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.

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 °F (°C)	Working Time	Crack Injection Port Adhesion Cure Time[4]	Full Cure Time
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)
	14 day			3,000 (20.7)	3,130 (21.6)	2,630 (18.1)
Bond Strength Fresh to Hardened Concrete				1,960 (13.5)		
Bond Strength Fresh Concrete to Steel				1,890 (13.0)		
Heat Deflection Temperature	7 day	D648	°F (°C)	138 (59)		
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 ≥ 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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