase, installation details (date, location, installer), a description of the defect with supporting evidence, and your contact details. Forspec may inspect the site, perform testing and collect samples before determining a claim.

Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

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Data Sheet Currency

This Technical Data Sheet (TDS) and the corresponding Safety Data Sheet (SDS) are subject to revision as necessary to ensure compliance with relevant Australian Standards and to incorporate technological advancement. Read the most current versions before use, as application and performance data may be updated. For the latest technical information, contact Forspec Protective Coatings on (02) 8021 3517 or info@forspec.com.au. The information provided is representative and does not serve as a comprehensive specification. For specific projects, consult directly with Forspec Protective Coatings for tailored specifications. This data sheet was issued on 12/08/2026 and is valid for three years from the date of issue unless superseded by a later revision — always confirm the current version at www.forspec.com.au before use.

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