ACTFLEX 600 PRIMER.



Technical Data Sheet | **One-Component Moisture-Cured Hybrid Polyurethane Primer for ACTFLEX 906 WPU** | **Issue date: 13 November 2026**

Description

ACTFLEX 600 PRIMER is a one-component, moisture-cured hybrid polyurethane primer engineered as a bonding primer for ACTFLEX 906 WPU. Rather than simply coating the surface, the hybrid chemistry interacts with the substrate to build a molecular interlocking interface, penetrating deeply into new and aged concrete, consolidating rendered and masonry surfaces and establishing a durable bonding plane on compressed fibrous cement, precast panels and existing waterproofing layers.

The hybrid backbone is the reason it bridges two chemistries that are normally incompatible: it cures on atmospheric moisture like a solvent polyurethane, yet accepts the water-based ACTFLEX 906 WPU membrane directly over the cured film. Applied as a single coat at 50–100 microns dry film by roller, brush or spray, the primed surface is waterproof within 3 hours and fully cured within 6 hours at 25°C and 50% RH, so the membrane follows within the same working day. Supplied in 4 L and 17 L packs.

Advantages

- A bonding primer for ACTFLEX 906 WPU water-based polyurethane membrane.
- Hybrid polyurethane chemistry — moisture cured, yet directly overcoatable with water-based membranes.
- Chemically interacts with the substrate to form a molecular interlocking bonding interface.
- Deep penetration into new and aged concrete for secure long-term bonding.
- Waterproof within 3 hours and fully cured within 6 hours at 25°C and 50% RH.
- Establishes intercoat bonding over existing waterproofing layers for repair and maintenance work.
- Improves adhesion on smooth, factory-finished precast concrete panels.
- Good solvent resistance once fully cured.
- Applies by roller, brush or spray at 4–6 m² per litre.

Uses

- Bonding primer beneath ACTFLEX 906 WPU water-based polyurethane waterproofing membrane.
- New and aged concrete substrates.
- Rendered surfaces and masonry structures.
- Compressed fibrous cement sheeting.
- Precast concrete panels and smooth factory-finished surfaces.
- Existing waterproofing layers, for intercoat bonding in repair and maintenance.
- Porous and non-porous substrates, subject to confirmation with a FORSPEC representative.

Compliance Status

All performance values are published as typical R&D characteristic values. System compliance is established by the certified ACTFLEX 906 WPU membrane applied over the primer.

STANDARD / TEST	STATUS	REFERENCE
AS/NZS 4858 — wet area membranes	Not applicable — the primer is a system component, not a membrane	Compliance is established by ACTFLEX 906 WPU
Adhesion performance beneath ACTFLEX 906 WPU	FORSPEC R&D result	Forspec R&D *

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Technical Data

Certified values are stated against their governing report. All other values are typical R&D characteristic values and are asterisked.

PROPERTY	VALUE	BASIS
Product type	One-component, moisture-cured hybrid polyurethane primer	—
System	ACTFLEX 906 WPU water-based polyurethane membrane	—
Appearance	Translucent matte viscous liquid	—
Odour	Solvent odour	—
Density at 25°C	1.0–1.2 g/mL	*
Volatile content	< 70% w/w	*
Vapour pressure at 25°C	3.8 kPa	*
Flash point	> 23°C	*
Solubility	Soluble in organic solvents; insoluble in water	—
Solvent resistance	Good when fully cured	*
Coats	1	—
Recommended dry film thickness	50–100 microns	—
Coverage	4–6 m^2/L, surface dependent	—
Touch dry, minimum (at 25°C, 50% RH)	Approx. 20 minutes †	*
Waterproof (at 25°C, 50% RH)	3 hours	*
Full cure (at 25°C, 50% RH)	6 hours	*
Usable period after opening	Within the same day	—
Application temperature	+10°C to +26°C	—
Packaging	4 L and 17 L	—
Shelf life	9 months, unopened, stored as specified	—
Application method	Roller, brush grade or spray	—

† Touch-dry time was stated in the source data as 30 minutes at 20°C and 15 minutes at 30°C. The value above is the interpolated figure at the library reference condition of 25°C and 50% RH — refer to the Change Register. ACTFLEX 600 PRIMER is a hybrid polyurethane primer for the water-based ACTFLEX 906 WPU system; for solvent-based ACTFLEX 929 SL and ACTFLEX 929 HV systems, specify ACTFLEX 700 PU PRIMER.

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

Coverage and Yield

MEASURE	VALUE	BASIS
Coverage per litre	4–6 m^2	Surface porosity dependent
Consumption per coat	Approx. 0.17–0.25 L/m^2 *	At 4–6 m^2/L
Coverage — 4 L pack	Approx. 16–24 m^2	At 4–6 m^2/L
Coverage — 17 L pack	Approx. 68–102 m^2	At 4–6 m^2/L
Dry film build	50–100 microns per coat	Recommended thickness

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Coverage and Yield (continued)

Coverage varies with substrate porosity and surface profile. Porous and textured substrates increase consumption. * Typical R&D characteristic values, not for engineering design without written FORSPEC confirmation.

