

FLEXI-BOND 540

100% Solids Epoxy Bonding Agent & Primer

DESCRIPTION:

FLEXI-BOND 540 is a 2-component, 100% solids, moisture-insensitive, odorless epoxy bonding agent and primer. Application of **FLEXI-BOND 540** to damp, wet or dry substrates assures tenacious adhesion of new toppings, patching compounds, and bedding mortars, when used in accordance with instructions. It may be applied to concrete, steel, wood, ceramic tiles or fiberglass.

SUGGESTED USES:

- As a **combination waterproof barrier and bonding agent**, when applying new concrete toppings over old concrete
- To **improve adhesion of tile bedding mortars** to existing concrete, or for direct use as a tile bedding adhesive, in combination with fine sand filler
- To **prime and waterproof steel reinforcement** prior to application of patching compounds or pouring of concrete, while improving adhesion of these materials
- To **penetrate and consolidate low-strength concrete** decks and floors, including high water-cement ratio concrete, cinder concrete, asbestos-cement compositions, and to improve adhesion of new toppings or patching compounds to same.
- To **promote adhesion** of concrete, bedding mortars or toppings to non-cementitious substrates, such as ceramic tile, plywood or steel plate.

TECHNICAL DATA:

PROPERTY	VALUE
Composition	Modified Epoxy with Adhesion-Promoting Additives
Viscosity	Approx. 450-700 cps
Mix Ratio	3:1 by volume
Pot Life*	20-30 mins. At 70 ⁰ F
Tack-Free Time*	16-24 hrs., unaccelerated 8-12 hrs., accelerated
Bond Strength	>500 psi, (Cohesive Failure in substrate)
VOC	Essentially "Zero"

*Working and cure times are affected by temperature and mass. Reduced cure time, as shown, is based on addition of 5% **FLEXI-SPEED 599 Accelerator**.

APPLICATION:

1. Conditions & Surface Preparation.

a. Substrates must be above 45⁰F, and free from hydrostatic pressure, moisture vapor transmission, paint, curing compounds, oil, dirt or other materials which could hinder adhesion. For colder temperatures (39⁰F-55⁰F) a system with better low-temperature curing properties can be recommended by your Edison Technical Representative.

b. New concrete should be cured for 28 days (min.) and should be mechanically abraded to remove laitance prior to coating. Old concrete should be inspected for soundness and properly prepared prior to topping.

2. Application:

a. Mix resin and hardener at specified ratio for 3 minutes (3:1 by volume) and apply by brush, squeegee or roller as a primer 30 minutes to 4 hours before topping.

On **porous surfaces**, apply in such a manner that material briefly “floods” the surface, allowing good penetration. If material is completely absorbed into highly porous surfaces, apply a second coat before topping.

On smooth or dense surfaces, apply even, thin films. If material “ponds” on hard, non-porous surfaces, spread to an even, thin film using a roller or squeegee.

NOMINAL COVERAGE RATE IS 100 - 200 SQ. FT. / GALLON. Actual coverage rate will vary with porosity and texture of substrate.

b. If desired, more than 1 coat may be applied. For best results, apply second coat after first coat has set, but within 96 hours of initial application. After 96 hours, light sanding or solvent-wiping with may be required to achieve proper inter-coat adhesion.

c. **Topping:** New concrete or other cementitious toppings may be applied any time after **FLEXI-BOND 540** application, until the coating begins to lose its tackiness. (Typically within 8 - 12 hours of application, at room temperature, within 4 hours in warmer weather). If coating loses tack before topping, reapply per above instructions.

g. For greater gloss and color retention, chemical resistance, an alternate seal coat may be selected for application over the topping. Consult your Edison Technical Representative.

3. Application Cautions:

Conditions affect handling characteristics of this system. Cool temperatures slow reaction and increase

epoxy viscosity, making application more difficult. Store materials for 24 hours before use at 70⁰F, if possible. Warm temperatures accelerate cure and reduce pot life. Blend only as much material as will be used prior to gel time at your particular working temperature.

4. Limitations

Do not apply at temperatures below 45⁰F, or when temperatures of topping, air or substrate will fall below 45⁰F within 8 hours of application. Do not apply against hydrostatic pressure, such as to foundation walls and slabs on grade subject to hydrostatic pressure or high amounts of vapor drive from behind or beneath the slab. This product is not intended for negative-side waterproofing.

5. Safety & Handling:

Avoid skin and eye contact. Hardener is Corrosive Liquid. Resin may cause allergic reactions in sensitized individuals. Observe all warnings, procedures and guidelines contained in Material Safety Data Sheets for these products. Clean tools immediately after use using Xylene or Methyl Ethyl Ketone. Solvents are hazardous materials which must be handled in accordance with the safety guidelines as detailed in the solvent manufacturer’s Material Safety Data Sheets.

Rev. 12/03



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Rev. 12/03