

# Adesilex PG2 TG

## Two-component thixotropic epoxy adhesive for structural bonding

### WHERE TO USE

Structural repair, bonding and reinforcement of concrete elements, natural stone, mortar and brick.

### Some application examples

- Structural reinforcement of beams and pillars by bonding steel (beton plaqué method) or composite material (e.g. **Carboplate**) plates to concrete.
- Non-flexible structural bonding of precast concrete elements.
- Sealing injectors and surface damage before injection of **Epojet LV** by low-pressure pump.
- Sealing large cracks and repairing joint corners in industrial flooring subject to traffic.
- Bonding fibre-reinforced cement slabs and pipes.
- Waterproofing large size joints by bonding TPE strips (e.g. **Mapeband TPE**) to concrete.

### TECHNICAL CHARACTERISTICS

**Adesilex PG2 TG** is a two-component product based on epoxy resins, selected fine-grain aggregates and special additives according to a formula developed in the MAPEI research laboratories.

After mixing **Adesilex PG2 TG** (part A) with its hardener (part B), a thixotropic mix, easy to apply even on vertical structures in thicknesses up to 1 cm in a single layer, is obtained. Once prepared, **Adesilex PG2 TG** hardens

by chemical reticulation alone without shrinkage. It becomes a compound with exceptional bonding and mechanical strength.

**Adesilex PG2 TG** is especially suitable for applications in temperatures between +25°C and +50°C.

### RECOMMENDATIONS

- Do not use **Adesilex PG2 TG** for sealing flexible joints or joints subject to movement.
- Do not use **Adesilex PG2 TG** for shrinkage joints between fresh and hardened concrete (use **Eporip**).
- Do not use **Adesilex PG2 TG** on wet surfaces.
- Do not use **Adesilex PG2 TG** on dirty or crumbling surfaces.
- Do not use **Adesilex PG2 TG** for bonding and grouting anti-acid ceramic tiles (use **Kerapoxy**).

### APPLICATION PROCEDURE

#### Preparing the substrate

To ensure good adhesion of **Adesilex PG2 TG**, special care must be taken for the preparation of surfaces to be bonded.

The concrete, natural stone or brick substrate must be clean, sound and dry.

Sand-blasting is ideal to remove all loose and crumbling parts, efflorescence, cement laitance and traces of form-release oils. Then remove all dust with compressed air.

TECHNICAL DATA (typical values)			
<b>PRODUCT IDENTITY</b>			
	<b>component A</b>	<b>component B</b>	
Consistency:	thick paste	thick paste	
Colour:	grey	white	
Density (kg/l):	1.70	1.80	
Brookfield viscosity (mPa·s):	800000 (F shaft - rev. 5)	700000 (D shaft - rev. 2.5)	
<b>APPLICATION DATA OF PRODUCT</b>			
Mix ratio:	component A : component B = 3 : 1		
Consistency of mix:	thixotropic paste		
Color of mix:	grey		
Mass density of mix (kg/l):	1.71		
Brookfield viscosity (mPa·s):	900000 (F shaft - rev. 5)		
Application temperature range(°C):	from +2 to +50		
Complete hardening time (days):	7		
Pot life (preconditioning +50°C) (FIP Clause 5.1) (mins):	20		
Open time (at +25°C for 24 hours and 100% R.H.) (FIP Clause 5.2) (mins):	> 60		
<b>FINAL PERFORMANCE</b>			
Performance characteristic	Test method	Requirement of FIP	Performance of product
Shrinkage (at +50°C for 7 days) (%):	FIP 5.7	≤ 0.4	0.2
Heat resistance:	FIP 5.10 (ASTM D 648 - Method B)	≥ 50°C	approx. 85°C
Compressive modulus of elasticity (7 days at +25°C and 50% R.H.) (MPa): – instantaneous: – deferred (1 hour):	FIP Clause 5.13	8000 6000	8500 7800
Shear modulus (at 25°C for 7 days) (MPa): – instantaneous: – deferred (1 hour):	FIP Clause 5.16	≥ 1500 ≥ 1200	2900 2600
Thixotropy test at 10 minutes: – flow (mm):	FIP Clause 5.3	≤ 30	0
Creep in pure compression with maximum load 16 kN (at +40°C for 7 days) (MPa): – instantaneous: – deferred (1 hour):	FIP 5.8 & 5.13	≥ 8000 ≥ 6000	10560 10140
Creep in pure shear (at +50°C for 7 days) (MPa): – instantaneous: – deferred (28 days):	FIP Clause 5.8 & 5.16	≥ 1500 ≥ 1000	3590 2095
Water absorption and solvability of segmental bonding (at +50°C for 7 days) (%): – water absorption: – solvability:	FIP Clause 5.9	≤ 0.5 ≤ 0.1	0.03 0.09
Angle of internal friction (mm <sup>2</sup> ): – load 15 kg and average diameter 75 mm: – load 200 kg and average diameter 123 mm: – load 400 kg and average diameter 130 mm:	FIP Clause 5.4	≥ 3000 ≥ 7500 ≥ 10000	4350 11830 13220
Tensile bending strength and bonding strength to concrete surfaces (20/40 concrete with brush hammered boarding faces) (+25°C and 100% R.H.):	FIP 5.5 & 5.14	100% failure of the concrete	100% failure of the concrete
Compressive strength at +25°C (MPa): – 12 hours: – 24 hours: – 7 days:	FIP Clause 5.6 & 5.12	≥ 20 (FIP 5.6) ≥ 40/60 (FIP 5.6/5.12) ≥ 75 (FIP 5.6 & 5.12)	35 82 89
Shear strength (at +25°C for 7 days) (MPa):	FIP Clause 5.15	≥ 12	27

