ACTFLEX 929 HV.



Technical Data Sheet | **Non-Sagging Moisture-Cured Polyurethane Class III Waterproofing Membrane** | **Issue date: 27 October 2026**

Description

ACTFLEX 929 HV is a Class III, non-sagging, moisture-cured polyurethane waterproofing membrane engineered for internal and external under-tile and non-exposed applications where toughness, chemical resistance and root resistance govern selection. Independently certified Class III under both AS/NZS 4858 and AS 4654.1, it delivers 547% certified elongation with proven cyclic movement, immersion and heat-ageing performance. Its thixotropic body builds evenly on vertical and horizontal surfaces without slumping, reaching sufficient cure for mortar beds and screeds 48 hours after the final coat. Root-resistant for planter boxes and landscaped structures with non-aggressive root systems, it serves roof terraces, retaining walls, parking decks and wet areas beneath protected finishes.

Advantages

- Dual certification — Class III under AS/NZS 4858 (XTecGen Report 0242-5) and AS 4654.1 (Report 0242-7), with NATA-accredited results.
- Certified 547% control elongation with proven water, bleach and detergent immersion and heat-ageing durability.
- Non-sagging thixotropic body — holds its profile on vertical surfaces without slumping or dripping.
- Moisture-cure technology — single component, cures on atmospheric moisture to a tough elastomer.
- Sufficient cure for mortar beds and screeds 48 hours after the final coat (at 25°C, 50% RH).
- Does not re-emulsify after curing; immersion tolerant and chemically resistant.
- Root-resistant for non-aggressive root systems — planter boxes, garden beds and landscaped structures.
- Outstanding barrier properties against corrosive soil conditions; excellent resistance to embrittlement.
- Roller and brush grade for controlled, precise film build.

Uses

- Internal and external wet areas beneath protected finishes, per AS 3740.
- Roof terraces and roofs — non-exposed, beneath approved coverings, per AS 4654.2.
- Planter boxes and above-ground pits with non-aggressive root systems only — minimum 1.5 mm total DFT.
- Retaining walls and below-grade protected surfaces exposed to corrosive soils.
- Bridges, walkways, substations and parking decks beneath protection.
- Prepared concrete and metal surfaces; general waterproofing maintenance and repairs.

Compliance Status

STANDARD / TEST	RESULT	REPORT
AS/NZS 4858:2004 — wet area membranes	Class III	XTecGen Report 0242-5
AS 4654.1-2012 — external above-ground membranes	Class III	XTecGen Report 0242-7 (summary 242-8)
Bond strength (ASTM C794, EP250-primed concrete)	30.76 N — predominantly substrate failure	XTecGen Report 0242-7
AS 3740:2021 — internal wet areas	Complies as a Class III membrane within a compliant system	—

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Compliance Status (continued)

STANDARD / TEST	RESULT	REPORT
AS 4654.2 — external above-ground systems	Non-exposed applications within an approved system	—
Hazard classification	Hazardous chemical; combustible liquid (storage-regulated); non-dangerous goods	SDS — Chemwatch 7954-30

Testing by XTec Gen Pty Ltd, accredited for compliance with ISO/IEC 17025. Reports issued 26/10/2023, valid to 26/10/2026, available on request from Forspec Protective Coatings. Tested membrane build: two coats at 0.7 mm to a 1.2 mm dry film.

