



# DURAL 452 GEL

ASTM C 881 Compliant, High Modulus Epoxy Adhesive

## Description

DURAL 452 GEL is a two-component, 100% solids, non-corrosive, moisture insensitive, high strength epoxy adhesive and binder for numerous applications. This high modulus, structural gel is perfect for bonding applications that require a non-sag adhesive.

## Primary Applications

- Bonding of concrete, masonry, steel, or wood
- Anchoring bolts, dowels, or pins
- Pick-proof sealant for jails/prisons and kennels
- Seals cracks and sets ports prior to injection
- Mix with sand to create a repair mortar

## Features / Benefits

- Exceptional adhesion to construction materials
- Perfect for vertical and overhead applications
- Easy to use 1:1 mix ratio by weight
- Moisture insensitive
- Superior strength
- Non-corrosive

## Technical Information

The following are typical properties obtained under laboratory conditions at 24°C

Property	Result
Gel Time, minutes ASTM C 881	20 - 25
Compressive Strength, MPa ASTM D 695	7 days: 65
Compressive Modulus, MPa ASTM D 695	7 days: 3,103
Bond Strength, MPa ASTM C 882	2 days: 15.0 14 days: 17.0
Heat Deflection Temperature ASTM D 648	54°C
Water Absorption @ 24 hours, % ASTM D 570	< 0.4
Appearance/Colour	Dark Grey

Reinforcing Steel				Threaded Rod			
Rebar Diameter	Hole Diameter	Embedment Depth	Pull-Out Strength*	Rod Diameter	Hole Diameter	Embedment Depth	Pull-Out Strength*
13 mm	16 mm	11.4 cm	71.3 kN	10 mm	13 mm	8.9 cm	28.4 kN
16 mm	19 mm	14.0 cm	121.8 kN	13 mm	16 mm	11.4 cm	58.3 kN
19 mm	22 mm	16.5 cm	153.5 kN	16 mm	19 mm	14.0 cm	118.6 kN
22 mm	25 mm	19.1 cm	203.6 kN	19 mm	22 mm	16.5 cm	152.0 kN
25 mm	29 mm	22.9 cm	247.4 kN	22 mm	25 mm	19.1 cm	190.9 kN
-	-	-	-	25 mm	29 mm	24.1 cm	257.1 kN

\* Direct tension pull-out strengths were obtained at 7 days, in accordance with ASTM E 488-10.

## Packaging

DURAL 452 GEL is packaged in 5 kg and 10 kg units. The mix ratio is 1:1 by weight.

## Shelf Life

2 years in original, unopened containers

## Specifications/Compliances

DURAL 452 GEL complies with ASTM C 881-10 Types I, II, IV and V, Grade 3, Class C

## Coverage

For anchoring, 1L yields 0.001 m<sup>3</sup> of epoxy. 1L of neat DURAL 452 GEL epoxy mixed with 1L of dry 20/40 mesh silica sand will yield approximately 1580 cm<sup>3</sup> of mortar.

Note: Coverage rates are approximate. Actual coverage depends on temperature, texture, and substrate porosity

## Directions for Use

**Surface Preparation:** The surface must be structurally sound, dry, clean and free of grease, oil, curing compounds, soil, dust and other contaminants. Surface laitance must be removed. Concrete surfaces must be roughened and made absorptive, preferably by mechanical means, and then thoroughly cleaned of all dust and debris. If the surface was prepared by chemical means (acid etching), a water/baking soda or water/ammonia mixture, followed by a clean water rinse, must be used for cleaning, in order to neutralise the substrate. Allow substrate to dry before application. Route cracks and blow dust/debris from them with oil-free compressed air. Following surface preparation, the strength of the surface can be tested if quantitative results are required by project specifications. An elcometer or similar tensile pull tester may be used in accordance with ASTM D 4541, and the tensile pull-off strength should be at least 1.7 MPa. When coating steel, all contamination should be removed and the steel surface prepared to a “near white” finish using clean, dry blasting media.

