

# Sparco Epoxy Bonding Primer #104

## Two-Component Solvent-Free Epoxy Bonding Primer

A medium-viscosity, solvent-free epoxy bonding primer for dry or damp concrete, asphalt and metal — the ideal key coat for absorbent and mechanically prepared substrates.

Sparco Epoxy Bonding Primer #104 is a two-component, solvent-free, medium-viscosity epoxy primer. It can be applied to dry or damp surfaces and is especially suited to highly absorbent substrates, developing an excellent mechanical key on cleaned concrete, cementitious screed, existing epoxy flooring, asphalt and metal.

### Dry or Damp Substrates:

Bonds to dry or damp surfaces, giving versatility across varied site conditions.

### Highly Absorbent Substrates:

Especially suitable for porous, highly absorbent surfaces such as concrete and cementitious screed.

### Excellent Adhesion:

Develops a strong key on mechanically cleaned concrete, asphalt and metal; bond strength to concrete results in concrete failure.

### Solvent-Free:

100% solids, low-odour formulation suitable for use in unventilated areas.

### Ready-to-Use Packing:

Pre-weighed two-part packs ensure correct mixing and easy application within the pot life.

## FIELDS OF APPLICATION

- ▶ New and existing concrete
- ▶ Cementitious screed
- ▶ Existing epoxy flooring
- ▶ Asphalt surfaces
- ▶ Mechanically prepared metal

## System Design



**Primer** Epoxy Bonding Primer #104

**Substrate**

## Technical Profile\*

### SOLIDS

Part A / Part B **100% / 100%**

### COLOUR

Part A / Part B **Milky amber / Brown**

### DENSITY

ASTM D4052, @ 25°C **1.35 / 1.00–1.02 g/cm<sup>3</sup>**

### MIXING RATIO

Part A : Part B, by weight **4 : 1**

### POT LIFE

@ 30°C **Up to 30 minutes**

### BOND STRENGTH

to concrete **Concrete failure**

### ADHESION STRENGTH

pre-treated substrate, min. **>1.5 N/mm<sup>2</sup>**

### FINAL CURE

@ 25°C **7 days**

### CONSUMPTION

per coat **6–8 m<sup>2</sup>/kg**

### SHELF LIFE

Part A / Part B, unopened **2 / 2 years**

\* Typical properties of unmixed material at 25°C unless stated. Values may vary with site conditions, substrate and application method.

## Model Specification

<b>System</b>	Sparco Epoxy Bonding Primer #104
<b>Type</b>	Two-component solvent-free epoxy primer
<b>Build-up</b>	1 coat as primer beneath Sparco epoxy / PU floor systems
<b>Manufacturer</b>	Sparco Paints (S) Pte Ltd

Preparatory work and application in accordance with manufacturer's instructions.

## System Build-Up by Substrate

Substrate	Preparation	Primer & Finish
<b>Concrete / screed</b>	Ball blast, mill or diamond grind; cure 28 days; moisture $\leq$ 5%	1 coat #104 @ 6–8 m <sup>2</sup> /kg, then floor build-up
<b>Asphalt / metal</b>	Clean; mechanically prepare metal surfaces	1 coat #104, then subsequent Sparco floor system

## Surface Preparation

Substrate must be dry, sound, clean and free from oil, grease, loose material, surface contaminants and other bond-inhibiting materials. Prepare concrete mechanically by ball blasting, milling or diamond grinding. Remove weak concrete and fully expose surface defects such as blowholes and voids; fill cracks, holes and gouges with proper patching materials. Remove all dust and loose material, preferably by vacuum cleaner. Moisture content must not exceed 5%. On new concrete, apply at least 28 days after construction.

## Packaging

Product	Pack Size
<b>Sparco Epoxy Bonding Primer #104 (Part A + B)</b>	5 kg set (A: 4 kg, B: 1 kg) or 20 kg set (A: 16 kg, B: 4 kg)
<b>Xylene or Toluene (cleaner)</b>	As required

## Warranty

**LIMITED WARRANTY:** Sparco Paints (S) Pte Ltd warrants that, at the time and place of shipment, our materials will be of good quality and will conform to our published specifications in force on the date of acceptance of the order.

**DISCLAIMER:** The information contained herein is included for illustrative purposes only and, to the best of our knowledge, is accurate and reliable. As Sparco Paints (S) Pte Ltd has no control over the use to which others may put its products, it is recommended that products be tested to determine suitability for specific applications. Responsibility remains with the architect or engineer, contractor and owner for the design, application and proper installation of each product. Specifier and user shall determine the suitability of the product for its specific application and assume all responsibility in connection therewith.

## Application Guidelines

Parameter	Value
<b>Mixing ratio (by weight)</b>	4 : 1
<b>Pot life @ 30°C</b>	Up to 30 minutes
<b>Consumption per coat</b>	6–8 m <sup>2</sup> /kg
<b>Min. substrate temperature</b>	5°C
<b>Final cure @ 25°C</b>	7 days

### IMPORTANT

Substrate must be cured at least 28 days (new concrete) with moisture content not exceeding 5%. Mix and cure between +10°C and +35°C; minimum substrate temperature 5°C. Process mixed epoxy within the pot life — it cures faster in hot weather and in larger batches.

## Product Preparation

Prior to application, store the product under cover in dry conditions and protect from temperature extremes, which may cause inconsistent workability, finish and curing times. Ideally, maintain the product at approximately 25°C for at least 24 hours before mixing.

Supplied in two pre-weighed parts; no additions or omissions are required. Pour all of Component A into a clean mixing barrel, add all of Component B, and mix homogeneously for at least 2–3 minutes with a mechanical stirrer. Apply evenly by roller, brush or airless spray.

## Cleaning

Remove uncured Sparco Epoxy Bonding Primer #104 from tools and equipment with suitable solvents such as Xylene or Toluene immediately after use. Cured material may only be removed mechanically.

## Storage

Store for a minimum of twelve months at 5°C to 35°C in unopened original packaging. Protect from direct sunlight.

## Health & Safety

Sparco Epoxy Bonding Primer #104 is physiologically harmless once cured. Keep resin and hardener away from eyes, mouth and skin and avoid breathing the vapours; wear protective gloves when handling — refer to the Safety Data Sheet (SDS) for full details.

## Technical Assistance

Please contact Sparco Paints (S) Pte Ltd for technical assistance, specification support and application advice.