

Technical Bulletin # 440A

## Product Description

An easily mixed, two-component epoxy paste developed for maximum productivity when filling in bug holes, anchor bolt holes, and pinholes. It can also be used as a skim coat for mildly spalled areas. It is specifically used for sealing, smoothing and fairing applications on concrete, metals, plastics (FRP), wood or masonry.

- Easily mixed with a drill and mixing blade
- 100% solids, solvent-free product
- Excellent workability
- Creamy paste consistency
- Natural unpigmented color

## Surface Preparation

**New Concrete:** All surfaces must be firm, free of any laitance or efflorescence, clean, free of any adverse moisture conditions, have an appropriate surface profile, and be well cured before coating. Newly poured concrete must age at least 30 days at temperatures over 70°F before coating. Form release agents, sealers, curing compounds, salts, hardeners and other foreign matter will interfere with adhesion and must be removed. Shot-blasting, mechanical scarification, suitable chemical means, or sandblasting should be employed to prepare substrate.

**Old Concrete:** Patching older, uncoated concrete floors is done in much the same manner as new concrete. Before preparation, the concrete surface must be thoroughly cleaned with a strong detergent cleaner to remove all grease, oils, etc. All loose concrete must be removed. If surface deterioration presents an unacceptably rough floor, IMPAX 5020 Floor Resurfacer is recommended to patch and resurface damaged concrete.

**Steel:** All surfaces must be dry, clean and free of all previous coatings, rust and surface contamination. Minimum surface preparation is abrasive blast to Commercial Grade SP-6. Blasted surfaces must be coated within 8 hrs. Prior to blast cleaning, remove all deposits of oil or grease using Solvent Clean method SP-1.

**Wood:** A clean, sound wood surface is required. Remove any oils and dirt from the surface, using degreasing solvent or strong detergent. Follow with sanding to remove loose or deteriorated surface wood and to obtain the proper surface profile. Consult ITW Resin Technologies Technical Department for specific recommendations.

**Previously Painted Surfaces:** If the paint is peeling or degrading in any way, it should be completely removed by sanding, blasting or stripping. If previous paint coating is completely intact, the surface may be cleaned with a strong detergent or solvent and scuff sanded to remove the gloss. A spot test should be made by applying a small amount of patching over old paint. The old finish may wrinkle or lift within 60 minutes. If it does not, wait 5 days and test for adhesion and compatibility. If the old finish fails, it must be removed or an appropriate barrier coat should be considered.

(For more detailed information, see Bulletin #400B)

## Mixing and Application Instructions

After surface has been prepared, mix 1 part resin to 1 part hardener, mix thoroughly until a uniform streak-free cream color is achieved. Mix material with putty knife or with drill and appropriate jiffy mixing blade. Do not reduce this material. Do not scrape or drain mixing containers.

Apply material using putty knife or spatula, removing all excess material. To achieve an exceptionally smooth finish, material may be smoothed by hand using a small amount of water sprinkled onto the surface (use rubber gloves). If desired, the product may be sanded after 8 hrs. @ 72°F.

**PRECAUTION:** Keep away from heat and open flame. Maintain good ventilation and avoid breathing vapors. Avoid prolonged or repeated skin contact. Wash thoroughly after handling. Take proper precautions against overexposure to the dust that may be generated from sanding or machining cured material.

## Technical Information

COLOR:	Cream
GLOSS:	Flat
VOLUME SOLIDS:	100%
VOC:	0 lbs./gal. (0 g/L) (Based on mixed components)
COVERAGE:	Approx. 231 cubic in./gal.
PACKAGING:	1 gal. unit consists of 1/2 gal. can of resin and 1/2 gal. can of hardener (3.78 liters unit vol.)
APPLICATION TEMPERATURES:	55° minimum to 100°F maximum (13° C min to 38° C max) *Must be 5°F above dew point
RELATIVE HUMIDITY:	85% maximum
SERVICEABILITY:	Recoat/Sand – 6-10 hrs. min. @ 72°F @ 50% RH Full Cure — 24 hrs. @ 72°F @ 50% RH
MIXING RATIO:	1:1 equal parts resin/hardener by volume
POT LIFE:	30 min. @ 72°F
FLASH POINT:	200°+F PMCC
VISCOSITY:	Paste 80,000 cps
CLEAN UP:	IMPAX IXT 59 Solvent
SHELF LIFE:	24 months in closed container stored @ 50° to 90°F (10° to 32°C)
SERVICE TEMPERATURE:	150°F (66°C) Dry Heat Resistance

**Date** 07/2006

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