Edison Coatings, Inc.

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°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 45°F and free from hydrostatic pressure, moisture vapor transmission, paint, curing compounds, oil, dirt, or other materials which could hinder adhesion. For colder temperatures (40°F-55°F) a system with better low-temperature curing properties can be recommended by your Edison Coatings 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 up to 30 minutes before initial set.

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, and within 4 hours in warmer weather. If coating loses tack before topping, reapply per above instructions.

d. For greater gloss, color retention, and chemical resistance, an alternative seal coat may be selected for application over the topping. Consult your Edison Coatings 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 70°F, 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 working temperature.

4. Limitations:

Do not apply at temperatures below 45°F, or when temperatures of topping, air or substrate will fall below 45°F 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 a 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 manufacturers Safety Data Sheets.

COMMERCIAL AND INDUSTRIAL USE ONLY

Edison Coatings, Inc.

Revised: 02/2022

3 Northwest Drive, Plainville, CT 06062

Phone: (860) 747-2220 or (800) 341-6621 **Fax: (860) 747-2280 or (866) 658-1189**

E-mail: chad@edisoncoatings.com **Internet: www.edisoncoatings.com**