

PRODUCT DESCRIPTION

Akona® Fast-Setting Anchoring Epoxy is a two-component, non-sag, 100% solids, high-performance, moisture tolerant epoxy adhesive designed for anchoring bolts and rebar steel into concrete and for bonding or repairing a variety of household and common building materials including concrete, porous tile, and stone. Because it is resistant to moisture during and after curing, it is ideal for stopping air and water leaks. Gray in color. Maximum width 1/8 in. (3 mm) annular, depth is limited by diameter of anchor

WHEN/WHERE TO USE

- Most household and building materials including concrete, tile, stone
- For horizontal and vertical repairs
- Fills defects in concrete floors, walls, driveways, stairs, and patios
- Bonds loose or cracked tiles
- Secures railings or posts
- Stops air and water leaks
- For setting anchor bolts, dowels, and rebar in concrete and masonry

ADVANTAGES

- High-strength
- Resists chemicals and solvents
- Moisture tolerant
- Fits standard caulking gun
- Non-shrink
- Fast-setting:
 - ⇒ Initial set time of in as little as 12-14 min.
 - ⇒ Initial cure time of 2 hr.
 - ⇒ Final cure of 12-16 hr.
- Non-sag
- Excellent adhesion

AVAILABLE SIZE

8.45 oz. (250 mL) tube (BOM #120438)

Shelf Life	One year - unopened and properly stored
Storage Conditions	Store dry at 50°-95°F (10°-35°C) Protect from freezing

Helpful Items:



Safety Glasses



Gloves



Caulk Gun

COVERAGE

- 8.45 oz. tube yields approximately 30 lin. ft. (9.1 m) at 1/8 in. x 1/8 in. (3x3 mm) line

Rebar Size	Hole Diameter	Hole Depth	Anchors per 8.45 fl. oz. Tube
3/8"	7/16"	3 3/8"	43
3/8"	7/16"	5 5/8"	27
1/2"	9/16"	4 1/2"	23
1/2"	9/16"	7 1/2"	13
5/8"	3/4"	5 5/8"	9
5/8"	3/4"	9 5/8"	5
3/4"	7/8"	6 3/4"	6
3/4"	7/8"	11 1/4"	3
1"	1-1/8"	9"	3
1 1/4"	1 3/8"	11 1/4"	1

TYPICAL CHARACTERISTICS

- Mix ratio: 1 part A : 1 part B by volume
- Mixed color: gray
- Gel Time: 2 oz. (60 g) mass: 14 minutes at 77°F (25°C)
- Gel Time: 1 oz. (30 g) mass: 30 minutes at 77°F (25°C)
- Tensile Strength: ASTM D-412: 4,500 psi (31 MPa)
- Elongation: ASTM D-412: 6%
- Water Absorption: ASTM D-570: 0.37% at 7 days
- Compressive Strength: ASTM D-695: 10,000 psi (68.9 MPa) at 7 days

PREPARATION

Air and surface temperature must be 40°F (5°C) or above. Minimum age of concrete must be 21-28 days from date of placement depending upon curing and drying conditions.

Prepare all anchor holes prior to placement of Fast-Setting Anchoring Epoxy. Drill the hole to the correct diameter and depth to suit the anchor, using a rotary percussion drill and carbide-tipped bit. Hole diameter is typically 1/8 in. (3 mm) greater than the anchor diameter and hole depth is typically nine times anchor diameter.

Surface to be bonded must be clean and sound. Remove dust, dirt, grease, curing compounds laitance, and other foreign



matter by sandblasting, hydro blasting, or mechanical abrasion. For drilled holes and cracks, clean with a nylon bristle brush. Remove all water and dust with clean compressed air prior to installation.

MIXING

Condition material to 65°F-85°F (18°C-29°C) before using. Unscrew and remove protective cap, attach the static mixer nozzle to the cartridge. Load cartridge in standard caulking gun and dispense a bead of epoxy until a uniform, non-streak color. The first two or three dispenses are used to remove air and ensure the correct mixing ratio, this material must be discarded. The cartridge is now ready to use. When the work is interrupted, the static mixer can remain on the cartridge after the gun pressure has been relieved. Work quickly, once material hardens in the nozzle, a new nozzle must be used.

APPLICATION

STRUCTURAL BONDING: Apply neatly and work into substrate. The glue line should not exceed 1/8 in. (0.3cm).

ANCHORING: Dispense the epoxy into the anchoring hole filling from the bottom up. The annular space around the bolt, dowel or anchor should not exceed 1/8 in. (0.3 cm). Insert the bolt, dowel, rebar, or rod to be anchored, turning it slowly, making sure all the rods are thoroughly coated. Adjust to the correct position within the stated working time. After insertion, the hole should be completely full of epoxy. Any excess resin should be expelled from the hole evenly around the anchor showing that the hole is full. Excess resin should be removed before it hardens.

CURING

The rate of cure is dependent on the amount of material used and the temperature at which it is applied. Gel time is 30 minutes for 1 oz. (30 g) and 14 minutes for 2 oz. (60 g), at 77°F (25°C). At temperatures below 77°F (25°C) this product will take proportionately longer time to cure. At temperatures above 77°F (25°C) it will take a proportionately shorter time to cure. Initial cure in 2 hours. Reaches final cure in 12-16 hours. Allow to cure until the epoxy is hard to the touch.

CLEAN UP

Wipe clean tools and equipment before epoxy sets, once cured it can only be mechanically removed. Use xylene or Akona Concrete / Masonry Restoration Cleaner to assist in cleaning.

FOR BEST RESULTS

- For professional use only
- Wear chemical resistant gloves and protect eyes and skin during use
- Per NTSB Safety Recommendations, the use of adhesive anchors is prohibited in sustained overhead load anchoring applications
- Always test a small amount to insure that the product is mixed thoroughly and that the material will harden properly before proceeding
- Do not thin with solvents
- Surface and ambient temperature must be 40°F (5°C) or above
- For applications with constant high temperature (above 120°F/49°C), contact Akona Mfg., LLC
- Do not expose stored product to cold or freezing temperature (below 35°F/ 2°C) for any length of time
- High temperature will accelerate the setting time and cool temperature will slow the setting time. As a general rule, the gel time of the epoxy will be cut in half for each 10°-15° increase in temperature above 75°F and the gel time will double for each 10°-15° drop below 75°F (24°C)
- Minimum age of concrete must be 21-28 days, depending on curing and drying conditions
- Not for sustained long-term loads, or over-head anchoring

Proper application and installation of all AKONA products are the responsibility of the end user.

WARNING

Read SDS prior to using this product. Corrosive. May cause eye, skin, and respiratory irritation. Avoid contact with eyes and skin. If contact with eyes occurs, flood eyes repeatedly with clean water and see a physician immediately. Do not rub eyes. Wash hands thoroughly after handling or before eating with warm, soapy water. Do not take internally. Use in a well-ventilated area. Keep out of reach of children.

WARRANTY

Seller warrants that its product will conform to and perform in accordance with the product specifications. The foregoing warranty is in lieu of all other warranties, expressed or implied, including, but not limited to those concerning merchantability and fitness for a particular purpose. Because of the difficulty in ascertaining and measuring damages hereunder, it is agreed that, Seller's liability to the Buyer shall not exceed the total amount billed and billable to the Buyer for the product hereunder.

WARNING: INJURIOUS TO EYES

KEEP OUT OF REACH OF CHILDREN

PROTECT FROM FREEZING

WARNING: DO NOT INGEST