

IMPAX 650RC/SL Self-Leveling Epoxy Coating

Technical Bulletin #1009B

PRODUCT DESCRIPTION: A two component, 100% solids, recoatable self-leveling floor coating. It is a high performance floor system that provides a high gloss, seamless, hygienic surface that is extremely hard wearing and durable. It is available in five colors and meets OSHA and State VOC regulations. It also meets USDA standards for maintenance protective coatings not in direct contact with food in federally inspected meat and poultry plants. The coating can also be applied to provide a nonslip texture.

RECOMMENDED USES: IMPAX 650RC/SL is especially suited for clean rooms, aircraft hangers, laboratories, workshops and light assembly areas where additional topcoats are deemed necessary. This product can be applied at recommended thicknesses of 6 to 30 mils WFT/DFT. For higher film builds, IMPAX 650RC/HB should be considered.

SURFACE PREPARATION: (For more detailed information, see Bulletin #994)

New Concrete. All surfaces must be firm, clean and well cured before coating. Newly poured concrete must age at least 30 days at temperatures over 70°F before coating. Form release agents, curing compounds, salts, hardeners and other foreign matter will interfere with adhesion and must be removed by sandblasting, shotblasting, mechanical scarification or suitable chemical means. If a curing membrane was not used, then proceed with a 16% muriatic acid etch (1 gal. 32% muriatic acid to 1 gal. water) at a rate of 75-sq. ft./gal.

Old Concrete. Coating older, uncoated concrete floors is done in much the same manner as new concrete. Before etching, the concrete surface must be thoroughly cleaned with a strong detergent cleaner to remove all grease, oils, etc. All loose concrete must be removed. Form release agents, hardeners, etc. must be removed using same procedure as for new concrete. Holes and cracks should be filled with IMPAX Crack Filler before application of a coating. If surface deterioration presents an unacceptably rough floor, IMPAX 5020 Floor Resurfacer is recommended to patch and resurface damaged concrete.

Steel. Consult ITW Philadelphia Resins' Technical Department.

Wood. Consult ITW Philadelphia Resins' Technical Department.

Previously Painted Surfaces. If the paint is peeling or degrading in any way, it should be completely removed by sanding, blasting or stripping. If the previous 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 coating over old paint. The old finish may wrinkle or lift within 60 minutes. If it does not, wait 5 days and test for adhesion. Do this by cutting an "X" into the coating, place tape firmly over the cut, then strip with a hard, fast pull. If the old finish fails, it must be removed.

RECOMMENDED SYSTEMS:

Concrete Floors:

1st coat: IMPAX 3300LV (Clear) Primer* or IMPAX 33 Primer
2nd coat: IMPAX 650RC/SL
3rd coat: IMPAX 650RC/SL or other IMPAX products. Consult ITW Philadelphia Resins' Technical Department.

IMPAX 3300LV Primer must be used with clear finish coats.

Painted Surfaces in Sound Condition:

1st coat: IMPAX 650RC/SL
2nd coat: IMPAX 650RC/SL or other IMPAX products. Consult ITW Philadelphia Resins Technical Department.

IMPORTANT

When recoating IMPAX 650RC/SL, it must be done no **less** than 8 hours after application of the previous coat and no **more** than 72 hours at 72°F (22°C) @ 50% RH. If this "window" has passed, the surface of the cured IMPAX 650RC/SL must be abraded to insure adhesion of subsequent coats.

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When coating previously painted surfaces, always apply test patch and examine for lifting and proper intercoat adhesion. If lifting occurs, remove old coating or apply an appropriate barrier coat.

MIXING AND APPLICATION INSTRUCTIONS: To mix 1 gallon units: Use electric or air mixer (approximately 250 rpm) with metal mixing blade (Jiffy Model HS or equal). Premix resin for 1/2 minute then pour hardener contents into slack-filled resin can. Mix for 2 to 3 minutes moving blade around can while mixing. Avoid whipping air into material. To mix 5-gallon units, use same procedure, as mixing 1-gallon units except a larger blade (Jiffy Model ES or equal) is required. With material freshly mixed, working out of a paint pan or bucket, roll material on floor to desired thickness with a 3/8" nap soft woven roller or equivalent. Check film thickness frequently. After 20 to 30 minutes set up time, material should be rolled with a spiked roller to remove any entrapped air. Do not spike roll after 40 minutes.

If a nonskid texture is desired, broadcast a clean, dry 30 to 50 mesh silica sand into the IMPAX 33 Primer immediately after application. Broadcast sand until the primer is saturated and only dry sand is showing. After the primer has set (6 hours minimum), sweep excess sand off the surface. Then topcoat with 10-20 mils of IMPAX 650RC/SL. Lower topcoat thickness will produce more pronounced nonskid profile, heavier topcoats will produce smoother profiles. Spike rolling is not necessary when IMPAX 650RC/SL is applied as a nonskid.

TECHNICAL INFORMATION:

COLORS:	Haze Gray, Deck Gray, Sandstone, Tile Red, White
GLOSS:	Full Gloss
VOLUME SOLIDS:	100%
VOC:	0 lbs./gal. (0 gms. /ltr.) (Based on Mixed Components)
COVERAGE:	160 sq.ft. /gal. @ 10 mils DFT/WFT (15 m ² /gal. @ 254 mm DFT/WFT)
PACKAGING:	1 gal. unit containing 1 gal. slack filled resin can, 1/2 gal. slack filled hardener can (3.7 liters unit volume) 5 gal. unit containing 5 gal. slack-filled resin can, 1-1/2 gal. hardener jug (18 liters unit volume)
APPLICATION TEMPERATURES:	55°F minimum to 100°F maximum (12°C minimum to 35°C maximum) *Must be 5°F above dew point
RELATIVE HUMIDITY:	85% maximum
SERVICEABILITY:	Recoat 8 hrs. minimum, 72 hrs. maximum @ 72°F (22°C) @ 50% RH Foot Traffic 24 hrs. maximum @ 72°F (22°C) @ 50% RH Heavy Service 72 hrs. @ 72°F (22°C) @ 50% RH Full Cure 5 days @ 72°F (22°C) @ 50% RH
MIXING RATIO:	Approximately 2.1 to 1 parts resin/hardener by volume (depending on color)
INDUCTION:	None
POT LIFE:	40 minutes @ 72°F (22°C)
FLASH POINT:	200°F (93°C)
VISCOSITY:	2,700 cps (mixed colors); 600-800 cps (clear)
REDUCER:	NOT RECOMMENDED
SERVICE TEMPERATURE:	-10°F to 120°F (-23°C to 49°C)
SHELF LIFE:	18 months in closed container stored @ 50°F to 90°F (10°C to 32°C)
PRECAUTION:	Maintain good ventilation and avoid breathing vapors. Avoid prolonged and repeated skin contact. Wear safety glasses and impervious gloves.