HEGGEL® Pox 408

Moisture-Tolerant Epoxy Primer

You Build, We Protect!

Description:

HEGGEL Pox 408 is a two-component, solvent-free, moisture-tolerant epoxy resin-based primer designed for concrete and screed substrates with permanent dampness or hydraulically setting substrates. It provides excellent adhesion and long-term reliability under high-moisture conditions. Prior to use, please consult HEGGEL to confirm suitability for the specific project and substrate conditions.

Characteristics:

- Excellent adhesion to cementitious substrates
- Solvent-free
- Moisture-tolerant
- Prevents bubble formation resulting from osmotic effects

Applications Areas:

HEGGEL Pox 408 is applicable on hydraulically setting substrates with residual moisture exceeding 4% or permanently damp substrates with residual moisture consistently above 6%.

Application Data:

Mixing Ratio	A : B = 1.74 : 1 (Parts by weight)
Consumption (HEGGEL Pox 408)	0.5 kg/m²
Consumption (HEGGEL Filler 60)	3 kg/m²
Temperature	**20 °C**
Pot Life	60 min
Curing Time (Walkable)	6 hrs
Curing Time (Until Further Processing)	8 hrs
Curing Time (Maximum Waiting Time)	24 hrs

Note 1: All above values are approximate and may be used as a guideline for specifications
Note 2: Maximum waiting times do not apply to surfaces that have been gritted.

Technical Data:

Title	Standard	Value
Density (Mix)	DIN EN ISO 1183-1	1.08 g/cm³
Adhesion Strength to Concrete / Screed	DIN EN ISO 4624	> inherent tensile strength

Packaging:

Product	Packaging
HEGGEL Pox 408 Solution	8 kg Drum
HEGGEL Pox 408 Hardener	4.6 kg Drum
HEGGEL Filler 60	25 kg Bag

Storage:

24 months in 20°C. Higher temperatures will reduce the minimum shelf life, while lower temperatures will prolong it. All components must be stored and transferred in original containers under dry and frost-free conditions.

1. Surface Preparation

The concrete surface to be coated must be free from cement slurry, cement skin, loose or friable areas, structural defects, and any contaminants or separating substances that could impair (Refer to DIN EN14879- 1). Ensure that the surface is properly pretreated to achieve sufficient adhesion tensile strength.

The substrate must be visibly dry, and no additional moisture may be introduced during processing.

2. Environment Conditions

Environmental Conditions	Value
Substrate & Material Temperature	min.15 °C up to max. 25 °C
Optimum Processing Temperature	20 °C
Dew Point Distance	min. 3°C

The application area shall be shielded from air drafts and direct sunlight.

3. Application Tools

- Measuring cup
- Mixing vessel
- Scale
- Brush / roller
- Drilling machine
- Basket spiral agitator

4. Mixing

Before mixing, ensure the components' temperature and ambient environment are between 15°C and 25°C. Temperatures outside this range may affect the working time and consistency of the composition, which can influence material consumption, film thickness and application performance. Ensure that all materials are conditioned to the same temperature prior to and during processing.

Measure or weigh the liquid components accurately. Add the **HEGGEL Pox 408 Solution** to the mixing vessel, then add the **HEGGEL Pox 408 Hardener.** Mix thoroughly using a suitable low-speed basket spiral mixer (300–500 rpm) until a fully homogeneous mixture is achieved.

5. Application

Start processing only when all required conditions are met and can remain stable during both application and curing.

HEGGEL Pox 408 is typically applied using brush or roller. Application shall be executed to avoid accumulation of material in concrete indentations or open expansion joints.

Variations in temperature, whether higher or lower, have a direct impact on the working time and consistency of the composition. Consequently, material consumption, achievable film thickness, and application performance may change.

To ensure optimal results, all materials must be brought to and maintained at the same temperature throughout the processing stage.

Floor Surfaces:

- The application is carried out in one working step (consumption: 0.500 kg/m²).
- Immediately after application, the fresh primer shall be fully sprinkled with **HEGGEL Filler 60** (consumption: 3 kg/m²).

Plinth / Wall Surfaces:

- The application is performed in 2 steps (consumption: 0.500 kg/m²).
- After the second step, sprinkle **HEGGEL Filler 60** onto the wet primer (consumption: 3 kg/m²).

6. Cleaning

Tools contaminated with uncured material should be cleaned using **HEGGEL Cleaner**. Ensure cleaning is carried out only in well-ventilated areas and that all relevant safety precautions are strictly followed.

7. Safety Measures

Ensure proper air circulation during application in enclosed areas.

Observe all fire safety regulations and strictly avoid smoking in the area. Always wear the required personal protective equipment and prevent skin contact with the materials. Clean and protect your hands using suitable skin protection soap and ointment, avoiding the use of solvents. When performing grinding or repair work, wear a dust mask. Keep the materials away from open flames, and during welding, ensure they do not come into contact with sparks or welding beads.

Residual quantities should preferably be consumed. Do not pour residues down the sink or dispose of them in the dustbin. Collect all remaining materials separately for disposal in durable, sealable, and properly labelled containers.

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.

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