

# ADCOPOXY 612

Wet-to-dry adhesive of old-to-new  
concrete structural bonding

ADCO  
Construction-  
and Mining  
Chemicals

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technical data sheet

## DESCRIPTION

ADCOpoxy 612 is a modified, solvent-free two-component structural epoxy adhesive specifically formulated to bond fresh to cured concrete.

## USES

ADCOpoxy 612 is specified for structural bonding of wet to dry concrete, as coating and corrosion inhibitor of steel as well as adhesive of concrete to steel, in concrete repairs and overlays as well as precast operations.

## SURFACE PREPARATION

Surfaces to receive ADCOpoxy 612 shall be clean, dry and sound, free from any oil and laitance, dust or curing agents. Rusted reinforcing steel should be cleaned by wire brushing or sand blasting – concrete surfaces shall be scabbled, scarified or etched to form a mechanically keyed surface. Remove dust with compressed air or vacuum.

## MIXING AND APPLICATION

ADCOpoxy 612 is preferably mixed mechanically using an electric drill and flat paddle, separately mixing the contents of the base and activator cans first before combining the components and mixing for 3 – 5 minutes thoroughly. The adhesive should be a uniform grey colour, free from streaks and lumps. Apply immediately after mixing.

Note : A strong smell of the product is correct.

Apply with a firm bristle brush or wire brush working well into voids and rough areas at a spreading rate of 1 – 3 m<sup>2</sup> per litre. Cast new concrete onto the coated areas within 20 minutes before the adhesive has lost tack (taking ambient conditions into consideration, the casting procedure may have to be adapted). If the adhesive has cured, roughen the surface material and re-apply the adhesive.

Clean all tools and equipment immediately after use with ADCOchem 291.

## PROPERTIES

Mixing Ratio	1 : 1 by volume
Pot Life	±30 minutes, depending on ambient conditions
Practical Cure	72 hrs @ 24°C, full cure at 7 days
Shelf Life	1 year
Storage	do not freeze
Solids Content	>98%
Colour	grey
Application Temp	10°C – 35°C
Service Temp	dry 80°C; wet 60°C
Compressive Strength	>70 MPa
Tensile Strength	>8 MPa

## SAFETY

Contact with the skin should be avoided by wearing gloves and protective clothing. In case of eye contact wash well with warm water and obtain medical advice. The cured material is not toxic.

Remember : Keep away from children, handle responsibly and consider the environment.

## UPDATE

May 2017.

This supercedes all previous documentation.