

## BONDING AGENTS AND ADHESIVES

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# DURAL 452 LV

ASTM C881 COMPLIANT, LOW VISCOSITY, HIGH MODULUS EPOXY ADHESIVE **EUCLID CHEMICAL**

## PACKAGING

0.75 gal (2.8 L) unit

Code: 002DL 01

3 gal (11.4 L) unit

Code: 002DL 03

15 gal (56.8 L) unit

Code: 002DL 15

15.2 oz (450 mL) dual cartridge  
(case of 12)

Code: 002DL 98

## 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 452 LV 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 1, Class C
- Meets the requirements of AASHTO M 235
- Canadian MTQ

## DESCRIPTION

DURAL 452 LV is a two-component, 100% solids, moisture insensitive, high strength epoxy adhesive and binder for numerous applications. This high modulus, low viscosity epoxy resin is the perfect solution for general bonding applications and for injecting cracks in concrete and a variety of other substrates.

## PRODUCT CHARACTERISTICS

### FEATURES/BENEFITS

- Exceptional adhesion to construction materials
- Low viscosity penetrates deep into cracks
- Easy to use 2:1 mix ratio
- Moisture insensitive
- Tenacious bond strength

### PRIMARY APPLICATIONS

- Bonding of concrete, masonry or wood
- Injection resin for cracked, structural substrates
- Gravity feed or pressure inject cracks in concrete slabs
- Anchoring bolts, dowels, or pins
- Mix with dried silica sand to create a repair mortar

### APPEARANCE

Part A liquid is colorless and Part B liquid is amber in color.

### COVERAGE

For injection, 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 452 LV epoxy mixed with 3 gal (11.4 L) of dry 20/40 mesh silica sand will yield approximately 643 in<sup>3</sup> (10,537 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 D2556	Mixed Viscosity, cp	450
ASTM C881	Gel Time	34 minutes
ASTM C882	Bond Strength	2 days: 1,300 psi (9.0 MPa) 14 days: 1,750 psi (12.1 MPa)
ASTM D570	Water Absorption	24 hours: 0.1%
ASTM D648	Heat Deflection Temperature	120 °F (50 °C)
ASTM D2566	Linear Coefficient of Shrinkage	0.003
ASTM D695	Compressive Yield	7 days: 15,500 psi (106.9 MPa)
ASTM D695	Compressive Modulus	7 days: 600,000 psi (4,137 MPa)
ASTM D638	Tensile Strength	7 days: 7,250 psi (50.0 MPa)
ASTM D638	Elongation at Break	1.5%

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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 452 LV 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: Pressure injection applications:** DURAL 452 LV will be mixed by the two-component pressure injection equipment, which uses a static mixing nozzle to combine material just prior to injection. Parts A and B of bulk units of DURAL 452 LV are placed in their separate tanks/hoppers of the two-component pressure injection equipment, and are pumped through separate lines until they reach the static mixing nozzle, which then mixes the material appropriately prior to injection.

**Poured by hand or dispensed with a bulk gun applications:** Mix bulk units of DURAL 452 LV 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.

**Mortar applications:** Gradually add clean, dry, 20/40 mesh silica sand to previously mixed DURAL 452 LV epoxy and mix thoroughly for 3 to 5 minutes. The mix ratio of aggregate to mixed epoxy is approximately 3:1 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 or #P2 as found in ICRI Guideline 320.5R-2014.

**Application: Pressure injecting vertical cracks:** Attach injection ports and seal the face of the crack with DURAL 452 GEL or DURAL FAST SET GEL. Allow the sealing gel to sufficiently harden before injecting, to prevent blowouts. Pump DURAL 452 LV into the crack via the injection ports, using two-component pressure injection equipment. Start at the bottom of the crack and work upwards from port to port. Cap off ports as you proceed up the crack to ensure that DURAL 452 LV is kept contained within the crack. DO NOT INJECT IF WATER IS LEAKING FROM THE CRACK. **Horizontal cracks:** Open cracks by mechanical means and ensure that the prepared crack is free of all debris and standing water. If pressure injecting, instructions are the same as for vertical cracks. If gravity feeding, pump DURAL 452 LV until cracks are completely filled. If working on an elevated slab, ensure the bottom of the slab is sealed prior to injecting or gravity feeding the crack, to ensure epoxy does not leak through. **Anchoring bolts, dowels, pins:** DURAL 452 LV can be used neat or as a mortar to grout vertically-aligned anchors (into a horizontal 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 452 LV neat as a primer coat to the prepared concrete surface. Mix the DURAL 452 LV 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.

## PRECAUTIONS/LIMITATIONS

- Store DURAL 452 LV 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 50 °F and 90 °F (10 °C and 32 °C)
- Material temperatures should be at least 50 °F (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 LV
- DURAL 452 LV will discolor upon prolonged exposure to ultraviolet light and high-intensity artificial lighting.
- DURAL 452 LV is not to be used as a finished/aesthetic coating
- Do not use DURAL 452 LV for horizontally-aligned anchors (into a vertical substrate)
- Do not use DURAL 452 LV for overhead anchoring
- Maximum application thickness of DURAL 452 LV mortar is 1.5" per lift.
- In all cases, consult the product Safety Data Sheet before use

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