

## Epoxy Concrete Primer

**PRODUCT DESCRIPTION** Interbuild 1004 Primer/Saturant is a low viscosity, epoxy compound based on a unique adduct curing technology. This provides tolerance of surface moisture at temperatures down to 2°C (32°F) and the ability to cure in the presence of moisture.

**INTENDED USES** Designed for a wide range of floors with various levels of mechanical and chemical exposure. A primer for all Interbuild products, it is designed for use with the traffic deck system for heavy duty traffic, areas such as ramps, car parks, parking bays, pedestrian walkways, roof decks and industrial floors. Recommended for cold stores, laboratories, hospitals, food and beverage plants, kitchens, high tech manufacturing facilities, dairies, warehouses, factories and hangars.

### PRACTICAL INFORMATION FOR INTERBUILD 1004

<b>Colour</b>	Clear			
<b>Gloss Level</b>	Not applicable			
<b>Volume Solids</b>	85%			
<b>Typical Thickness</b>	40-100 microns (1.6-4 mils) dry equivalent to 47-118 microns (1.9-4.7 mils) wet			
<b>Theoretical Coverage</b>	11.33 m <sup>2</sup> /litre at 75 microns d.f.t and stated volume solids 454 sq.ft/US gallon at 3 mils d.f.t and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Airless Spray,Brush,Roller			
<b>Drying Time</b>	Overcoating Interval with recommended topcoats			
<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	16 hours	30 hours	9 hours	4 weeks
20°C (68°F)	8 hours	24 hours	5 hours	4 weeks
35°C (95°F)	3 hours	8 hours	3 hours	2 weeks

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 42°C (108°F); Part B 109°C (228°F)		
<b>Product Weight</b>	1.08 kg/l (9.0 lb/gal)		
<b>VOC</b>	1.50 lb/gal (180 g/lit)	EPA Method 24	
	112 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)	

See Product Characteristics section for further details

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### SURFACE PREPARATION

#### Concrete and Masonry

Concrete should have a minimum strength of 20MPa. All surfaces should be clean and free from laitance, curing compounds, release agents, efflorescence, grease, oil, dirt, organic growth, old coatings and loose or disintegrating concrete. Smooth surfaces should be roughened, using high pressure water jetting or similar techniques.

Laitance deposits are best removed by planetary diamond disc grinder or by captive blasting followed by vacuum cleaning to remove dust debris. For old concrete, a site visit by the local AkzoNobel technical representative should be undertaken to assess the condition and provide an appropriate surface preparation method.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.	
	(1) Agitate Base (Part A) with a power agitator.	
	(2) Agitate Curing Agent (Part B) with a power agitator.	
	(3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.	
<b>Mix Ratio</b>	3 part(s) : 1 part(s) by volume	
<b>Working Pot Life</b>	20°C (68°F) 45 minutes	
<b>Airless Spray</b>	Recommended	Tip Range 0.45-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2503 p.s.i.)
<b>Brush</b>	Recommended	Use a stiff nylon brush.
<b>Roller</b>	Recommended	Use a short nap roller.
<b>Thinner</b>	DO NOT THIN	
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.	
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA822. It is good working practice to periodically clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, temperature and elapsed time, including any delays.	
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

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### PRODUCT CHARACTERISTICS

The detailed Interbuild 1004 Application Guidelines should be consulted prior to use.

The Interbuild 1004 application shall be conducted by the Applicator Company using employees trained in the appropriate application procedures. It is strongly advised that both application and application supervision is only carried out by professional personnel who have been trained in the correct use of the products.

The exact specification with regards to dry film thickness and number of coats will be provided by International Protective Coatings prior to application start up.

For all application steps, the surface temperature, air temperature and material temperature should be between 10°C (50°F) and 43°C (110°F).

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitence.

Consult International Protective Coatings for temperature limits for specific end use requirements.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

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### SYSTEMS COMPATIBILITY

Interbuild 1004 will normally be applied to correctly prepared concrete substrates.

The following topcoats are recommended for Interbuild 1004:

- Interbuild 1071
- Interbuild 1072
- Interbuild 1091
- Interbuild 1094

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### ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at [www.international-pc.com](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

### SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations. All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety and Environmental standards, regulations and legislation.

Proper ventilation must be provided during application and afterwards during drying (Refer to product datasheets for typical drying times) to keep solvent concentrations within safe limits and prevent fires and explosions. Forced extraction will be required in confined spaces. Ventilation and/or respiratory personal protective equipment (airfed hoods or appropriate cartridge masks) must be provided during application and drying. Take precautions to avoid skin and eye contact (overalls, gloves, goggles, masks, barrier cream, etc).

Before use, obtain, read and then follow the advice given on the Material Safety Data Sheets (Parts A and B if two-pack) and the Health and Safety section of the Coatings Applications Procedures for this product.

In the event that welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

The detailed safety measures are dependent on application methods and the work environment. If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product and consult International Protective Coatings.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	15 litre	20 litre	5 litre	5 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	4 US gal	32 lb	8.8 lb

STORAGE	Shelf Life	
		18 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

### Important Note

*The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.*

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