

**1. DESCRIPTION**

**Impa Wet To Dry Epoxy Adhesive** is a two-component, solvent-free, polysulphide modified epoxy adhesive.

Bonding fresh (plastic) concrete to existing concrete, plaster to brickwork. Can be used to provide a damp-proof barrier within the concrete matrix. If applied onto reinforcing steel **Impa Wet To Dry Epoxy Adhesive** will cause no loss concrete/steel bond strength.

**2. PRODUCT FEATURES**

- May be used in structural situations
- Excellent bond to damp or dry surfaces.
- High ultimate tensile strengths
- Bonds to rock

**3. SURFACE PREPARATION**

The existing concrete surfaces must be clean and mechanically sound. They must be free of dust, laitance and any foreign matter as well as cracked or loose stone.

Maximum bond strength is only achieved if main aggregate of existing concrete is exposed. This may be done by scabbing, grinding, abrasive blasting or manual chipping. All cracked or loose aggregate must be removed.

In repairing spalls all loose and friable material must be broken away. If damage has exposed reinforcing, this should be undercut and hammered back into position, if so directed by the engineer. If exposed reinforcing has rusted badly it should be cleaned by abrasive blasting. The existing concrete surface should ideally be dry. **Impa Wet To Dry Epoxy Adhesive** will bond to green concrete. It will not, however, penetrate free water on the surface of any concrete.

**4. MIXING**

Stir well the contents of both containers individually and ideally use a can opener to remove the lip from both cans. Add the entire contents of the activator tin to the base material and stir with a flat paddle until an even, streak-free, grey mixture results. This takes at least 5 minutes.

If only a small quantity of material is required, pre-stir contents of each can using separate clean paddles.

**HIGH PERFORMANCE FINISHES  
IMPA WET TO DRY EPOXY ADHESIVE**

**TECHNICAL DATA**

<i>Product Code</i>	EP302 Base EP301 : Activator: Pale Translucent
<i>Pot Life</i>	25 min @ 23°C
<i>Colour</i>	Base: Grey-Black Activator: Pale Translucent
<i>Appearance</i>	Mixed, Blue-Grey
<i>Shelf life</i>	24 Months
<i>Packaging</i>	5L
<i>Flashpoint</i>	120°C
<i>S.G (weight)</i>	1.55– 1.63kg/l
<i>Solids per volume</i>	63-64%
<i>Solids per mass</i>	59– 60%
<i>Practical Spreading rate (depending on porosity)</i>	1.8-2.00m <sup>2</sup> /L per coat @ 120µm
<i>Recommended finishing coats.</i>	1 minimum
<b>DRYING TIME</b>	
<i>Touch dry time</i>	2-3 Hours at 23°C
<i>Recoating Time</i>	4-6 Hour s at 23°C
<i>Full Cure</i>	10- 14Days 60 MPA
<b>APPLICATION</b>	
<i>Roller &amp; Brush (Mohair preferred)</i>	Ready for use
<i>Mixing Ratio</i>	2 Base : 1 Activator by Volume
<i>Cleaning</i>	IMPA Epoxy Thinners
<i>Mixing</i>	IMPA Epoxy Thinners if needed

Remove 2 volumes of base and one volume of activator into a clean, separate container and mix together, to obtain an even grey colour. If the ambient temperature is between 10°C to 15°C pre-condition the unopened cans by standing them in the sun or in warm water until the temperature of the contents is approximately 20°C. This makes mixing and spreading much easier.

### 5. APPLICATION

- **Impa Wet to Dry Epoxy Adhesive** should be spread onto the surface as soon as possible after complete mixing. Apply the compound in a thin rough layer and only once the can is emptied should an attempt be made to spread to working thickness.
- **Impa Wet to Dry Epoxy Adhesive** is best spread by means of a stiff bristle brush such as a kitchen scrubbing brush. A paint brush with bristles shortened by 50% may also be used.

