



CRACKBOND® EPOXY REPAIR PASTE



**Multi-Purpose
Structural Adhesive**

GENERAL USES & APPLICATIONS

- Bonds to most construction materials including concrete, block, brick, metal, stone
- May be used as an adhesive or filler
- High-build, non-sag patching material for non-moving cracks and spalls
- Excellent for pick-proofing, as a capping paste for injection processes, waterproofing applications, repair and restoration

ADVANTAGES & FEATURES

- High-build and easily tool-able
- Superior hardness for tamper resistance
- Hi-mod formula - cures stronger than concrete
- Available in cartridges, 102 oz. and 3 gallon kits
- Moisture insensitive
- Easy 1:1 mix ratio



Chemex Industries, Inc.

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CRACKBOND EPOXY REPAIR PASTE ADHESIVE, DISPENSING TOOLS AND MIXING NOZZLES

| Package Size | 21.2 fl. oz. (627 ml) Cartridge | 102 oz. (3.0 L) Bulk Unit Gallon | 3 Gallon (11.0 L) Kit |
|---------------------------|------------------------------------|-------------------------------------|----------------------------|
| Part # | A22-ERPN | BUG-ERP | B1.5G-ERP-A B1.5G-ERP-B |
| Manual Dispensing Tool | TM22HD | N/A | |
| Pneumatic Dispensing Tool | TA22HD-A | | |
| Case/Kit Qty. | 12 | 1 | 1 |
| Pallet Qty. | 432 | 75 kits | 30 kits |
| Pallet Weight (lbs.) | 1,180 | 948 | 1,376 |
| Recommended Mixing Nozzle | T12 | N/A | |
| Alternate Mixing Nozzle | T34HF | | |

CRACKBOND EPOXY REPAIR PASTE CURE SCHEDULE^{1,2,3}

| Base Material Temperature | Working Time | Crack Injection Port Adhesion Cure Time ⁴ | Full Cure Time |
|---------------------------|--------------|--|----------------|
| °F (°C) | | | |
| 75 (24) | 75 min | 4 hr | 24 hr |

1. Working and full cure times are approximate, may be linearly interpolated between listed temperatures and are based on cartridge/nozzle system performance.
2. Application Temperature: Substrate and ambient air temperature should be from 40 - 110 °F (4 - 43 °C).
3. When ambient or base material temperature falls below 70 °F (21 °C), condition the adhesive to 70 - 75 °F (21 - 24 °C) prior to use.
4. Crack Injection Port Adhesion Cure Time is based on the

CRACKBOND EPOXY REPAIR PASTE PERFORMANCE TO ASTM STANDARDS

| Property | Cure Time | ASTM Standard | Units | Sample Conditioning Temperature ³ | | |
|--|-----------|---------------|--------------|--|--------------------|--------------------|
| | | | | 40 °F (4 °C) | 55 °F (13 °C) | 75 °F (24 °C) |
| Gel Time - 60 Gram Mass | ---- | C881 | min | 244 | 230 | 68 |
| Pot Life ^{4,5} | ---- | ---- | min | 18 | | |
| Tack-Free or Open Time ⁴ @ 75 °F (24 °C) | ---- | D2377 | hr | 2 - 3 | | |
| Consistency or Viscosity | ---- | C881 | ---- | Non-sag paste | | |
| Compressive Yield Strength | 7 day | D695 | psi (MPa) | 4,790 (33.0) | 13,760 (94.9) | 13,850 (95.5) |
| Compressive Modulus | | | psi (MPa) | 398,100 (2,745) | 693,700 (4,783) | 743,300 (5,125) |
| Tensile Strength ⁶ | | D638 | psi (MPa) | ---- | | 3,600 (25) |
| Tensile Elongation ⁶ | | | % | ---- | | 0.4 |
| Shore D Hardness ⁴ | 1 day | D2240 | ---- | 85 | | |
| Bond Strength Hardened to Hardened Concrete | 2 day | C882 | psi (MPa) | 2,180 (15.0) | 2,650 (18.3) | 2,180 (15.0) |
| Bond Strength Fresh to Hardened Concrete | 14 day | | | 3,000 (20.7) | 3,130 (21.6) | 2,630 (18.1) |
| Bond Strength Fresh Concrete to Steel | | | | 1,960 (13.5) | | |
| Heat Deflection Temperature | | | | 7 day | D648 | °F (°C) |
| Water Absorption | 14 day | D570 | % | 0.23 | | |
| Linear Coefficient of Shrinkage | ---- | D2566 | | 0.0007 | | |

1. Results based on testing conducted on a representative lot(s) of product. Average results will vary according to the tolerances of the given property.
2. Results may vary due to environmental factors such as temperature, moisture and type of substrate.
3. Approved for Class B at temperatures \geq 55 °F (13 °C).
4. Property not referenced in ASTM C881.
5. Pot life is measured as the workable and applicable time of 102 fl. oz. (3.0 L) when mixed at 75 °F (24 °C). Pot life lengthens to 21 minutes when mixed in a 500 gram mass @ 75 °F (24 °C).
6. Tensile & Elongation are optional requirements for ASTM C881 Grade 3.



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