



# DURAL FAST SET GEL

## RAPID-SETTING, NON-SAG, HIGH MODULUS EPOXY ADHESIVE

### PACKAGING

4 gal (15 L) unit  
Code: TD5323104NC

10 gal (38 L) unit  
Code: TD5323110NC

22 oz (650 mL) dual cartridge  
(case of 12)  
Code: TD5323122NC

10 oz (300 mL) single cartridge  
(case of 24)  
Code: TD5323115NC

### CLEAN UP

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

### SHELF LIFE

2 years in original, unopened package

### SPECIFICATIONS AND COMPLIANCES

- Complies with ASTM C881 Types I and IV, Grade 3, Classes B and C
- Meets the requirements of AASHTO M 235
- Canadian MTQ

### DESCRIPTION

DURAL FAST SET GEL is a two-component, 100% solids, moisture insensitive, rapid-setting epoxy adhesive and binder for numerous applications. This high modulus, structural gel is perfect for bonding applications that require a quick turn-around. DURAL FAST SET GEL can be used in temperatures as low as 40 °F (4 °C) and rising.

### PRODUCT CHARACTERISTICS

#### FEATURES/BENEFITS

- Exceptional adhesion to construction materials
- Easy to use 1:1 mix ratio
- Moisture insensitive
- Rapid strength gain in a wide temperature range

#### PRIMARY APPLICATIONS

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

#### APPEARANCE

Part A liquid is gray in color and Part B liquid is gray in color.

#### COVERAGE

For anchoring, 1 neat gal (3.8 L) yields 231 in<sup>3</sup> (3,785 cm<sup>3</sup>) of epoxy. 1 gal (3.8 L) of neat DURAL FAST SET GEL epoxy mixed with 1 gal (3.8 L) of dry 20/40 mesh silica sand will yield approximately 368 in<sup>3</sup> (6,030 cm<sup>3</sup>) of mortar.

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

## TECHNICAL INFORMATION

The following are typical values obtained under laboratory conditions. Expect reasonable variation under field conditions.

Test Method	Test Property	Result
ASTM C881	Consistency	1/8" (3.2 mm)
ASTM C881	Gel Time	8 minutes
ASTM C882	Bond Strength	2 days: 2,600 psi (17.9 MPa) 14 days: 3,000 psi (20.7 MPa)
ASTM D570	Water Absorption	24 hours: 0.3%
ASTM D648	Heat Deflection Temperature	145 °F (62 °C)
ASTM D2566	Linear Coefficient of Shrinkage	0.001
ASTM D695	Compressive Yield	1 hour: 4,000 psi (27.5 MPa) 4 hour: 6,950 psi (47.9 MPa) 8 hour: 11,400 psi (78.6 MPa) 7 days: 12,500 psi (86.2 MPa)
ASTM D695	Compressive Modulus	7 days: 450,000 psi (3,103 MPa)
ASTM D638	Tensile Strength	7 days: 7,250 psi (50.0 MPa)
ASTM D638	Elongation at Break	1.5%

Reinforcing Steel				Threaded Rod			
Rebar Diameter	Hole Diameter	Embedment Depth	Pull-Out Strength*	Rebar Diameter	Hole Diameter	Embedment Depth	Pull-Out Strength*
#4: 1/2"(13 mm)	5/8"(16 mm)	4.5"(11.4 cm)	20513 lbf (91 kN)	3/8" (10 mm)	1/2" (13 mm)	3.5" (8.9 cm)	8722 lbf (39 kN)
#5: 5/8"(16 mm)	3/4"(19 mm)	5.5"(14.0 cm)	30591 lbf (136 kN)	1/2" (13 mm)	5/8" (16 mm)	4.5" (11.4 cm)	20851 lbf (93 kN)
#6: 3/4"(19 mm)	7/8"(22 mm)	6.5"(16.5 cm)	42912 lbf (191 kN)	5/8" (16 mm)	3/4" (19 mm)	5.5" (14.0 cm)	33072 lbf (147 kN)
#7: 7/8"(22 mm)	1"(25 mm)	7.5"(19.1 cm)	55180 lbf (245 kN)	3/4" (19 mm)	7/8" (22 mm)	6.5" (16.5 cm)	42092 lbf (187 kN)
#8: 1"(25 mm)	1 1/8"(29 mm)	9"(22.9 cm)	67395 lbf (300 kN)	7/8" (22 mm)	1" (25 mm)	7.5" (19.1 cm)	59520 lbf (265 kN)
-	-	-	-	1" (25 mm)	1 1/8" (29 mm)	9.5" (24.1 cm)	71117 lbf (316 kN)