Technical Data

PROPERTY	VALUE	BASIS
Form	Viscous, thixotropic, non-sag liquid	—
Colour	Grey	—
Packaging	15 L (20 kg) pail	—
Chemical base / cure	Single-component polyurethane; moisture-cured	—
Solids content	90% ± 2%	*
Density	1.33 kg/L (20 kg ÷ 15 L)	—
Membrane classification	Class III (both standards)	Reports 0242-5 / 0242-7
Control elongation at break	547% (AS/NZS 4858); 511% (AS 4654.1)	AS 1145.3 — Reports 0242-5 / 0242-7
Control tensile strength	4.15 MPa (AS/NZS 4858); 3.17 MPa (AS 4654.1)	AS 1145.3 — Reports 0242-5 / 0242-7
Bond strength	30.76 N	ASTM C794 — Report 0242-7
Water absorption	0.79%	AS 3558.1 (modified) — Report 0242-5
Water vapour transmission	7.76 g/m²/24 h	ASTM E96 — Reports 0242-5 / 0242-7
Shore A hardness	55–60	*
Root resistance	Non-aggressive root systems only	*
Tack-free time (at 25°C, 50% RH, well ventilated)	6 hours	*
Recoat time (at 25°C, 50% RH, well ventilated)	4–6 hours — maximum 24 hours	—
Full cure (at 25°C, 50% RH, well ventilated)	48 hours at 1.2 mm DFT	*
Maximum wet film per coat	1.5 mm	—
Application temperature	10–26°C (ambient and substrate)	—
Shelf life	12 months, unopened, stored at 5–25°C	—

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Technical Data (continued)

Certified durability test results — XTecGen Reports 0242-5 and 0242-7

CONDITION	AS/NZS 4858 (REPORT 0242-5)	AS 4654.1 (REPORT 0242-7)
Control (AS 1145.3)	547% / 4.15 MPa — Class III	511% / 3.17 MPa — Class III
Water immersion	474% / 3.88 MPa — pass	744% / 3.06 MPa — pass
Bleach immersion	435% / 3.21 MPa — pass	—
Detergent immersion	601% / 3.84 MPa — pass	781% / 2.88 MPa — pass
Heat ageing	341% / 4.41 MPa — pass	504% / 3.78 MPa — pass
Cyclic movement	Pass — 50 cycles at 4 mm, nil crazing, tears or rupture	Pass — failure not observed

Values with report citations are accredited test results. * Typical Forspec R&D characteristic values on standard production material at 25°C and 50% relative humidity — not to be relied upon for engineering design without written confirmation from FORSPEC Technical Services.

Consumption

Approximately 1.4 L/m² total (≈ 1.9 kg/m²) for the certified two-coat, 1.2 mm DFT system — two coats at approximately 0.7 mm wet film each. Basis: at 90% solids, 0.7 mm WFT dries to approximately 0.63 mm DFT per coat — the certified build reconciles. Planter boxes: minimum 1.5 mm total DFT — two coats at approximately 0.85 mm wet film each, approximately 1.7 L/m² total (≈ 2.3 kg/m²). Consumption rises with substrate profile, porosity and detailing.

Coverage and Yield

PACK SIZE	COVERAGE
15 L (20 kg) pail — 1.2 mm total DFT	Approx. 10 m²
15 L (20 kg) pail — planter boxes, 1.5 mm total DFT	Approx. 8.5 m²

Check: 15 L ÷ 1.4 L/m² = 10.7 m² — the coverage and consumption figures reconcile. The specified total DFT controls acceptance, not theoretical coverage.

Limitations

- Not suitable for exposure to sunlight or UV — the membrane must be protected or covered immediately after full cure. Pedestal systems that leave the membrane fully exposed to UV require an ACTFLEX ATC or ACTFLEX ULTRA TC topcoat before pedestal installation.
- Direct adhesion of tiling to the cured membrane is not recommended — tiling is always to the screed per AS 3958.1.
- Allow full cure — a minimum of 48 hours at 25°C, 50% RH — before tiling, backfilling, topping or immersion.
- Maintenance foot traffic only in uncovered internal areas such as plant rooms — not designed for daily traffic, piercing footwear or machinery.
- Root resistance is limited to non-aggressive root systems (small garden trees, hedges, shrubs) — not for aggressive or invasive species.
- Not compatible with all silicone-based and bituminous surfaces and products — confirm compatibility first.
- Not for constantly submerged applications (pools, ponds) or chlorine environments.
- Not a vapour barrier — not designed to withstand negative-side hydrostatic pressure.
- Apply only to dry substrates free from dampness; do not apply if rain threatens.
- Movement joints may exceed the membrane's capability — detail with the approved flexible joint and bond-breaker method; never bridge active joints.
- Apply only between 10–26°C (ambient and substrate); do not apply below 10°C surface temperature.
- Do not dilute — dilution with xylene or any solvent is prohibited unless expressly authorised in writing by an authorised FORSPEC representative.
- Spray application is not approved — roller and brush only.

