
Type:	Two-component, low viscosity, epoxy resin / hardener.
Primary Use:	Bonding plastic (fresh) concrete to hardened concrete. Bonding rigid construction materials to themselves or each other. Anchoring bolts, dowels and rebar into concrete, masonry or stone.
Substrates:	Concrete, masonry, stone (dry, damp and wet), steel and sealed wood. Suitable for horizontal surfaces and vertical, downward oriented holes.
Minimum Temp:	Installation- 40 F, Cure- 40 F (substrate temperature).
Special Feature:	Adjustable working life and viscosity by blending with compatible products.
ASTM C 881:	Meets the requirements for bonding agents in load bearing applications.
Shelf Life:	Three years minimum in sealed containers (see below for conditions).

The properties listed in this bulletin are typical and descriptive of the product and should not be used for specification purposes. For specification preparation, reference the specification of this product available from ChemCo Systems, Inc. This product is available only through KIP System licensee/applicators.

Description: KEMKO 008, SP Bonder is a two-component, short potlife, structural, epoxy liquid adhesive designed for application on horizontal surfaces and in vertical, downward oriented holes. Primary uses include the structural bonding of plastic (fresh) concrete to hardened (existing) concrete, bonding of rigid construction materials, e.g., hardened concrete, masonry, stone, steel and sealed wood to themselves or each other and anchoring bolts, dowels and rebar into vertical, downward oriented holes in concrete, masonry or stone. The product is designed for bonding and grouting applications requiring short set times and bending fresh to existing concrete at low ambient temperatures. KEMKO 008 bonds to dry, damp and wet (no free standing water) substrates. The components do not contain volatile organic compounds (VOC's).

Features: The physical properties of the product allow its use in applications requiring resistance to creep and stress relaxation, maintenance of mechanical properties at high ambient temperatures and high load bearing strength. Exceptional substrate wetting and water displacement properties ensure excellent adhesion under adverse application conditions, e.g., cold, wet concrete. The working life/cure time of KEMKO 008, SP Bonder may be increased, if required, by preblending the Part B with the Part B of the long potlife liquid product, KEMKO 001, LP Bonder. The viscosity of KEMKO 008, SP Bonder may be increased by blending the mixed product with mixed companion paste product, KEMKO 009, SP Paste. The long and short potlife and bender and paste forms of the product (KEMKO 001, 008, 009 and 028) employ a 2:1 (by vol.) mixing ratio that must be maintained at all times.

Limitations: The recommended minimum substrate temperature during installation and for cure is 40 deg F. (For installation and cure at high ambient and substrate temperatures or when a longer work life is needed, use KEMKO 001, LP Bonder.) The maximum in-service temperature should not exceed 20 deg F below the HDT in bonding applications subjected to substantial and sustained shear stresses that may cause creep. When bonding plastic concrete containing resinous admixtures, establish the suitability of the concrete mix before actual use. Do not add solvents or otherwise thin this material.

Packaging: Standard package sizes of Part A + Part B are 3, 15 and 150 gallon units.

Shelf Life: Three years minimum in unopened, original containers when stored between 60 and 90 deg F in a dry place away from

sunlight. Remixing of components may be required upon prolonged storage.

Chemical Resistance: KEMKO 008, SP Bonder has excellent resistance to a wide range of commonly encountered chemicals including acids and bases, aircraft and automotive fluids, petroleum fuels, cutting oils, etc. It has limited resistance to hydrocarbon solvents. Performance is a function of the specific chemical and concentration, ambient and solution temperatures, exposure times and housekeeping procedures. For information on specific chemicals and exposure conditions, contact a ChemCo Systems, Inc., technical representative.

Color Selection: The standard color of the mixed components is concrete gray (blue-gray). Custom colors are available and may require minimum quantities and/or slightly higher cost.

Surface Preparation: Concrete surfaces may be dry, damp or wet (no free standing water) but must be sound and free of all bond inhibiting substances. Prepare surfaces for bonding in accordance with ASTM D 4259, 'Standard Practice for Abrading Concrete,' or ACI 503R, Chapter 5, 'Preparing Surfaces for Epoxy Compound Application,' and ChemCo Systems, Inc.'s specific recommendations. Properly prepared concrete surfaces should have a minimum strength of 250 psi in direct tension. Steel surfaces should be cleaned to 'white metal' according to SSPC SP 5.

