



LAMINATING
EPOXY

ADHESIVES

PROCESS
EQUIPMENT

Technical Data

M1005 Resin/M2005 Hardener

High Flow Adhesive

M1005/M2005 Adhesive is a pre-thickened, two-part epoxy adhesive formulated for injection into stable cracks in concrete and masonry structures. Due to its shear thinning characteristics, this gel adhesive will flow and efficiently wet-out the substrate, but will resist sagging out of the crack or injection port.

SURFACE PREPARATION

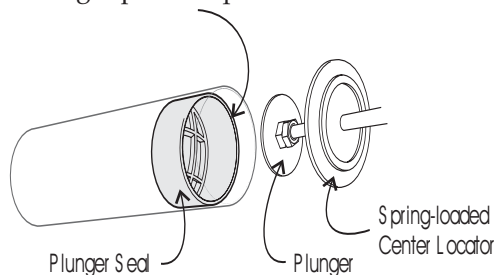
Surfaces should be clean and free of contaminants and laitance. Sandblast or abrade concrete, masonry and stone surfaces if possible. Vacuum or clean with compressed air to remove dust before injecting.

MIXING

The two-cartridge system provides accurate and convenient dispensing of the adhesive. Manual or air-powered dispensing guns force resin and hardener through the static mixing wand and makes application of a uniform bead of mixed adhesive fast and easy.

DISPENSING

1. Place the cartridge set in the gun—push the back of the cartridges against the spring-loaded center locator and drop the front of the cartridge set into the vertical slot at the head of the gun. Push the plungers in to contact the back of the plunger seals inside the cartridge barrels. Be sure the plungers are seated against the centers of the seals and not caught on the seal lip.
2. Remove the locknut and plugs from the cartridge spouts. Equalize the level of resin and hardener in the cartridges by squeezing the trigger until a small amount of both resin and hardener are dispensed. This assures that the first adhesive through the mixing wand will be at the correct ratio. Mix the waste resin and hardener and dispose of it after it has cured.
3. Place the mixing wand over the spouts and secure it with the locknut. Cut the tip for the appropriate size for the injection port or crack.
4. Dispense the adhesive as needed. **CAUTION:** The cartridge dispensing system is very reliable. However, if the adhesive is cold or is curing in the mixer, increased back-pressure may cause the adhesive to blow by the seal and be dispensed off-ratio. Dispense the adhesive at 60°F or above to assure the proper mix ratio. If the adhesive is left undisturbed in the mixing wand for more than 30 minutes (@72° F) replace the mixing wand.



Pro-Set Inc.
P.O. Box 656
Bay City, MI 48707 USA
888-377-6738
prosetepoxy.com

PRO-SET is a registered
trademark of Pro-Set Inc.

ISO 9001:2000 certified

April 2010



APPLICATION

Inject the mixed adhesive into the cracks or injection ports. Use enough adhesive to ensure complete filling of any gaps in the crack. Use low to moderate injection pressure with masonry or hollow concrete structures. Inject from the bottom port toward the top port of a vertical crack.

CURING

After mixing, the adhesive will cure to a solid state in 2 to 6 hours. The dimensions of the crack, thereby the mass of the adhesive, will determine the actual cure rate. Larger mass cures more quickly than a smaller mass. After 5 days at 72° F, the material is considered fully cured. Higher temperatures will accelerate the cure while lower temperatures will retard the cure.

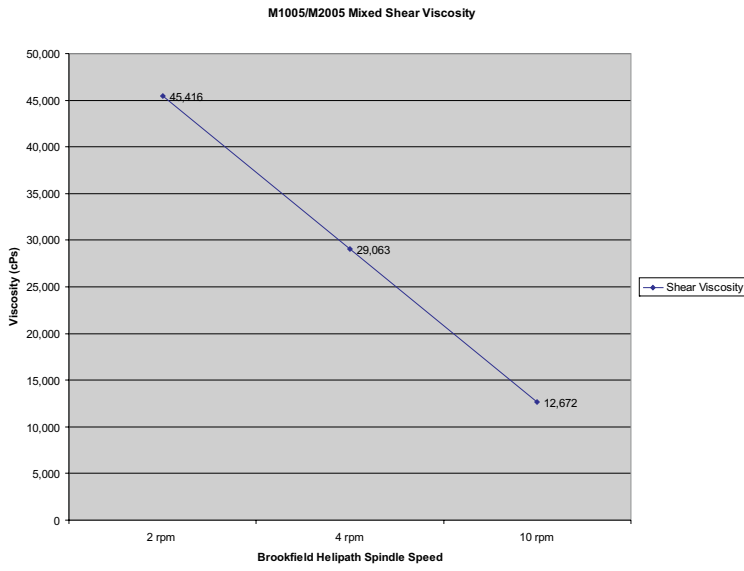
We recommend testing any product using proposed materials and procedures to confirm working and curing characteristics under expected use conditions.

HANDLING CHARACTERISTICS *(Not for specification purposes)*

- Mix ratio M1005:M2005
- by volume 2:1
- by weight 2.2:1
- Density Mixed 9.7 lb/gal
- Pot Life (ASTM D-2471-94) 100g @ 72° F 30 min.
- Cure Time 1/16" glue line @ 72° F 8 hrs.
- Color Mixed Translucent Green

PHYSICAL PROPERTIES

- Compression Yield (psi) ASTM D-695 11,927
- Tensile Strength (psi) ASTM D-638 7,225
- Elongation ASTM D-638 3.5%
- Flexural Strength (psi) ASTM D-790 11,914
- Onset of Tg by DSC 126° F
- Izod Impact (ft lbs/in) ASTM D-256 1.13



All cured properties data based on 2 week cure at 72° F
August 2005