IMPAX ® 33 Primer

Technical Bulletin 812E

PRODUCT DESCRIPTION: A low viscosity, 100% solids, high build, fast cure epoxy primer designed for use under IMPAX 650SL and IMPAX 650HB or where a high build primer is needed. This primer/seal coat enhances adhesion by penetrating into the concrete substrate and helps reduce bubbling and pinholes that may occur when coating porous surfaces with high build coatings. IMPAX 33 meets OSHA, State VOC regulations and USDA standards for maintenance protective coatings not in direct contact with food in federally inspected meat and poultry plants.

RECOMMENDED USES: IMPAX 33 is intended as a high build primer for use on open or porous substrates where it is necessary to cover a rough surface profile with a pigmented topcoat. Concrete substrates that are scarified, shotblasted or sandblasted may have a coarse profile requiring a primer that both penetrates and seals the surface.

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

New Concrete: All surfaces must be firm, clean, dry 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 ITW REPAIR COMPOUND 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.

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.

MIXING & APPLICATION INSTRUCTIONS: Before mixing IMPAX 33 it is important that the surface is completely prepared and ready and that all tools and equipment are handy. To mix 1 gallon units: Use electric or air mixer (approximately 250 rpm) with metal mixing blade (Jiffy Model HS or equal). Pour hardener contents into slack-filled resin can and mix for 2 to 3 minutes until material is thoroughly blended. To mix 5 gallon units: Use same procedure as 1 gallon units except a larger blade (Jiffy Model ES or equal) is required.

Immediately pour a substantial portion of mixture onto the floor and spread material using a flat, rubber squeegee using sufficient pressure to work the primer into the porous surface. Immediately backroll the material with a quality 3/8" nap roller leaving 6 to 10 mils on the surface.

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The fast set primer can be topcoated in 6 hours at 72°F (22°C). The primer must be tack free before topcoating. If pinholes or porosities are evident after initial cure of the primer, repriming may be necessary; especially on very porous concrete.

TECHNICAL INFORMATION

COLOR:	Light Gray
GLOSS:	Satin Sheen
VOLUME SOLIDS:	100%
VOC:	0 lbs./gal. (0 gms./ltr.) (Based on mixed components)
COVERAGE:	200 sq. ft./gal. @ 8 mils DFT/WFT (4.9 m^2/liter @ 200 microns WFT/DFT)
PACKAGING:	1 gal. unit containing 1 gal. can (slack-filled) resin, ½gal. Can (slack filled) hardener (3.7 liters unit volume) 5 gal. unit containing 5 gal. can (slack-filled) resin, 1½gal. plastic jug hardener (18 liters unit volume)
APPLICATION TEMPERATURES:	55°F minimum to 95°F maximum (12°C minimum to 35°C maximum) *Must be 5°F above dew point
RELATIVE HUMIDITY:	85% maximum
SERVICEABILITY:	Recoat – 6 Hours minimum @ 72°F (22°C) @ 50% RH 24 Hours maximum @ 72°F (22°C) @ 50% RH
MIXING RATIO:	2.2 to 1 parts epoxy resin/hardener by volume
INDUCTION:	None
POT LIFE:	30 Minutes @ 72°F (22°C)
FLASH POINT:	200°+F (93°+C)
VISCOSITY:	800 cps
REDUCER:	Not recommended
SERVICE TEMPERATURE:	180°F (82°C) Dry Heat Resistance
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.