EPOXY CRACK REPAIR

Two-component epoxy designed for injection into cracks in structural materials

1. PRODUCT NAME

Akona® Epoxy Crack Repair

2. MANUFACTURER

TCC Materials®
2025 Centre Pointe Blvd.
Mendota Heights, MN 55120 USA
Phone: 1.651.688.9116
Web: tccmaterials.com

3. PRODUCT DESCRIPTION

Akona Epoxy Crack Repair is a two-component, low-viscosity, 100% solids, epoxy repair product designed for injection into cracks in structural materials including concrete and bricks, for the purpose of bonding and sealing them. Color will be clear to light yellow. Designed for filling narrow cracks with maximum width of ¼ in. (6 mm) to a maximum depth of 6 in. (150 mm).

Features and Benefits

- High-strength - stronger than concrete
- Low-viscosity - easy to inject and flows well into small cracks
- Moisture tolerant and blocks moisture
- Fits standard caulking tube
- No mess - self mixing

When/Where to Use

- Horizontal repairs
- Interior and exterior
- Stops air and water leaks
- Secures railings, bolts, and rebar
- Repairs foundation cracks
- Sets injection ports

4. TECHNICAL DATA

Typical Values • Akona Epoxy Crack Repair	
Color	Clear, light yellow
Solids (%)	100
Compressive strength (ASTM D695)	11,000 psi (75.8 MPa)

Available Sizes

- 6 oz. tube (BOM #120439)

Coverage

Each 6 oz. tube yields approximately 10-11 cu. in. (163-180 cm^3)

5. INSTALLATION

Preparation

Read all directions before starting work. Proper surface preparation is crucial to achieving a successful application.

1. Always remove all loose and unsound materials. Thoroughly clean all surfaces of dirt, dust, grease, or other contaminants which could interfere with bonding. Surfaces should be as smooth as possible before installation.
2. For better adhesion concrete surfaces should be dry and cured a minimum of 21-28 days from date of placement depending upon curing and drying conditions. Surface and ambient temperature must be 40°F (5°C) or above.
3. Product has a low viscosity and will penetrate into the cracks, the base of cracks or underside of slabs may need to be sealed prior to application. For best results, taping on each side of a crack will give finished repair a cleaner appearance.

Note: It is the responsibility of the installer/applicator to ensure the suitability of the product for its intended use.

Mixing

- Before using, condition material to 65°F-85°F (18°-29°C). Use cartridge in standard caulking gun.
- Unscrew and remove both protective cap and plug from the cartridge. Insert the flow restrictor, attach the static nozzle mixer and tighten nut. Load cartridge into standard caulking gun.
- Dispense a bead of epoxy until the color is uniform. 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.

Application

- As a gravity-fed crack filler, create a vee-notched crack and slowly inject the epoxy into the crack, filling the crack completely.
- Disperse with deliberate slow and even pressure to allow proper blending of the resin and hardener in the static mixing nozzle. This material will be very fluid, dispersion that is too fast or with too much pressure can cause an uneven mix that may not properly harden.
- As a crack injection, set appropriate injection ports, then seal ports and surface of crack with Epoxy Crack Repair. When the epoxy seal has cured, slowly and steadily inject Epoxy Crack Repair into injection ports.
- 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. Cartridge should remain upright to reduce the risk of material draining from the nozzle.

Curing

Epoxy Crack Repair has a pot life of 3 hours (60g) 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. Thin layers (5 mil) will become tack-free in approximately 3½ hours at temperatures of 77°F (25°C).

Clean Up

Epoxy Crack Repair should be wiped clean before it cures. Once cured, epoxy crack repair can only be mechanically removed. Avoid getting epoxy on skin.

Limitations

- For professional use only.
- Follow all industry standard safety procedures when handling, such as chemical resistant gloves, eye and skin protection.
- Subject to discoloration upon exposure to UV light.
- Not for use in cracks subject to hydrostatic pressure.
- Maximum crack width is ¼ in. (6 mm).
- Maximum crack depth is 6 in. (150 mm).
- Do not add solvents or fillers to change viscosity of the product.
- 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.
- Surface and ambient temperature must be 40°F (5°C) or above.
- For applications with constant high temperature (above 120° F/49°C), contact TCC Materials.
- Do not expose stored product to cold or freezing temperature (below 35°F/ 2°C) for any length of time.

Safety

READ THE SAFETY DATA SHEET (SDS) BEFORE USING THIS PRODUCT. SDS information is available on our website: tccmaterials.com

Cautions

Read complete cautionary information printed on product container prior to use.

This Product Data Sheet has been prepared in good faith on the basis of information available at the time of publication. It is intended to provide users with information about and guidelines for the proper use and application of the covered Akona brand product(s) under normal environmental and working conditions. Because each project is different, TCC Materials cannot be responsible for the consequences of variations in such conditions, or for unforeseen conditions.

6. AVAILABILITY

To locate Akona products in your area, please contact:
Phone: 1.651.688.9116
Email:: info@tccmaterials.com

7. 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.

Shelf Life	Best when used within 18 months in original, unopened container.
Storage Conditions	Store dry, cool (35°F-<95°F/2°C-<35° C), out of direct sunlight.
Color	Clear to light yellow

KEEP PRODUCT IN CONTAINER FROM FREEZING

WARNING: INJURIOUS TO EYES

KEEP OUT OF REACH OF CHILDREN

TCC MATERIALS
SPEC BLENDED CONSTRUCTION PRODUCTS

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