



Roka Epo Bond

Two Component Epoxy Bonding Agent for Wet to Dry Concrete Surfaces

Roka Epo Bond is a two-component epoxy resin based adhesive for internal or external bonding of renderings.

Uses & Advantages:

- Supplied in pre weighted units.
- Provides an even and stress-free bond.
- High bond strength.
- No shrinkage.
- Tolerates a degree of moisture before and during curing.
- Resistant to chemical attacks.
- Effective barrier to migration of chlorides.

Areas of Application:

- For bonding of fresh concrete to set concrete.
- Repair mortar to concrete or mortar.

Technical Data:

Consistency

Viscous Consistency



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83 A, Block C, PAF Colony, Zarar
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Mixing Ratio	83 (Base) 17 (Hardener)
Mixed Density	~ 1.48 kg/l
Mixed Viscosity at 25°C	2450±450 cps
Consumption	0.3 kg- 0.4 kg/m ² depending on substrate conditions
Substrate Temperature	+15°C to + 35°C
Material Temperature	+15°C to + 30°C
Pot Life	2 hours at 25°C 1 hour at 40°C
Open Time	8 hours at 25°C 6 hours at 40°C
Setting Time	150 minutes at 25°C
Full Cure	7 days at 25°C
Compressive Strength (25°C)	65 MPa at 7 days
Tensile strength (25°C)	25 MPa at 7 days
Adhesive bond strength to concrete (ASTM D4541)	>2.5 MPa (concrete failure)
Slant Shear Bond Strength (BS 6319 Part4)	>11 MPa (concrete failure)
Packaging	3 Kg units



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Shelf Life	12 months when kept in recommended storage conditions.
Storage Conditions	Dry, frost-free & away from direct sunlight (+5°C- +30°C)

Material Temperature:

Very low or very hot temperatures will make application more difficult and careful consideration should be given to storage of materials. Pre-conditioned materials at 20-25°C will reduce the possibilities of flash/slow setting and other defects.

Substrate Preparation:

All surfaces must be cleaned and prepared to achieve a laitance and contaminant free, open textured surface by blast cleaning or other equivalent mechanical means if good bond strength is to be achieved. All laitance should be removed by mechanical scarification, grit blasting, or by acid etching. Visible signs of mold growth, lichen, or algae should be removed and treated with a fungicidal wash. New concrete should be cured until the shrinkage and moisture movement is low. All curing compounds should have disintegrated or be removed and application carried out only onto a clean, dust free surface.



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Mixing:

Roka Epo Bond is supplied in pre-weighted units and it is recommended to avoid part mixing at site to achieve best performance. Carefully transfer the entire Hardener to the Base and using a slow running drill with a paint mixing paddle, mix for 3 minutes until a uniform homogenous consistency is achieved.

Application:

Apply Roka Epo Bond evenly across the whole surface with a clean, short haired paint brush. To achieve the best results, apply the screed overlay within 45-50 minutes. For bonding fresh concrete to old concrete ensure to place the fresh concrete within the overlay time depending upon the ambient temperatures. If coating becomes glossy and loses tackiness, remove any surface contaminants then recoat with additional Roka Epo Bond and proceed.

Curing:

Roka Epo Bond is self-curing but the curing is affected by ambient temperature. It will cure slowly at low temperatures and the reaction stops if the temperature falls below +5°C.



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Protection on Completion:

The newly laid surface must be kept damp for at least 5 days to promote good curing of the portland cement. The newly applied mortar must be protected from rain, direct strong sunlight and wind since too rapid drying will lead to shrinkage, cracking and reduce cohesion.

Cleaning:

Tools, brushes and mixing equipment should be cleaned immediately after use and before material has set with Roka Thinner or MEK followed by washing with soap and water.

Health and Safety:

It is recommended to wear safety goggles and gloves during application. If any material splashes into eyes it should be washed immediately with plenty of clean water and medical advice sought.