Limitations

- Not a waterproofing membrane and not a moisture barrier — where moisture control is required, specify ACTFLEX EP250 or ACTFLEX MB200.
- Not UV stable — the primed surface must be overcoated with ACTFLEX 906 WPU and never left exposed.
- Formulated for the ACTFLEX 906 WPU system — for solvent-based ACTFLEX 929 SL and ACTFLEX 929 HV systems specify ACTFLEX 700 PU PRIMER.
- Apply ONE coat only.
- Do not apply below 10°C or above 26°C substrate and ambient temperature.
- Do not dilute unless approved in writing by an authorised FORSPEC representative.
- Use all contents within the same day of opening — the product is moisture-cured and will skin and gel in a part-used container.
- Confirm suitability with a FORSPEC representative before use on non-porous substrates.
- Do not apply over damp substrates or where high moisture content is present.
- The uncured product and its vapours are combustible — exclude all ignition sources.
- Do not store or use in pits, depressions, basements or areas where vapours may be trapped.

Surface Preparation

- Clean the surface, removing dust, dirt, oil, grease, wax and all loose contaminants.
- Where necessary, mechanically grind or abrade to remove old coatings, laitance and weak layers.
- Reinstate cracks, holes and surface irregularities with a FORSPEC concrete repair system such as FORBUILD 100 or FORCRETE 100, finished flush and cured.
- Confirm the substrate is stable, sound and free from movement or flaking.
- Decontaminate non-porous surfaces by wiping with solvent or degreaser to remove surface residue.
- Dry the substrate — confirm the surface is dry and that moisture content will not compromise adhesion.
- Vacuum or blow clean to remove fine dust immediately before priming.
- Conduct a small adhesion test on critical surfaces to confirm compatibility where required.

Application and Film Build

- Stir the product thoroughly and gently before use — do not whip air into it.
- Ensure continuous ventilation and exclude all ignition sources throughout application.
- Apply ONE even coat by roller, brush or approved spray at 4–6 m^2 per litre to achieve 50–100 microns dry film.
- Work to full coverage across all edges, junctions and transitions.
- Avoid puddling and over-application.
- Reseal the container tightly whenever not in use, and use all contents within the same day.
- Confirm the primer is touch dry before applying ACTFLEX 906 WPU, and overcoat within the working session.
- Inspect for missed areas, pinholes and glossy puddled zones before the membrane is applied.

Drying, Curing and Testing Times

All times below are measured at 25°C and 50% RH. Low temperature, high humidity, poor ventilation and substrate porosity extend every stage — verify the primer is fully dry on site before overcoating.

STAGE (AT 25°C, 50% RH)	TIME
Touch dry, minimum	Approx. 20 minutes †
Waterproof	3 hours

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Drying, Curing and Testing Times (continued)

STAGE (AT 25°C, 50% RH)	TIME
Full cure	6 hours
ACTFLEX 906 WPU application	Once touch dry, within the same working session *
Maximum exposure before overcoating	Do not leave exposed — not UV stable *

† Interpolated to the library reference condition from the 20°C and 30°C source values — refer to the Change Register.

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

Clean Up

Clean tools and equipment immediately while the product is still wet, wiping down with FORSPEC EPOXY CLEANER or an approved solvent where the Safety Data Sheet permits. Once dry the product is difficult to remove and mechanical means will be necessary. Observe all WHS requirements and the Safety Data Sheet for safe solvent handling. Do not discharge product or wash water into sewers or waterways and do not touch spilled material.

Container and Waste Disposal

Allow residues to fully cure before disposal in accordance with State and local requirements, and route unused product to an authorised waste collection point per Section 13 of the Safety Data Sheet. Do not seal or stopper drums being decontaminated — carbon dioxide is generated and may pressurise the container. Do not reuse contaminated packaging and do not discharge into sewers or waterways.

Quality Records

Record the batch numbers of all ACTFLEX 600 PRIMER used, substrate type and preparation method, adhesion test results where undertaken, coverage and dry film thickness achieved, application date and conditions, touch-dry confirmation, and the interval between priming and ACTFLEX 906 WPU application, as part of the project quality assurance records.

Storage

Store locked up in original, unopened containers in a cool, dry, well-ventilated place, tightly closed and away from heat, sparks, open flames and all ignition sources — the uncured product is combustible and moisture sensitive. Do not store in pits, depressions, basements or areas where vapours may be trapped. Shelf life: 9 months from the date of manufacture when stored as specified.

Safety Precautions and First Aid

Refer to the current Safety Data Sheet before use. ACTFLEX 600 PRIMER is a solvent-based, moisture-reactive primer and is classified as hazardous: it may cause skin and eye irritation, and the uncured product and its vapours are combustible. Always use in a well-ventilated area and exclude all sources of ignition. Wear protective gloves, safety footwear, protective clothing and eye protection against splashes, and use appropriate respiratory protection at all times — organic vapour respirators fitted with particulate pre-filters and powered air-purifying respirators are NOT suitable for this product; select respiratory protection in accordance with the SDS and the workplace risk assessment. Change soiled work clothing and wash hands before breaks and after finishing work. Do not eat, drink or smoke when handling. Do not store or use in pits, depressions, basements or any area where vapours may be trapped.

First aid — Swallowed: immediately call a doctor or the POISONS INFORMATION CENTRE; do NOT induce vomiting. Inhaled: remove to fresh air and keep comfortable; if experiencing respiratory symptoms, seek medical attention. Skin: remove contaminated clothing and wash the affected area with soap and water; do not use solvent to clean skin. Eyes: rinse cautiously with water for several minutes; remove contact lenses if easy to do; continue rinsing and seek medical attention. 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.

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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 600 PRIMER 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.

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 13/11/2026 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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