\*Direct tension pull-out strengths were obtained at 7 days, in accordance with ASTM E488.

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## 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 neutralize 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 D4541, and the tensile pull-off strength should be at least 250 psi (1.7 MPa). When DURAL FAST SET GEL is being mixed to a mortar consistency and then used to perform patching and repairs, provide a CSP of 3 to 5 in accordance with ICRI 310.2. When coating steel, all contamination should be removed and the steel surface prepared to a “near white” finish (SSPC SP10) using clean, dry blasting media.

**Mixing:** Mix bulk units of DURAL FAST SET 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 1:1 ratio by volume, then mix thoroughly for 3 minutes.

To make DURAL FAST SET GEL mortar, gradually add clean, dry, 20/40 mesh silica sand to previously mixed DURAL FAST SET GEL epoxy and mix thoroughly for 1 to 2 minutes. The mix ratio of aggregate to mixed epoxy is approximately 1:1 by volume, 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, the recommended mixing paddles are #P1 and #P2 as found in ICRI Guideline 320.5R-2014.

**Application: Bonding hardened concrete to hardened concrete:** Apply by spatula, brush, or trowel. Ensure the surfaces to be joined have uniform coatings of DURAL FAST SET GEL. For optimum results, the bond line should not exceed 1/8” (3.2 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 FAST SET 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 1/16” (1.6 mm) annular space (1/8” (3.2 mm) larger diameter than anchor diameter). Depth of embedment is typically 10 to 15 times anchor diameter. **Patching and repairs:** Apply DURAL FAST SET GEL neat as a primer coat to the prepared concrete surface. Mix the DURAL FAST SET GEL into an epoxy mortar and apply to the area by trowel or spatula in lifts of 1” to 1-1/2” (25 to 38 mm) before the neat primer 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 FAST SET 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 FAST SET GEL over the face of the cracks to be pressure injected, and around each injection port. Allow DURAL FAST SET GEL to sufficiently harden before injecting, to prevent blowouts. **Pick-proof sealant:** Apply a bead of DURAL FAST SET GEL to the joints and areas being sealed. Strike off the epoxy with a rounded spatula, or similarly rounded tool, to finish.

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## PRECAUTIONS/LIMITATIONS

- Store DURAL FAST SET GEL indoors, protected from moisture, at temperatures between 50 °F and 90 °F (10 °C and 32 °C)
- Surface and ambient temperature during applications should be between 40 °F and 90 °F (4 °C and 32 °C)
- Material temperatures should be at least 40 °F (4 °C) and rising
- Install cartridges of DURAL FAST SET GEL with a high quality, professional grade gun with a gear ratio of at least 26:1 for ease of application and best results
- Working time and cure time will decrease as the temperature increases, and will increase as the temperature decreases
- Do not thin DURAL FAST SET GEL
- DURAL FAST SET GEL will discolor upon prolonged exposure to ultraviolet light and high-intensity artificial lighting.
- DURAL FAST SET GEL is not to be used as a finished/aesthetic coating
- Do not use DURAL FAST SET GEL for overhead anchoring
- Maximum application thickness of DURAL FAST SET GEL mortar is 1.5” per lift.
- In all cases, consult the product Safety Data Sheet before use

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