

# Madewell® 927

## Penetrating Epoxy Primer/Sealer



### FEATURES/BENEFITS

STRENGTHENS POROUS SUBSTRATES	ADHESION TO DAMP SURFACES
EASY MIXING AND APPLICATION	SUPERIOR PENETRATION
100% SOLIDS	FAST SETTING

### PRODUCT DESCRIPTION

**M**ADEWELL® 927 is a two component penetrating epoxy primer and sealer for porous substrates such as wood, concrete, and other cementitious surfaces. MADEWELL 927 is 100% solids, thereby providing a safer working environment, and it has a very low viscosity which permits easy mixing, application and deep penetrating action into porous surfaces. MADEWELL 927 can be applied to damp surfaces; its unique chemistry permits rapid displacement of substrate moisture and excellent adhesion. In addition, the applied system increases the tensile, compressive and impact strengths of the substrate. It may be used in a variety of applications in the pulp and paper, chemical process, steel, metal finishing and refining industries. MADEWELL 927 is recommended as a concrete primer under many Madewell epoxy coating systems.

### PRODUCT DATA

#### COMPOSITION:

100% solids, two component epoxy.

#### COLOR:

Semitransparent (depends on thickness and porosity of substrate).

#### THICKNESS:

MADEWELL 927 is not designed to be a film building product. No more than 1 or 2 mils should remain on the surface after application.

#### COVERAGE:

Depends on the porosity of the substrate. Rates from 250 FT<sup>2</sup>/gallon on new, dense concrete to 150 FT<sup>2</sup>/gallon on old, porous concrete have been observed.

#### PACKAGING:

Normally stocked in 4.5 gallon two component kits. Larger and smaller kit sizes available on special order.

#### SURFACE PREPARATION:

Because MADEWELL 927 is used as a primer for a variety of topcoat materials and to seal and strengthen porous substrates, surface preparation requirements vary greatly. In general, surfaces should be free of all loose and foreign material and should be roughened slightly to open the concrete surface and provide a suitable anchor pattern.

*Concrete:* Prepare all surfaces by removing surface contaminants such as old coatings, adhesives, curing compounds, dirt, efflorescence, grease and similar substances. Surface contaminants must be removed by any effective combination of detergent scrubbing, pressure washing, high pressure water blasting, grinding and/or scarifying.

Concrete that has been contaminated with oils, sugars, resins or other contaminants which cannot be readily removed by the methods described above or by abrasive blasting may require additional surface preparation by chemical cleaning, steam cleaning or other surface treatment. Depending on the topcoat material and service environment, testing and evaluation of concrete for deficiencies, contaminants and/or the presence of a previously applied sealer prior to the application of Madewell 927 may be advisable. Such testing and evaluation should be performed by properly qualified persons or organizations.

Acid etching is not recommended for removal of surface contaminants prior to surface preparation or as a method of surface preparation.

Prepare all surfaces by shotblasting or abrasive blast cleaning to a minimum International Concrete Repair Institute Concrete Surface Profile #3 condition (ICRI CSP #3). Small areas (less than 5% of total surface area) may be prepared by surface grinding followed by needle scaling, scabbling or scarifying to a minimum ICRI CSP 3 condition. Abrasive blasting should produce a sound, slightly roughened surface free from laitance and contaminated or degraded concrete. Generally, a finer abrasive and a greater distance from the workpiece is employed than when abrasive blasting steel surfaces. It is important that the air supply and abrasive are free from harmful contaminants. All safety equipment and procedures required by the equipment manufacturer and OSHA should be followed carefully. Self-propelled, self-contained shot blasting equipment has been shown to produce good results on concrete floor surfaces.

When in doubt, adhesion should be checked by application of a test patch.

*Note:* MADEWELL 927 will bond to many damp porous surfaces, but it may not bond to surfaces which are thoroughly saturated or have water standing on them.

**MIXING RATIO:**

Mix components at a volume ratio of 2 parts A to 1 part B.

**MIXING:**

This is a two component system. All components (liquids A and B) should be between 70° F and 90° F prior to mixing. The entire contents of each component should be thoroughly mixed individually before combining separate components together. Pour premeasured quantities of both components into a clean container and blend thoroughly using a power agitator, such as a Jiffy® mixer and a high strength industrial drill, for 5 minutes. Do not mix more material than can be used within stated working times.

**WORKING TIME:**

Approximately 1 hour at 70° F. The working time will be extended at lower temperatures and shortened when higher.

**THINNING:**

Thinning is not recommended for topcoats. Use **MADEWELL 457 Thinner** for equipment cleanup (see descriptive brochure).

**APPLICATION:**

**MADEWELL 927** can be applied by brush, roller or conventional or airless spray (contact a Madewell technical representative for specific equipment recommendations and sources). Apply as thinly as possible to form a thin film on the surface. Puddles and runs should be avoided. Dry areas where no primer remains on the surface should be recoated.

*Special Note:* Tests and case histories indicate that **MADEWELL 927** can be used to coat wet, uncured concrete if applied under a carefully controlled set of conditions:

1. The concrete must be a high quality, low slump mix placed with a minimum amount of agitation to reduce the possibility of separation.
2. After the concrete has been screeded into place and bullfloated, it should be allowed to stiffen sufficiently so that work-

men can stand on its surface using walkboards. At the point when no bleedwater exists on the concrete surface, the concrete should be given a coarse broom or wood float finish and the **MADEWELL 927** should be applied immediately by roller. If properly timed, it should be necessary to keep the roller saturated with primer in order to prevent picking up concrete particles from the surface (you should still be able to write your name in the concrete with a sharp stick at this point).

When applying **MADEWELL 927** to uncured concrete, beware of high slump concrete which produces an abundance of bleedwater. Also, use caution when placing concrete outdoors on hot windy days to ensure that the concrete surface does not dry prior to the application of **MADEWELL 927**. Either of these conditions can cause the formation of laitance which may cause adhesion problems. **MADEWELL 927** should not be applied to hard steel troweled surfaces unless the concrete has been fully cured and aggressive surface preparation methods have been employed. Do not apply **MADEWELL 927** to concrete the day following placement, when the concrete is hard but still extremely damp. Although **MADEWELL 927** has been used over uncured concrete containing water reducing admixtures (plasticizers), the effect of most commercially available concrete admixtures is unknown. Consult a Madewell technical representative for assistance.

**CURE TIME:**

*Foot traffic:* 24 hours at 70° F (avoid contaminating surface if primer is to be topcoated).

*To topcoat:* 4 to 6 hours depending on temperature. The minimum time is not critical – can be topcoated as soon as tacky.

**CLEAN UP:**

**MADEWELL 457 Thinner** is recommended to clean equipment (see descriptive brochure). Skin should be cleaned

using warm soapy water or commercial hand cleaner.

**STORAGE:**

Store components in sealed containers in dry environment at moderate temperature conditions (40° F to 80° F).

**SHELF LIFE:**

1 year, subject to reinspection thereafter.

**SAFETY:**

**MADEWELL 927** contains epoxy resins that *MAY CAUSE EYE OR SKIN SENSITIZATION*. Adequate health and safety precautions should be observed during all storage, handling, use and drying periods. For best results and safest usage, user is specifically directed to consult the current “Material Safety Data Sheet” for this product. When using this product in a confined space or closed area, consult the current OSHA or ANSI bulletins on safety requirements. Do not take internally. If swallowed, call a physician immediately. Keep away from open flame and keep containers tightly closed when not in use.

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