



Technical Data Sheet

DESCRIPTION	<p>Megapoxy H315 is a rapid set low viscosity, 100% solids, resin based, solvent-free, liquid resin, that can be utilized as a coating or a casting, when fast return to service applications are needed.</p> <p>Megapoxy H315 has excellent static and dynamic mechanical properties, and can be used with the fine aggregates to make a fast set, high strength epoxy mortar.</p> <p>Megapoxy H315 is volatile organic compounds free (Nil V.O.C.)</p>	
RECOMMENDED APPLICATIONS	<ul style="list-style-type: none"> • Concrete Crack Repair • Concrete Repairs • Epoxy Mortars • Coating • Floor Repairs • Low Pressure Injection 	
PROPERTIES		
	Mixing Ratio by Volume	3 Part A to 1 Part B
	Work Time at 25°C:	10 minutes
	Minimum Cure Time at 15°C	8 hours
	Minimum Cure Time at 25°C	4 hour
	Minimum Cure Time at 35°	2 minutes
	Thin Film Cure at 25°C	90 minutes
	Minimum Application Temperature	10°C
	Viscosity Part A at 25°C	1300 - 1900cps
	Viscosity Part B at 25°C	25 - 30cpss
	Mixed Viscosity at 25°C	405cps
	S.G. Part A at 25°C	1.30 -1.40
	S.G. Part B at 25°C	1.30 - 1.40
	Mixed S.G. at 25°C	1.09
	Colour Part A	Clear or N35 Grey
	Colour Part B	Clear
CURED PROPERTIES		
	Compressive Strength - ASTM D695	80Mpa
	Bond Strength Concrete - ASTM D4541	>3Mpa
	Tensile Bond Strength Steel - ASTM D897	20Mpa
	Modulus of Elasticity - ASTM D695	7.5Mpa
	Tensile Bond Strength Steel - ASTM D897	3.09Gpa
	Flexural Strength - ASTM D790	40Mpa
	Tensile Strength - ASTM D638	24Mpa
	Tensile Shear Strength - ASTM D1002	13Mpa
	Hardness - Shore D - ASTM D2240-00	75 minimum

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CHARACTERISTICS	<ul style="list-style-type: none"> • VOC Free • Rapid Setting • Thin Liquid • Mixes easily by hand • Very high strength permanent bonds • Excellent tensile and compressive strengths, superior to concrete • Excellent chemical resistance
SURFACE PREPARATION	<p>Concrete</p> <p>Concrete should be free from grease and oil. If necessary, clean with industrial heavy duty degreaser. When clean, remove surface laitance. This is best done by mechanical abrasion such as scabbling, grit blasting or grinding. If this is not possible acid etching must be carried out. Mix concentrated hydrochloric acid with equal volume of water and spread at the rate of 0.5 litre per square meter of concrete surface. Allow to react for about 10 minutes and wash the area thoroughly and scrub with a stiff bristled broom to remove loose sand. Allow to dry for 24 hours. For maximum adhesion the concrete should be surface dry.</p> <p>Metal Surfaces</p> <p>Metals should be grit blasted to AS CK 9.4 - 1964 Class 3 finish. If this is not possible, mechanically abrade the surface to a clean, bright metal surface. Once this abrasion is complete, degrease the surface by flooding with an industrial grade degreaser. Wire brushing is not entirely satisfactory and gives minimal adhesion only.</p> <p>Coated Surfaces</p> <p>It is recommend to remove all coatings prior to bonding, bonding to coated surfaces will give inferior bond strengths compared to bonding directly to a prepared substrate.</p> <p>Concrete:</p> <p>The surface may be either flame-cleaned, or mechanically treated with a scutching tool, to remove all traces of paint. Complete the preparation by diamond grinding or scabbling.</p> <p>Metals:</p> <p>Steps should be taken to remove all paint and/or galvanizing. Good quality paint stripper should be used, followed by grit blasting or grinding to a bright metal finish.</p>
IMPORTANT INFORMATION	<p>It is essential that the correct mixing ratio be used and that the Part A and Part B are thoroughly mixed together before use. When using the self mixing nozzle, the Megapoxy 36 should be one colour when being applied. Inaccuracies and poor mixing will result in lower physical properties of the cured system and, if the error is sufficiently large, the system may not cure satisfactorily and discolour on ageing.</p>
CLEANING	<p>To keep mixing implements and working tools clean, use Megapoxy Thinners.</p> <p>Use disposable rubber gloves to protect hands and maintain proper industrial hygiene.</p> <p>For further details refer to the Megapoxy 36 Safety Data Sheets.</p>
PACKAGING	<p>Megapoxy 36 is available in 600ml Twin Pack Cartridge, supplied with 1 static mixing nozzle.</p> <p>Extra Static Mixing Nozzles are also available to purchase separately.</p> <p>Product should be stored in cool dry place</p>
TECHNICAL SERVICE	<p>All purchasers of Megapoxy Products, are encouraged to avail themselves of our Technical Service for our Megapoxy Products. The information in this Bulletin is correct at time of publication, however continual research and development is being carried out and specs may change without notice.</p>

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CRACK REPAIR - TREATMENT OF CRACKS

The treatment of cracks in concrete not expected to undergo further movement can be carried out by one of the following methods:

Heat Treatment

The temperature of concrete surrounding the crack is slowly raised to 80°C and the mixed Megapoxy H is applied over the crack as a paint. On cooling the resin will be drawn into the crack where it will cure and provide a water tight seal.

Capillary Action

Methylated Spirits or Acetone is applied to the crack followed by brush coating of mixed Megapoxy H. As the solvent dries out, the resin is drawn into the crack.

