

# DURAFIX 615

DURAFIX 615 is a solvent free adhesive paste in a twin pack that provides excellent adhesion to steel, wood, fiberglass, asbestos, cement, concrete, glass and ceramic products as well as mosaic and quarry tiles. Also suitable for repairing leaks in pipes and for grouting steel bars and bolts into concrete and repairing concrete spalls. The product is water resistant.

**Colours:** Grey Paste

## PRODUCT USES

- Ideal for sealing static cracks from widths greater than 100 microns but no more than 9mm. It is highly penetrative and cures to form a permanent seal against the ingress of corrosive fluids and gases and is capable of restoring integrity to structural elements.
- Repairs, seals and bonds all types of concrete cracks in:
- Columns, Bridge decks, Floors, Piers, Tunnels, Basements, Beams and Underpasses
- Adhesive for carbon fibre strengthening
- Primarily for use in repairing cracks and spalling and for filling gaps, grouting and bedding fixtures.
- Wherever a thixotropic epoxy mortar is required

## ADVANTAGES

- High strength.
- Strong adhesion.
- Non-slump.
- Impact resistant.
- Excellent chemical resistance.
- Non-shrink.
- Epoxy based.
- Easy to use.
- No bonding agent or primer required.

## COVERAGE

- 1 litre will fill 1m<sup>2</sup> at 1mm thickness

## SURFACE PREPARATION

- Before sealing or injecting any materials, it is important to ascertain why and how the cracks originated; this will significantly affect the selection process of repair materials.
- All cracks should be thoroughly cleaned to ensure a strong bond develops between surfaces.
- All cracks to be treated should be flushed out with clean, dry, oil free compressed air or inert gas (nitrogen). This should be done after drilling of injection holes or fixing nipples.
- Ensure all substrates are thoroughly clean, sound, dry and free from any contaminants such as dirt, rust, salt, algae and grease. It is advisable to abrade surfaces where possible as this will ensure good adhesion. Degrease oily surfaces before abrasion. Degrease again before application of Durafix 615

## APPLICATION

- **Mixing:** Durafix 615 has been designed to be readily mixed by trowel. Mix part A and part B separately and then mix together for 4-5 minutes until a homogeneous mixture is achieved. Mixing must be done in a clean container or on a dry surface. A mix ratio of 1:1 (Part A to Part B) by mass is maintained.
- **Working temperature:** Durafix 615 will cure at temperatures as low as 10°C, although at low temperatures cure is severely retarded.
- Apply Durafix 615 with a spatula, putty knife or trowel. For a smooth surface use a paint brush dipped in soapy water to smooth out
- Keep bonded surfaces in place until the adhesive is touch dry. No pressure is required

- Once Durafix 615 has fully cured and a smoother finish is required use a hand held grinder or sander to smooth to the required level.

## CLEANING

- Clean tools immediately after use with a cleaning solvent such as Xylene.

## SAFETY PRECAUTIONS

- As with all chemical products, care should be taken during use and storage to avoid contact with eyes, mouth, skin and foodstuffs. Treat splashes to eyes and skin immediately.  
If accidentally ingested, seek medical attention.  
Reseal containers after use.  
Use in well ventilated areas and avoid inhalation.

## TECHNICAL DATA

Pack size	2 litres
Colour	Greyish
Mix ratio	1:1
Compressive Strength	55 MPa
Bond Strength	22 MPa @ 2 days 25 MPa @ 14 days
Pot life	35 minutes @ 25°C
Touch Dry	6-10 hours
Practical Cure	18 Hours
Full Chemical Cure	7 days

*Technical details above are provided in good faith. We are an ISO 9001:2008 registered company and our products are manufactured to the highest standards using raw materials of superior quality. Consequently we believe in the quality of our products and will willingly replace any product in the unlikely event of a quality related performance failure. Whilst we are confident in guaranteeing the quality of our products, we cannot however accept any liability for performance failure due to the incorrect application of our products. Correct application is critical to the successful performance of our products and as this process falls outside of our control we are unable to cover the application under our product performance warranty. Where there are doubts, it is recommended that the user conduct their own suitability tests before use. To retain sheen and colour consistency of your paint, always make sure that the batch numbers are the same on all paint containers that you purchase.*

*Updated: March 2013 (this supercedes all previous publications)*