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Surface Preparation

- Substrates must be structurally sound, clean, dry, and free of laitance, dust, oils, grease, curing compounds, release agents, coatings, rust, efflorescence and loose material. Application constitutes acceptance of the substrate.
- Concrete: cured a minimum of 28 days with a wood-trowel finish. Renders and screeds: cured a minimum of 7 days, wood-trowel finish.
- Repairs: reinstate damaged concrete with the FORSPEC concrete repair system such as FORBUILD 100 or FORCRETE 100, cured before priming.
- Approved substrates: prepared concrete, renders and screeds, wet-area-grade fibre cement wall sheeting (minimum 6 mm), compressed fibre cement (minimum 15 mm), brickwork, blockwork, masonry, and primed metal surfaces. Never particleboard, platform flooring, yellow-tongue or chipboard — replace with wet-area-grade compressed fibre cement.
- Falls — internal wet areas: minimum 1:80 to the floor waste, maximum 1:50, per AS 3740:2021 and NCC Housing Provisions 10.2.12. External areas: minimum 1:100 per the project design and AS 4654.2.
- Remove high points and protrusions that could pierce the membrane.

Priming

- ACTFLEX EP250 — epoxy primer for prepared concrete and porous cementitious substrates: one coat as a primer on sound, dry substrates; two coats where specified for moisture control. The certified bond system — Report 0242-7 tested ACTFLEX 929 HV over EP250-primed concrete.
- ACTFLEX MB200 — epoxy moisture-barrier primer: one coat as a primer; two coats as a moisture barrier where elevated substrate moisture is identified, per its TDS.
- ACTFLEX 700 PU PRIMER — fast-drying polyurethane primer for porous substrates. Not a moisture barrier.
- Prepare, mix and apply the selected primer strictly per its current TDS, achieve complete even coverage without pooling, and apply the membrane within the primer's overcoat window. Confirm the primer selection with FORSPEC Technical Services where the substrate condition is unusual.

Crack Treatment

Identify whether each crack is non-moving or active before treatment. Static cracks under 2 mm: repair with the approved FORSPEC crack-repair method, then centre ACTFLEX SA TAPE over the crack, free of bubbles and wrinkles, ends overlapped a minimum of 50 mm, fully encapsulated within the membrane system. Static cracks 2 mm and over, and sealed junctions: prepare and fill with ACTFLEX 75FC with the approved bond-breaker detail, cured to its membrane-ready condition before coating. Structural cracks: rectify with the FORSPEC epoxy crack repair range — PROBOND 1100, CRACK PRO 1200PS or CRACKLOCK E400L — per their TDS. Active cracks and movement joints are never bridged with continuous membrane.

Detailing — Junctions, Fillets and Penetrations

Form a continuous ACTFLEX 75FC fillet at wall/floor junctions, drains and penetrations before membrane application — nominal 12 mm internally, 15 mm x 15 mm externally — tooled smooth and cured to membrane-ready per its TDS. Where reinforcement is specified at junctions and floor joints, embed ACTFLEX SA TAPE or the specified FORSPEC reinforcement tape centrally into the wet first coat, free of creases and air pockets, overlapped a minimum of 50 mm at ends, and encapsulate fully with the subsequent coats. Seal penetrations with the primer, sealant, reinforcement and membrane detail together — tape alone is never a complete penetration detail. Probe and inspect every detail before the following coats.