Low Pressure Injection

Prepare concrete around the crack by lightly grinding the surface. Bond crack injection balloons over the crack at a distance of 300mm apart, depending on the crack width, using Megapoxy PM. Seal over the balloon bases and crack to a minimum width of 50mm either side of the crack, using Megapoxy PM. Once the Megapoxy PM has cured, mix the Megapoxy H and pour into the back of the crack injection gun. Open all the crack injection balloon taps, attach the crack injection gun to the crack injection balloon and pump the Megapoxy H into the balloon until it comes out of the next balloon or the balloon inflates to approx. 20mm. Turn tap off and repeat the process until all the balloons are inflated and remain inflated.

Once every thing has cured, knock balloons of with a chisel below the steel clip, then using a 40grit flap disc, grind the surface back smooth.

Pressure Injection

Seal outside of crack with Megapoxy PM non-sag paste system. Some "V-ing" may be necessary to obtain better bonding. When applying the Megapoxy PM, bond over the crack nuts into which ball-less grease nipples can be screwed prior to injection the next day.

Nuts should be placed 200 to 400 mm apart, depending on the depth of the crack.

The deeper the crack, the closer the nut. Megapoxy H can be injected by grease gun or pressure pot. A nipple is screwed into the bottom-most nut and Megapoxy H injected until it exudes from the adjacent nut. Remove the nipple and plug with fitting bolt.

The nipple is then screwed into the next nut and the procedure repeated until the crack is full.

In some cases it may be necessary to seal concrete on the opposite side with Megapoxy PM.

The following day the nuts can be removed with a chisel leaving a minimum of grinding to achieve a clean appearance.

IMPORTANT INFORMATION

It is essential that the correct mixing ratio be used and that the Part A and Part B are thoroughly mixed together before use. Inaccuracies and poor mixing will result in lower physical properties of the cured system and, if the error is sufficiently large, the system may not cure satisfactorily and discolour on ageing.

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EPOXY MORTARS AND EPOXY CONCRETE

POURABLE EPOXY MORTARS

POURABLE EPOXY MORTAR (GROUT)	Mixing Ratio by volume	3 Parts A to 1 Part B 12 Parts Silica 50N by volume The proportion of silica 50N (epoxy quality fine sand) can be varied to provide suitable pourability in cold and warm weather conditions.
LARGE POUR POURABLE EPOXY MORTAR (GROUT)	Mixing Ratio by volume	3 Parts A to 1 Part B 12 Parts Silica 16/30 by volume This mix of Megapoxy H and silica 16/30 (epoxy quality sand) can be used for larger and deeper sized pour while still maintaining strength. It can be varied slightly to provide different pourability. Suitable for large truncation pocket grouting. Compressive Strength : 85Mpa

TROWELLABLE EPOXY MORTARS

EASY TO WORK MORTAR	Mixing Ratio by volume	3 Parts A to 1 Part B 12 Parts Silica 50N by volume Prior to placement of this mortar, prime the prepared concrete surface with a brush applied coat of pre-mixed Megapoxy H. Finish the placed mortar using a steel trowel. To avoid sticking and dragging of the trowel, broadcast a thin layer of Silica 50N on the mortar surface and work with trowel until desired surface finish is achieved. Allow to cure for 24 hours. Compressive Strength : 90Mpa
HIGH STRENGTH CORRECTIVE RESURFACING MORTAR.	Mixing Ratio by volume	3 Parts A to 1 Part B 12 Parts Silica 50N by volume 12 Parts Silica 30/60 by volume Prior to placement of this mortar, prime the prepared concrete surface with a brush applied coat of pre-mixed Megapoxy H. Finish the placed mortar using a steel trowel. To avoid sticking and dragging of the trowel, broadcast a thin layer of Silica 50N on the mortar surface and work with trowel until desired surface finish is achieved. Allow to cure for 24 hours. This provides a moisture tolerant epoxy modified leveling screed upto 6 mm in thickness. Compressive Strength : 70Mpa

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EPOXY CONCRETE

HIGH STRENGTH MEGAPOXY H BASED CONCRETE

Mixing Ratio by volume

3 Parts A
to
1 Part B
10 Parts Silica 50N by volume
10 Parts Blue Metal 10 - 20 mm by volume

Prior to placement of this mortar, prime the prepared concrete surface with a brush applied coat of pre-mixed Megapoxy H. Finish the placed mortar using a steel trowel. To avoid sticking and dragging of the trowel, broadcast a thin layer of Silica 50N on the mortar surface and work with trowel until desired surface finish is achieved. Allow to cure for 24 hours.

This provides a moisture tolerant epoxy modified leveling screed up to a 6 mm in thickness.

Compressive Strength : 70Mpa

NEW TO OLD CONCRETE ADHESIVE

Mixing Ratio by volume

3 Parts A
to
1 Part B

Mix Megapoxy H as detailed above and apply by brush, roller or airless spray to prepared old concrete at the rate of 1 to 1.5 litres per square metre.

Place new concrete within 15 minutes of applying Megapoxy H to ensure good bonding.

For vertical and overhead rendering use Megapoxy HT in place of Megapoxy H.

CLEANING

To keep mixing implements and working tools clean, use Megapoxy Thinners.
Use disposable rubber gloves to protect hands and maintain proper industrial hygiene.
For further details refer to the Megapoxy H Safety Data Sheets.

PACKAGING

Megapoxy H is available in 4lt & 20lt kits.
Product should be stored in cool dry store.

TECHNICAL SERVICE

All purchasers of Megapoxy Products, are encouraged to avail themselves of our Technical Service for our Megapoxy Products. The information in this Bulletin is correct at time of publication, however continual research and development is being carried out and specs may change without notice.