PRODUCT DESCRIPTION

Stonprime 639 is a two-component, clear, solvent-based aliphatic amine adduct cured epoxy concrete primer. Its deep penetrative and wetting properties seals concrete pores which reduces outgassing and strengthens substrate surfaces.

USES

As a general purpose concrete primer for joint sealants and this coatings, particularly on previously contaminated floors that have been cleaned and prepared. Ideal for porous screeds and concrete that may require surface hardening prior to coating. Generally used as a penetrating primer under various epoxy coating systems, or left as a non-staining, easy cleaning, anti-dusting flooring sealer.

PRODUCT ADVANTAGES

- Enhances bond of coating system to substrates
- Excellent penetration
- Economical floor sealer
- Strengthens cementitious surfaces

PACKAGING & COVERAGE

5lt Kit Part A + B

4 to 6m²/litre/coat – 2 or more coats may be required depending on floor porosity.

NOTE: Coverage rates shown are theoretical. Actual coverage rates may vary. Make necessary allowances for the condition of the surface to be coated, working conditions, waste, spillage, experience level and skill of the installers, etc.

TYPICAL PROPERTIES AT 25°C

Finish	Gloss
Colour	Amber
Consistency	Liquid
Volume Solids	30 to 35%
Number of Components	2
Mix Ratio By Volume	4:1 (Base:Activator)
Pot Life	6 to 8 Hours
Apply Over	Cleaned concrete or wood
Apply By	Brush, roller or spray
Curing Time	6 Hours recoat 24 Hours service 7 Days full cure
Thinner	Thinner # 10 (not more than 5% by volume)
Max Service Temperature	120°C Dry 60°C Wet
Application Temperature Range	16°C to 30°C
Dew Point	Substrate to be 2°C above dew point
VOC Content	586 g/l

NOTE: The above physical properties were measured in accordance with the referenced standards. Samples of the actual floor system, including binder and filler, were used as test specimens. All sample preparation and testing is conducted in a laboratory, values obtained on the field applied materials may vary.

TYPICAL RESISTANCE GUIDE

Exposures	Splash & Spillage	Fumes
Acids	Good	Good
Alkalies	Very Good	Very Good
Solvents	Very Good	Very Good
Water & Salts	Excellent	Excellent
Weather	Coating will chalk	

REFERENCE SAMPLE

A trial reference sample should be installed by the applicator prior to start of contract to ensure correct coverage and workmanship.

STORAGE CONDITIONS

Store all components of Stonprime 639 between 16 to 32°C in a dry area. Avoid excessive heat and do not freeze.

SHELF LIFE

24 Months if stored between 16 to 32°C.

PLACEMENT GUIDELINES

SCOPE OF WORK (BOQ)
Prepare surface and apply Stonprime 639 to seal substrate prior to overcoating with specified products.

SUBSTRATE PREPARATION
Remove oils, grease and other contaminants by scrubbing with Carboclean 252 and rinsing with clean running potable water to obtain a water break-free surface. Allow to dry. Abrade the surface by etching or grinding or light vacublasting to remove laitance and open all voids. The roughened surface should have a texture similar to 100-grit sandpaper, and minimum tensile strength of 1.5MPa and moisture content of 5% maximum.

MIXING
Empty the entire contents of the Activator component into the Base component and mix thoroughly for 2 minutes using a mechanical mixer. Transfer material into another mixing container, scraping the sides and bottom of the container and remix for a further 2 minutes. This step is critical to ensure complete cross-linking of components is achieved. Do not aerate mix nor mix by hand.

PRIMING
Onto clean, dry, dust-free sound surfaces, apply Stonprime 639 utilising a medium nap roller and paint tray at 6.4m²/litre to ensure a dry film thickness of 50 microns. Allow to cure for 6 hours and apply an additional coat at the same spread rate is the substrate is porous and a uniform gloss finish has not been achieved.

CURING
If temperatures are between 16 to 30°C, the coating system can be exposed to light traffic after 24 hours. Excessive traffic, aqueous cleaning and exposure to aggressive chemicals should only take place after 5 days, when full cure has been achieved.

RECOMMENDATIONS
- DO NOT attempt to install material if temperature of components and substrate are not within 16 to 30°C. The cure time and application properties of the material are severely affected.
- DO NOT use water or steam in the vicinity of the application. Moisture can seriously affect the working time and other properties.
- Protect areas from dust and isolate access. Contamination between layers will affect the final appearance.
- Avoid contact with all liquid Parts A and B as they may cause skin and/or eye irritation. Workmen should cover hands with protective creams or rubber gloves and wear safety glasses.
- Use only with adequate ventilation.

NOTES
- Procedures for maintenance of the flooring system during operations are described in "StonCor Cleaning Procedures".
- Specific information regarding chemical resistance is available in the Chemical Resistance Guide.
- Material Safety Data Sheets are available on request.
- A staff of technical service engineers is available to assist in installation or to answer questions related to our flooring products specifically or flooring problems in general.
- Requests for technical service or literature can be made through local sales representatives and offices, or corporate offices located throughout the world.

COLD CONDITIONS
Low temperatures decrease flow, delay set and affect water resistance and final appearance. Materials should be conditioned for 16 hours at 21 to 27°C; heaters should be utilised to warm floors.