

# Marine Resin Coating Systems

## Weber.floor 4760N Epoxy Primer

Moisture-tolerant special base coat



Mixing ratio	Parts by weight	A : B	=	100 : 60
	Parts by volume	A : B	=	100 : 66
Application time	Temperature	10 °C / 50 °F	20 °C / 68 °F	30 °C / 86 °F
	Time	60 minutes	40 minutes	20 minutes
Application temperature		Minimum 10 °C / 50 °F (room- and floor-temperature)		
Curing time (Accessibility)	Temperature	10 °C / 50 °F	20 °C / 68 °F	30 °C / 86 °F
	Time	24 - 28 hrs.	12 - 15 hrs.	8 - 12 hrs.
Curing		2 - 3 days for mechanical load at 20 °C / 68 °F		
		7 days for chemical resistance at 20 °C / 68 °F		
Further coatings		After curing, but not longer than 48 hours at 20 °C / 68 °F		
Consumption	Base coat	Approx. 0.35 kg/m <sup>2</sup>		
	Scratch coat	Approx. 0.4 - 0.6 kg/m <sup>2</sup>		
	Mortar	Approx. 0.150 - 0.300 kg/m <sup>2</sup> for each mm of layer		
Packaging		Hobbock-Combi 30 kg		
Shelf life		12 months (originally sealed)		

### Usage and Properties

**WEBER.FLOOR 4760N EPOXY PRIMER** is a solvent-free, 2-component epoxy resin. The material is highly moisture tolerant.

**WEBER.FLOOR 4760N EPOXY PRIMER** humidifies matt-damp surfaces, blocks water, and leads to excellent adhesion.

In combination with degreaser oily substrates can be cleaned. Afterwards a base coat can be applied.

Because of the very good penetration capability and high wettability properties the material stands the test on critical substrate. The material offers increased adhesive strength for substrate with lacking solidity. Because of its medium

viscosity the material is suitable for scratch coats and as a wet bonding course for bonded screed. Good adhesion on steel-, galvanized steel-, aluminum- and concrete substrates.

### Product Features

- solvent-free
- tested, low-emission quality
- with accreditation (DIBt®) for interior areas
- very excellent adhesion
- reinforcing
- all-purpose application
- resistant to hydrolysis and saponification
- cures even on damp substrate
- increased durability to osmosis
- high penetration
- free of deleterious substances against varnish

## Testing

External test certificates are available:

- AgBB-tested and DIBt®-accredited in combination with different coatings.
- Tested and approved in combination with **WEBER.FLOOR 4761N EPOXY COATING** according to **SOLAS MED IMO 2010 FTP Code**.

**Note:** Please ask for the tested system structure!

## Area of Application

- Use as base coat before coating pale-damp and chemically wet-cleaned substrate.
- Use as base coat on screed- and concrete substrate.
- Use as base coat on steel, galvanized steel, aluminum.
- Reinforcement for substrate with insufficient rigidity.
- Scratch-coat for sealing and levelling.

## Substrate

The substrate to be coated has to be levelled, dry, free of dust, has to have adequate tensile and compressive strength, and be free from weakly-bonded components or surfaces. Materials impairing adhesion, such as grease, oil, and paint residues must be removed using suitable methods. **WEBER.FLOOR 4760N EPOXY PRIMER** can be used as a bonding course on pale-damp substrate after degreasing. Suitable surfaces are concrete C20/25, cement screed CT-C35-F5, as well as other adequately sound sur-faces such as steel, galvanized steel and aluminum. The substrate must have adequately high strength for the proposed occupational use. The coating of mastic asphalt with epoxy resin is not recommended. The adhesive tensile strength can be increased on stability lacking substrate because of the reinforcing effect of the material. The surface to be coated should be prepared mechanically, preferably by shot-blasting or grinding. The surface strength must then be a minimum of 1.5 N/mm<sup>2</sup>. For concrete, moisture content must not exceed 4.5 CM-%, remaining residual humidity. The possibility of moisture ingress from the rear must be permanently excluded. Under certain circumstances **WEBER.FLOOR 4760N EPOXY PRIMER** may be applied on damp or inadequately sealed substrate. Check the suitability for given premises. Please refer to the advice issued by the trade associations, e.g. the current edition of BEB-work-sheets KH-0/U and KH-0/S. Reconstructing floors re-quires a final examination, e.g. testing the adhesive tensile strength beside the usual requirements.

## Mixing

Single packages of the components need to be weighed in the precise mixing ratio. Combi-trading units will be supplied in the correctly measured mixing ratio. Component A has sufficient volume for the entire trading unit.