Mixing

- Stir gently at low speed to a uniform consistency before use — avoid whipping air into the material.
- Moisture-cured product: keep the pail sealed except when drawing material, and use opened pails promptly.
- Do not dilute — xylene and all solvents are prohibited as diluents.

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Application and Film Build

- **Membrane coats**
  Apply by roller or brush in a minimum of two complete, uniform coats at approximately 0.7 mm wet film per coat, to achieve the minimum 1.2 mm total dry film thickness — never exceed 1.5 mm wet film in any single coat. Apply each subsequent coat at approximately right angles to the preceding coat. Recoat after 4–6 hours at 25°C, 50% RH in well-ventilated conditions, once the preceding coat is tack-free — and within a maximum of 24 hours; where the window is exceeded, contact FORSPEC Technical Services for the inter-coat preparation. Checks: WFT verified per coat with a wet film gauge; no misses, pinholes or ponded material; details fully encapsulated.

  Planter boxes: apply a minimum of two coats at approximately 0.85 mm wet film per coat (approximately 0.77 mm dry film each) to achieve a minimum 1.5 mm total dry film thickness — approximately 1.7 L/m² total. The 1.5 mm maximum wet film per coat still applies. Cure is slower at the heavier build: confirm full cure before flood testing, drainage protection or backfill.

Application rates

APPLICATION	TOTAL DFT	COATS	WFT PER COAT	RECOAT (AT 25°C, 50% RH, WELL VENTILATED)	FULL CURE (AT 25°C, 50% RH)
Wall applications	Minimum 1.2 mm	Minimum 2	Approx. 0.7 mm	4–6 hours — max 24 hours	48 hours after final coat
Floor applications	Minimum 1.2 mm	Minimum 2	Approx. 0.7 mm	4–6 hours — max 24 hours	48 hours after final coat
Planter boxes	Minimum 1.5 mm	Minimum 2	Approx. 0.85 mm	4–6 hours — max 24 hours	Minimum 48 hours after final coat — confirm full cure

- **Conditions and protection**
  Apply only when ambient and substrate temperatures are between 10°C and 26°C, in ventilated conditions, and never when rain, condensation or water exposure is expected before cure. Moisture-cure rates slow in dry air and at low temperatures. Protect the membrane from water, contamination, sharp objects and traffic throughout curing, and cover or protect from UV immediately after full cure — 48 hours at 25°C, 50% RH.

Check wet film with a gauge during application of every coat. Never exceed 1.5 mm WFT in a single pass on this moisture-cured polyurethane.

PARAMETER	COAT 1	COAT 2	TOTAL SYSTEM
Wet film thickness (WFT)	Approx. 0.7 mm	Approx. 0.7 mm	Approx. 1.4 mm
Dry film thickness (DFT)	Approx. 0.6 mm	Approx. 0.6 mm	1.2 mm minimum
Consumption	Approx. 0.7 L/m²	Approx. 0.7 L/m²	Approx. 1.4 L/m²
Recoat window (at 25°C, 50% RH)	4–6 hours — maximum 24 hours		

Drying, Curing and Testing Times

All times below are measured at 25°C and 50% RH and run from completion of the stated coat. Program each stage as a hold point — no stage may commence before the preceding stage is complete.

STAGE (AT 25°C, 50% RH, WELL VENTILATED, 1.2 MM DFT)	TIME
Tack-free	6 hours
Recoat — minimum	4 hours
Recoat — maximum	24 hours
Full cure	48 hours after the final coat
Screeds and mortar beds	From 48 hours after the final coat
Flood testing	After full cure — 24-hour test duration
Tiling, backfilling, topping or immersion	After full cure — minimum 48 hours

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Flood Testing

Flood test only after full cure — a minimum of 48 hours at 25°C, 50% RH — and after confirming every membrane area and detail is completely dry and undamaged. Plug all drains and outlets, flood to a minimum depth of 50 mm at the highest point and retain for 24 hours, inspecting for leakage. Release, dry, rectify any defect and re-test before covering. Conduct testing per the project specification, AS 3740 internally and AS 4654.2 externally.

