

Madewell® 927™

Penetrating Epoxy Primer/Sealer



FEATURES/BENEFITS

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

PRODUCT DESCRIPTION

MADEWELL 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. It also 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, including the sanitary sewer, pulp and paper, chemical processing, 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, modified epoxy coating.

COLOR:

Clear.

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 square feet (ft²)/gallon on new, dense concrete to 150 ft²/gallon on old, porous concrete have been observed.

PACKAGING:

Normally stocked in 4.5-gallon, two-component kits; special packaging available.

SURFACE PREPARATION:

MADEWELL 927 is not typically used to prime steel or other metallic substrates. 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 that 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 the 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 (ICRI) Concrete Surface Profile (CSP)

#3 condition. 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 substrate 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 the Occupational Safety and Health Administration (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 the application of a test patch.

Note: **MADEWELL 927** will bond to many damp porous surfaces, but it may not bond to surfaces that 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. Whenever possible, avoid mixing partial kits.

MIXING:

This is a two component system. All components (liquids A and B) should be between 70° Fahrenheit (F) and 90° F prior to mixing. The entire contents of each component should be thoroughly mixed individually before combining separate components together. If it is not possible to mix an entire kit, pour carefully measured 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 3 minutes. Do not mix more material than can be used within stated working times.

WORKING TIME:

Approximately 60 minutes at 70° F. Working time will be extended at lower temperatures and shortened when higher.

THINNING:

Thinning is not recommended.

APPLICATION:

This product is to be applied by trained workmen using specialized equipment. Both components must be preheated between 70° F and 90° F prior to application. A minimum 45:1 airless spray pump with an air input pressure of 45 pounds per square inch (psi) may be used to feed material through up to 50' of 1/4" diameter hose to a standard airless spray gun with a 0.019" reversible tip. Other equipment, such as whip hoses, heaters, or plural component equipment may be employed. **MADEWELL 927** can also be applied by brush or roller. 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. Contact a Madewell Technical Representative for specific application equipment recommendations.

Special Note: Tests and case histories indicate that **MADEWELL 927** can be used to coat freshly placed, 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 bull floated, it should be

allowed to stiffen sufficiently so that workmen can stand on its surface using walkboards. At the point when no bleed water 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 bleed water. Also, use caution when placing concrete outdoors on hot or 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. **MADEWELL 927** can be topcoated as soon as tacky.

CLEAN UP:

Use xylene or methyl ethyl ketone (MEK) to clean application equipment. Skin should be cleaned using warm, soapy water or commercial hand cleaner.

DELIVERY & STORAGE:

Check containers for damage, and verify quantities before accepting ship-

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

SHELF LIFE:

1 year, depending on storage conditions, subject to reinspection thereafter.

SAFETY:

KEEP OUT OF REACH OF CHILDREN. FOR INDUSTRIAL USE ONLY. **MADEWELL 927** contains epoxy resins that *MAY CAUSE EYE, SKIN, RESPIRATORY, OR NERVOUS SYSTEM 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 Safety Data Sheet for this product. When using this product in a confined space or closed area, consult the current Occupational Safety and Health Administration (OSHA) or American National Standards Institute (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.

WARRANTY:

All technical data, recommendations, and services are rendered by the Seller gratis. They are based on technical data that the Seller believes to be reliable and are intended for use by persons having skill and knowledge at their discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by the Buyer whether as recommended herein or otherwise. Such recommendations, technical advice, or services are not to be taken as a license to operate or intended to suggest infringement of any existing patent. **MADEWELL PRODUCTS CORPORATION MAKES NO GUARANTEE OR WARRANTIES EXCEPT AS OTHERWISE PROVIDED IN WRITING AND DISCLAIMS ANY AND ALL WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**

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