Mixing: KEMKO 008 is a two-component adhesive. The resin to hardener (Part A: Part B) mix ratio is 2:1, by volume. Premix the individual components before drawing from bulk packaging. Wear safety glasses and clean neoprene rubber gloves when handling the material. Transfer the appropriate quantities of Part A and Part B into a mixing container. Use quantities that can be applied before the potlife of the material expires. Blend thoroughly using a Jiffy mixer blade attached to a low speed (350-750 rpm) electric or pneumatic drill. Proper mixing will take 2-3 minutes.

Installing: Pour mixed material onto the prepared substrate and spread to the specified coverage with a V-notch trowel, squeegee or paint roller. For large areas, spray application of the material is recommended. When mating two solid surfaces, apply bonding agent to both surfaces. Allow all coated substrate surfaces to rest for 5-10 minutes before pouring fresh concrete or mating with another surface. In plastic to hardened concrete bonding applications, the bond line should be at least 15 mils. Lightweight concrete may require a second coat of adhesive. In other bonding applications, bond line thickness is less critical but

Typical Properties (1)

Property	Test Method	Value		
Mix Ratio, A:B, by vol by wt		2:1 100: 35		
Color: Part A Part B Mixed	VISUAL	White Black Concrete blue-gray		
Weight per Gallon, lb: Part A Part B Mixed	ASTM D 1475	12.1 8.1 10.8		
Viscosity, poise: Part A Part B Mixed	ASTM D 2393	@50 F 300 10 80	@73 F 105 5 40	@105 F 35 1 10
Gel Time, 1 quart, hours	ASTM C 881	0.5	0.3	0.1
Thin Film Properties:				
Open Time, hours	AASHTO T-237	4	3	0.2
Hard Dry Time, hours	ASTM D 1640	24	8	2
Cure Time, days	AASHTO T-237	10	4	1
Tensile Strength, psi	ASTM D 638	6500		
Elongation at Break, %	ASTM D 638	1.5		
Compressive Yield Strength, psi	ASTM D 695	12,000		
Compressive Modulus, psi	ASTM D 695	350,000		
Flexural Strength, psi	ASTM D 790	11,000		
Flexural Modulus, psi	ASTM D 790	450,000		
Heat Deflection Temp., deg F	ASTM D 648	120		
Bond Strength, psi: 2 day cure @ 60 F 14 day cure @ 60 F	ASTM C 882	----- 1500 (2)		

(1) Cure schedule, 7 days at 73 ± 4 F and test temperature, 73 ± 4 F unless otherwise indicated.

(2) Compressive strength of cement mortar, 4500 psi.

should be at least 4 mils above the peaks of the surface profile. For additional application information, see ACI 503R, Chapter 7, "Applying Epoxy Compounds."

Clean-up: All tools and equipment must be cleaned before the mixed material cures. Cleaning can be facilitated with a solvent such as acetone or heavy duty detergents. Cured material may be removed from equipment and tools by soaking in an epoxy stripper.

Handling and Toxicity: This bulletin does not accompany the product when sold. For hazard warnings, safe handling and first aid instructions, READ CAREFULLY THE MATERIAL SAFETY DATA SHEETS AND CONTAINER WARNING LABELS. Part A: Liquid epoxy resin, HMIS Health Hazard Rating- 2 (Moderate Hazard). Warning! Causes eye and skin irritation. May cause allergic skin reaction. Harmful if swallowed. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling. Avoid prolonged or repeated contact with skin. Part B: Liquid epoxy hardener, HMIS Health Hazard Rating- 3 (Serious Hazard). Contains alkaline amines. Danger! Causes severe eye and skin burns. May cause allergic skin and respiratory reaction. Combustible, corrosive. Do not get in eyes or skin or on clothing. Avoid breathing vapor. Keep container closed. Use only with adequate ventilation. Wash thoroughly after handling. Keep away from heat and open flame.

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