

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

General: Every reasonable effort is made to insure the technical information and recommendations on these data pages are true and accurate to the best of our knowledge at the date of issuance. However, this information is subject to change without notice. Prior versions of this publication are invalid with the release of this version. Products and information are intended for use by qualified applicators that have the required background, technical knowledge, and equipment to perform said tasks in a satisfactory manner. Consult your local distributor for product availability, additional product information, and technical support.

Warranty: ITW Polymer Technologies, a division of Illinois Tool Works Inc., warrants that its products meet their printed specifications. This is the sole warranty. This warranty expires one year after product shipment.

Warranty Claims: If any product fails to meet the above, ITW Polymer Technologies will, at its option, either replace the product or refund the purchase price. ITW Polymer Technologies will have no other liability for breach of warranty, negligence, or otherwise. All warranty claims must be made in writing within one year of the date of shipment. No other claims will be considered.

Disclaimer: ITW Polymer Technologies makes no other warranty, expressed or implied, and specifically disclaims any warranty of merchantability or fitness for a particular purpose.

Suggestions concerning the use of products are not warranties. The purchaser assumes the responsibility for determining suitability of products and appropriate use. ITW Polymer Technologies' sole liability, for breach of warranty, negligence or otherwise, shall be the replacement of product or refund of the purchase price, at ITW Polymer Technologies' election. Under no circumstances shall ITW Polymer Technologies be liable for any indirect, incidental or consequential damages.

Modification of Warranty: No distributor or sales representative has the authority to change the above provisions. No change in the above provisions will be valid unless in writing and signed by an officer or the Technical Director of ITW Polymer Technologies. No term of any purchase order shall serve to modify any provision of this document.

Mediation and Arbitration: If any dispute arises relating to products or product warranties, either the purchaser or ITW Polymer Technologies may a) initiate mediation under the then current Center for Public Resources (CPR) Model Procedure for Mediation of Business Disputes, or b) initiate a non-binding arbitration under the rules of the American Arbitration Association for the resolution of commercial disputes.