**Mixing:** Mix units of DURAL 452 GEL using a low-speed drill and a mixing paddle. Pre-mix Part A and Part B separately for approximately 1 minute each. Combine Part A and Part B in a 1 to 1 ratio by weight, then mix thoroughly for 3 to 5 minutes.

To make DURAL 452 GEL mortar, gradually add clean, dry, 20/40 mesh silica sand to previously mixed DURAL 452 GEL epoxy and mix thoroughly for 3 to 5 minutes. The mix ratio of aggregate to mixed epoxy is approximately 1 to 1 by weight, but can be modified depending on the desired consistency of the mortar.

Scrape the bottom and sides of the containers at least once during mixing. Do not scrape bottom or sides of the container once mixing operations have ceased; doing so may result in unmixed resin or hardener being applied to the substrate. Unmixed resin or hardener will not cure properly. Do not aerate the material during mixing. To keep aeration to a minimum, using the recommended mixing paddles.

**Application:** Bonding fresh concrete to hardened concrete: Apply by brush, roller, or squeegee to the prepared, existing concrete substrate. Place fresh concrete onto the DURAL 452 GEL while it is still tacky. The open time is typically 3 to 4 hours at 24°C. The open time is reduced at warmer temperatures. If the DURAL 452 GEL loses tackiness or exceeds open time, abrade the surface of the epoxy, wipe surface clean, re-apply DURAL 452 GEL, and proceed. **DO NOT PLACE CONCRETE OVER DRIED EPOXY.** Bonding hardened concrete to hardened concrete: Apply by spatula, brush, or trowel. Ensure the surfaces to be joined have uniform coatings of DURAL 452 GEL. For optimum results, the bond line should not exceed 3 mm. Join surfaces and hold or clamp firmly until the epoxy gels. Ideally, a small amount of adhesive should exude from the joint. Surfaces must be mated while the adhesive is still tacky. Anchoring bolts, dowels, pins: DURAL 452 GEL can be used neat or as a mortar to grout vertically-aligned anchors (into a horizontal substrate) or horizontally-aligned anchors (into a vertical substrate). The anchor hole should be free of all debris before grouting. The optimum hole size is 1.6 mm annular space (3.2 mm larger diameter than anchor diameter). Depth of embedment is typically 10 to 15 times anchor diameter.

**Patching and repairs:** Apply DURAL 452 GEL neat as a primer coat to the prepared concrete surface. Mix the DURAL 452 GEL into an epoxy mortar and apply to the area by trowel or spatula in lifts of 25 to 40 mm before the neat primer

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coat becomes tack free. Allow each lift to reach initial set before applying subsequent lifts.

Setting ports & sealing cracks: Place a small amount of mixed DURAL 452 GEL on the back of the port and carefully place it centered over the crack. Be careful to not fill the hole of the injection port. Place neat DURAL 452 GEL over the face of the cracks to be pressure injected, and around each injection port. Allow DURAL 452 GEL to sufficiently harden before injecting, to prevent blowouts.

## Clean Up

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Clean tools and application equipment immediately with acetone, xylene, or MEK. Clean spills or drips with the same solvents while still wet. Hardened DURAL 452 GEL will require mechanical abrasion for removal.

## Precautions / Limitations

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- Store DURAL 452 GEL indoors, protected from moisture, at temperatures between 10°C and 32°C
- Surface and ambient temperature during applications should be between 10°C and 32°C
- Material temperatures should be at least 10°C and rising
- Working time and cure time will decrease as the temperature increases, and will increase as the temperature decreases
- Do not thin DURAL 452 GEL
- DURAL 452 GEL will discolour upon prolonged exposure to ultraviolet light and high-intensity artificial lighting.
- DURAL 452 GEL is not to be used as a finished/aesthetic coating
- Do not use DURAL 452 GEL for overhead anchoring
- In all cases, consult the product Safety Data Sheet before use

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