Screeds, Tiling and Pedestal Systems

Screeds over cured ACTFLEX 929 HV are unbonded: a 200-micron polyethylene slip sheet is always installed between the membrane and the screed, with a minimum screed thickness of 40 mm per AS 3958.1 — or 35 mm minimum using FORSPEC SCREEDX engineered screed per its TDS; below 35 mm requires written FORSPEC approval with the enhanced mix. Tiling is always to the screed in accordance with AS 3958.1 — never direct to the membrane. Allow 48 hours full cure before screeding, tiling, backfilling, topping or immersion. Pedestal paver systems are installed over the fully cured membrane with the specified protection and load-distribution layers; where the pedestal system leaves the membrane fully exposed to UV, topcoat with ACTFLEX ATC or ACTFLEX ULTRA TC before pedestal installation.

Clean Up

Clean tools and equipment immediately after use with a suitable solvent per the SDS, before the product cures — cured ACTFLEX 929 HV can only be removed mechanically. Handle solvents per their own SDS. Do not discharge product, solvents or wash residues into drains, sewers, soil or waterways.

Container and Waste Disposal

Allow residues to fully cure before disposal in accordance with the relevant State or Territory legislation and local council requirements. Do not seal or stopper drums being decontaminated — the moisture-curing reaction generates CO_2 gas and may pressurise sealed containers. Dispose of contents and containers to an authorised hazardous or special waste collection point per the SDS. Refer to Section 13 of the SDS for detailed requirements.

Quality Records

Record the batch numbers of all ACTFLEX 929 HV, primers, sealants and tapes used, substrate moisture and preparation records, primer system applied, application dates and conditions, wet film thickness measurements per coat, detail inspections and flood test results, as part of the project quality assurance records. The specified total DFT — 1.2 mm minimum, or 1.5 mm minimum for planter boxes — is the acceptance criterion and must be verifiable from the records.

Storage

Store sealed in original, unopened containers in a cool, dry, well-ventilated place between 5°C and 25°C, away from heat, sparks, open flames and all ignition sources — the product is a combustible liquid regulated for storage. Keep containers tightly closed; the product cures on atmospheric moisture and opened containers must be used promptly. Shelf life: 12 months from the date of manufacture when stored as specified.

Safety Precautions and First Aid

ACTFLEX 929 HV is classified as a HAZARDOUS CHEMICAL (non-dangerous goods) and a COMBUSTIBLE LIQUID regulated for storage under its current Safety Data Sheet (Chemwatch 7954-30). It causes skin irritation and serious eye damage, may cause an allergic skin reaction, may cause allergy or asthma symptoms or breathing difficulties if inhaled, may cause respiratory irritation, is suspected of causing cancer and of damaging fertility or the unborn child, and is toxic to aquatic life. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources — no smoking. Use only in well-ventilated areas; avoid breathing mist, vapour or spray; wear protective gloves, protective clothing, and eye and face protection; wear respiratory protection where ventilation is inadequate. Persons with a history of respiratory sensitisation must not be exposed. Contaminated work clothing must not leave the workplace. Prevent release to the environment.

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Safety Precautions and First Aid (continued)

First aid — Eyes: rinse cautiously with water for several minutes; remove contact lenses if easy to do; continue rinsing and seek immediate medical attention. Skin: wash with plenty of soap and water; if irritation or rash occurs, get medical advice; wash contaminated clothing before reuse. Inhaled: remove the person to fresh air and keep comfortable; if experiencing respiratory symptoms, call a doctor immediately. Swallowed: do not induce vomiting; seek medical advice. 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 929 HV 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.

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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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