### 6. VIBRATION OF NEW CONCRETE

Once the plastic concrete has been placed it should be panned with a steel or wooden rod to force main aggregate into the adhesive layer. When this has been done, vibration may be commenced. The vibrator head must be kept away from the adhesive layer. Poker vibrators have been found to give better results than vibrators clamped onto the shuttering

### 7. CURING OF NEW CONCRETE

Care must taken to see that the new concrete is adequately cured as is required in good practice. This curing is particularly vital where thin concrete layers are involved and should be continued for at least 5-7 days.

### 8. PRECAUTION

In order to limit minor colour variations from batch to batch, it is advisable to use product from the same batch on large open areas. Batches may be factory blended on request.

- Application should be avoided in cold and moist weather conditions.
- **Do Not** apply the product at surface temperatures below 6°C (minimum of 2°C above dew point) and temperatures above 40°C
- **Do Not** apply if ambient temperature is less than 10°C or more than 40°C.
- **Do Not** apply if relative humidity temperature is less than 10°C or more than 85. °C
- Extremely cold conditions will make the drying time longer.
- Ensure that recommended mixing ratio is adhered to
- Discard any mixed material left over from the previous day
- **HARDENER** reacts readily with moisture. **Do not** expose to high humidity. Keep containers tightly sealed when not in use.
- **HARDENER** contains solvents – use suitable respirator, particularly during spray application of the mixed material.
- Take care with surface preparation
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#### Environmental Health & Safety Information

**DANGER! CONTAINS SULFAMIC ACID. CAN BURN EYES AND SKIN. SEVERELY HARMFUL IF SWALLOWED. HARMFUL IF INHALED. AVOID BREATHING IN DUST, MIST OR VAPORS. USE ONLY IN A WELL VENTILATED AREA. MAY CAUSE COUGHING, WHEEZING, THROAT IRRITATION, SHORTNESS OF BREATH, HEADACHE, NAUSEA OR VOMITING. DO NOT MIX CONTENTS WITH CHLORINE BLEACH OR ANY OTHER CLEANING PRODUCT OR DETERGENT. TO DO SO MAY EXPOSE YOU TO DANGEROUS GASES. MIX ONLY IN PLASTIC CONTAINERS.**

Wear protective clothing, eyegoggles and acid resistant rubber gloves and footwear. Avoid contact with eyes and skin. **FIRST AID: If Swallowed:** Do not induce vomiting. Have victim drink lots of milk or water if conscious. Get medical attention immediately! **Eye and Skin Contact:** Flush immediately with plenty of water for at least 15 minutes; spread eyelids and occasionally flush underneath them. **Get medical attention immediately!** Remove contaminated clothing and shoes immediately. Wash contaminated clothing before reuse. If experiencing Respiratory Discomfort (e.g., throat irritation, coughing, wheezing): Remove victim to fresh air. Get medical attention immediately!

**CAUTION: KEEP OUT OF REACH OF CHILDREN AND ANIMALS - DO NOT TAKE INTERNALLY.**

**Refer to Material Safety Data Sheet for additional health and safety information.**

**IN CASE OF FIRE:** Use foam, CO2, dry chemical, or water fog.

**SPILL –** Absorb with inert material and dispose of as specified under **Thinning/Clean-up**.

**DISCLAIMER**

*The technical information contained in this document are given in good faith and are meant to be used as a guideline by the specifier or user. Whilst we are confident about the quality of our products, we cannot accept any liability for the incorrect use or application of our products. Surface preparation forms an integral part of the scope of works and it is expected that the highest standards are maintained during surface preparation and application, to ensure that our products perform as intended. Always ensure to use the same product batch numbers, refrain from doing spot touch-ups and paint surfaces from corner to corner to prevent colour and sheen variance. As technology may change over time we reserve the right to change products to keep up with changes in raw materials or product trends without pre notice. Although we will always prevail to keep clients informed about changes to be made, but cannot bind ourself to such notes Please ensure the use of the latest Technical Data Sheet.*

**Please note:** that all our latest Product Data Sheets and Material Safety Data Sheets are available for viewing on our website at [www.impa.co.za](http://www.impa.co.za). All information listed is owned or used under licence of Impa Paints and its related companies. © 2010 Lurama 149 (Pty) Ltd. All rights is reserved.