Decant the hardener B into the resin completely. Blend with a slow speed mixer (200 - 400 r/pm) for at least 2 - 3 minutes, for a material that is homogeneous and free of streaks. To avoid mixing errors, it is recommended to empty the resin/hardener-mixture into a clean container and mix briefly once again ("to repot").

Producing scratch coats:

1.0 kg      **WEBER.FLOOR 4760N EPOXY PRIMER**  
0.5 - 0.8 kg   **WEBER.FLOOR QUARTZ SAND**

Before adding additives, the resin has to be premixed. The amount of the sand-blend to be added depends on the desired texture and consistency.

## Application / Handling

**Base coat:** Processing the material as a base coat takes place immediately after mixing with a coating knife, spatula, or nylon roller. Apply an evenly closed sealing coat on the substrate, re-roll time-delayed if necessary. On highly absorbent surfaces a second coat or a saturated scratch coat is recommended to achieve a fully sealed substrate. While still fresh, scatter the surface with approx. 0.8 kg fire-dried quartz sand (grain size 0.3/0.8 mm) for optimum adhesion. This is also mandatory if the subsequent coatings will be applied later than 36 hours after base coat application. For an increased resistance to osmosis it is necessary to apply the base coat in two layers, or apply a base-and scratch-coat. Then do not scatter the first coating and work within the recommended time pattern.

**Scratch coat:** For smoothing and completely sealing the substrate it is recommended to apply a scratch coat before subsequent coatings. Use a trowel, metal-, or rubber coating knife. The consistency has to be adjusted according to the absorbency of the substrate and set so the material may run true.

Floor- and air-temperature must not fall below 10 °C / 50 °F and/or humidity must not exceed 75 %. The difference in floor- and room-temperature must be less than 3 °C / 37.4 °F so the curing will not be disturbed. If a dew-point situation occurs adhesion may malfunction, curing may be disturbed, and spotting may occur.

Curing time applies to 20 °C / 68 °F. Lower temperature may increase, higher temperature may decrease the curing and processing time. If working conditions are not complied with, deviations in the described technical properties may occur in the end product.

**Special remarks:** We advise against the "gumming" of screed joints/flat joints with pure or with thixotropic agent filled epoxy resin. In the course of time, these areas will begin to show on the surface. For the application, use always the **WEBER.FLOOR 4760N EPOXY PRIMER** in combination with quartz sand e.g. **WEBER.FLOOR QUARTZ SAND**. For this, we recommend to add at least 1 - 3 parts by weight of filler.

### Cleaning

To remove fresh contamination and to clean tools, use thinner immediately. Hardened material can only be removed mechanically.

### Storage

Store in dry and at frost-free conditions. Ideal storage temperature is between 10 - 20 °C / 50 - 68 °F. Bring to a suitable working temperature before application. Tightly re-seal opened containers and use the content as soon as possible.

### Special Remarks

The product is subject to the hazardous material-, operational safety-, and transport regulations for hazardous goods. Refer to the Safety Data Sheet and the information on the labelled containers!

GISCODE: RE 1

#### Indication of VOC-Content:

(EG-Regulation 2004/42)

Maximum Permissible Value 500 g/l (2010,II,j/lb):

Ready-for-use product contains < 500 g/l VOC.

### Technical Data\*

Viscosity	Components A + B	950	mPas	DIN EN ISO 3219 (23 °C / 73.4 °F)
Solid content		> 99	weight-%	Weber-Method
Density	Components A + B	1.08	kg/l	DIN EN ISO 2811-2 (20 °C / 68 °F)
Weight loss		0.3	weight-%	(after 28 days)
Water absorption		< 0.2	weight-%	DIN 53495
Bending tensile strength		> 25	N/mm <sup>2</sup>	DIN EN 196/1
Compressive strength		> 70	N/mm <sup>2</sup>	DIN EN 196/1
Shore-hardness D		82	-	DIN 53505 (after 7 days)
Adhesive tensile strength		> 1.5	N/mm <sup>2</sup>	DIN EN 1542

(\* Values achieved in sampling are average values. Variation in product specification is possible.)



All stated information is based on our previous experience and composition. It is not possible to consider every single case. Please seek advice for your special cases. We guarantee the correct and proper quality of our products. We do not assume responsibility for the work not carried out by us since we have no influence on the processing or processing conditions. We recommend that on-site-trials will be conducted. Our "General Terms and Conditions" apply. With appearance of this new data sheet all prior information loses validity.