Important Note:

The information provided in this data sheet is based on ongoing development efforts and extensive field experience. While we strive to ensure the accuracy and reliability of the information, we cannot assume responsibility for any work performed using our materials, as we have no control over application methods, site conditions, and other factors. Due to ongoing research and



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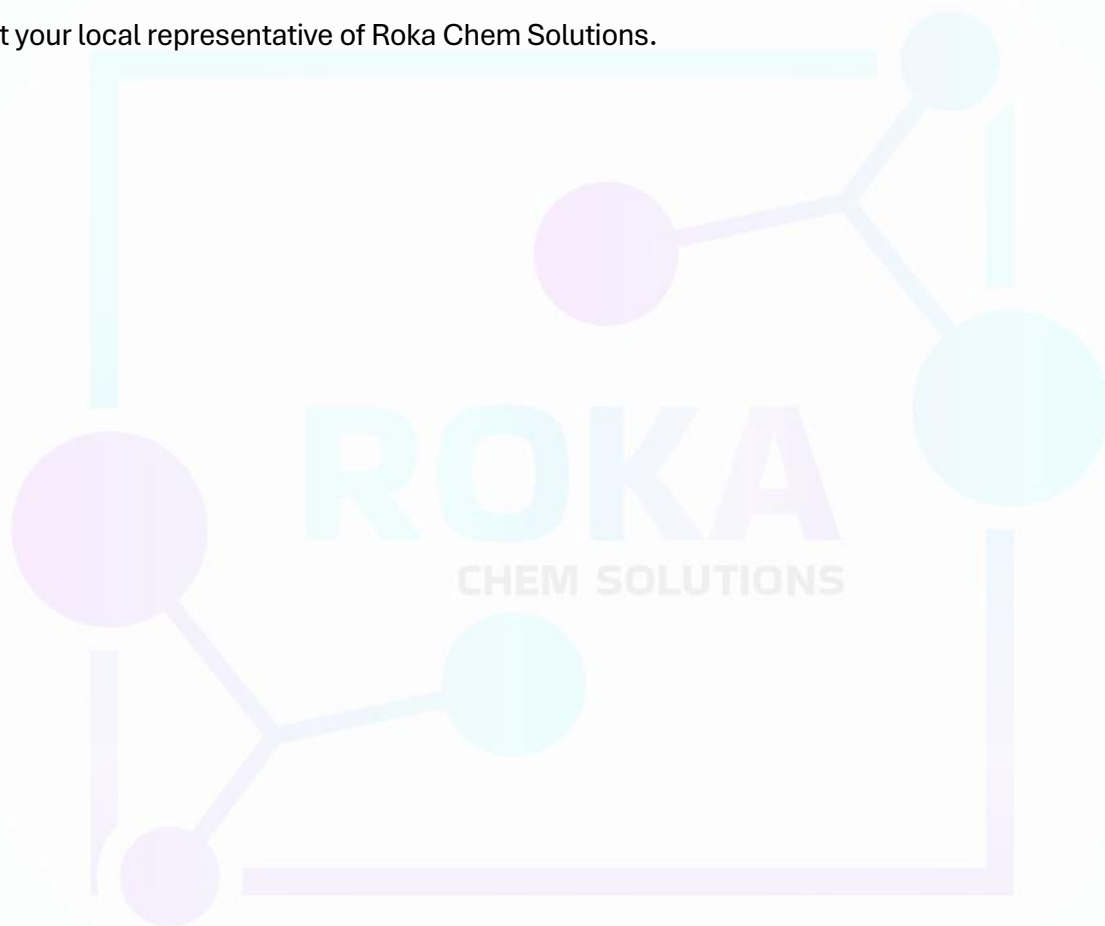


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development in our laboratories, we recommend that customers verify that this data sheet has not been replaced by a more recent publication.

All products are sold under our standard conditions of sale, which are available upon request. Any field services offered do not imply supervisory responsibility. For further information, please contact your local representative of Roka Chem Solutions.



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