All traces of rust, paint and oil must be removed from metal surfaces, preferably by means of sand-blasting (SA 2½) down to bright metal.

With regards to fresh placed concrete, it is necessary that the concrete cures for at least 28 days before applying **Adesilex PG2 TG**.

This is to avoid tensions induced by hygrometric shrinkage of the concrete concentrated in the interface of the bonding. The application temperature of **Adesilex PG2 TG** must not be below +25°C.

#### **Preparing the mixes**

The two parts of **Adesilex PG2 TG** must be mixed together. Pour part B (white) into part A (grey) and mix at a slow speed with a drill fixed with an agitator until a uniform paste is obtained (a uniform grey). The product is already pre-dosed. To avoid incomplete hardening of **Adesilex PG2 TG**, do not use partial quantities. When partial quantities are necessary, use a precision electronic scale. The mixing ratio is:

- 3 parts by weight of part A;
- 1 part by weight of part B.

#### **Applying the mixes**

**Adesilex PG2 TG** can be applied on concrete, stone, brick or metal with a flat trowel or float.

To obtain good bonding, it is recommended to spread the adhesive on both surfaces that need bonding and let the product penetrate well, especially on irregular surfaces.

After applying the adhesive, unite the two pieces that need bonding and keep firm until the adhesive has completely hardened. Because of the excellent thixotropic property, **Adesilex PG2 TG** can be also applied vertically or on ceilings without slipping.

The environmental temperature has an effect on the hardening time of the product. At +50°C **Adesilex PG2 TG** remains workable for 20 minutes. After this time, the product begins the hardening process.

**Adesilex PG2 TG** must be applied within the useful pot life time. It is therefore useful to plan the work within the time limit mentioned above.

#### **Precautions to be taken before application**

No particular precautions need to be taken with temperatures between +25°C and +50°C.

Do not expose the product to sun light and carry out bonding during the cooler hours of the day in order to prevent the rapid hardening of the product which would make the application difficult.

#### **Cleaning**

Due to the high bonding strength of **Adesilex PG2 TG** even to metal, it is

recommended to clean working tools with solvents (ethyl alcohol, toluol, etc.) before the product hardens.

#### **CONSUMPTION**

1.71 kg/m<sup>2</sup> per mm of thickness.

#### **PACKAGING**

6 kg kit (part A: 4.5 kg; part B: 1.5 kg).

#### **STORAGE**

Store the product in original packaging in an environment at temperatures not below +10°C.

#### **SAFETY INSTRUCTIONS FOR PREPARATION AND APPLICATION**

Instructions for the safe use of our products can be found on the latest version of the SDS available from our website [www.mapei.com.my](http://www.mapei.com.my)

PRODUCT FOR PROFESSIONAL USE.

#### **WARNING**

*Although the technical details and recommendations contained in this product data sheet correspond to the best of our knowledge and experience, all the above information must, in every case, be taken as merely indicative and subject to confirmation after long-term practical application; for this reason, anyone who intends to use the product must ensure beforehand that it is suitable for the envisaged application. In every case, the user alone is fully responsible for any consequences deriving from the use of the product.*

**Please refer to the current version of the Technical Data Sheet, available from our website [www.mapei.com](http://www.mapei.com)**

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**All relevant references for the product are available upon request and from [www.mapei.com](http://www.mapei.com)**

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**MAPEI Malaysia Sdn. Bhd.** (231780-K)

**Head Office:** Tel +(60) 3 7842 9098 - Fax +(60) 3 7842 6197

**Johor Bahru Office:** Tel +(60) 7 595 3032 - Fax +(60) 7 595 3098

**Penang Office:** Tel +(60) 4 642 9098 - Fax +(60) 4 642 9097

**Kuching Office:** Tel +(60) 82 246 660 - Fax +(60) 82 246 661

**Sales Admin:** Tel +(60) 3 7842 9989 - Fax +(60) 3 7842 9880

**Nilai Plant:** Tel +(60) 6 799 8028 - Fax +(60) 6 799 8191

**Email:** [mapei@mapei.com.my](mailto:mapei@mapei.com.my) **Website:** [www.mapei.com.my](http://www.mapei.com.my)