



DURAL 100

PRECAST SEGMENTAL EPOXY ADHESIVE

PACKAGING

3 gal (11.4 L) unit
 Code: TD63323 (Class D)
 Code: TD63223 (Class E)
 Code: TD63123 (Class F)

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 100 will require mechanical abrasion for removal.

SHELF LIFE

2 years in original, unopened package

SPECIFICATIONS AND COMPLIANCES

- Meets the requirements of ASTM C881 Type VI, Grade 3, Classes D, E, and F

DESCRIPTION

DURAL 100 is a two-component, moisture insensitive, 100% solids epoxy adhesive used as a bonding agent for precast segmental box girders, bridge and other segmental construction. DURAL 100 is a non-sag paste which is available in 3 formulations that cover a wide range of temperature applications.

PRODUCT CHARACTERISTICS

Class	Temperature Application Range
D	40 °F to 65 °F (4 °C to 18 °C)
E	60 °F to 90 °F (16 °C to 32 °C)
F	85 °F to 115 °F (29 °C to 46 °C)

APPEARANCE

Part A liquid is white in color and Part B liquid is black in color.

COVERAGE

Covers approximately 12 ft²/gal to 13 ft²/gal (0.29 m²/L to 0.32 m²/L) at 1/8 inch (3 mm) thickness

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	Property	Class D	Class E	Class F
-	Temperature Range	40 °F to 65 °F (4 °C to 18 °C)	60 °F to 90 °F (16 °C to 32 °C)	85 °F to 115 °F (29 °C to 46 °C)
-	Sag Resistance at High Temperature	< 1/4 in (6.4 mm)	< 1/4 in (6.4 mm)	< 1/4 in (6.4 mm)
-	Gel Time at High Temperature	49 minutes	70 minutes	38 minutes
ASTM D695	Compressive Yield	24 hours: 3,205 psi (22.1 MPa) 48 hours: 6,826 psi (47.1 MPa)	24 hours: 4,998 psi (34.5 MPa) 48 hours: 6,529 psi (45.0 MPa)	24 hours: 3,245 psi (22.4 MPa) 48 hours: 9,216 psi (63.5 MPa)
ASTM D648	Heat Deflection Temperature, Minimum	143 °F (61 °C)	138 °F (58 °C)	153 °F (67 °C)
-	Open Contact Time at High Temperature	60 minutes	60 minutes	60 minutes
-	Compressive Shear Strength	Low Temp: 1,120 psi (7.7 MPa) High Temp: 1,300 psi (9.0 MPa)	Low Temp: 1,270 psi (8.7 MPa) High Temp: 1,620 psi (11.2 MPa)	Low Temp: 1,170 psi (8.1 MPa) High Temp: 1,450 psi (10.0 MPa)
ASTM C882	Bond Strength	2 days: 1,275 psi (8.8 MPa)	2 days: 2,320 psi (16.0)	2 days: 3,230 psi (22.3 MPa)
ASTM C882	Contact Strength	2 days: 1,464 psi (10.1 MPa)	2 days: 1,425 psi (9.8 MPa)	2 days: 3,130 (21.6 MPa)

DIRECTIONS FOR USE

Surface Preparation: The surface must be dry and structurally sound. The substrate must also be free of all dust, dirt, grease, oil, coatings, laitance and other contaminants that would interfere with proper adhesion. The surface should be lightly sand blasted, shot blasted or water blasted with a minimum pressure of 5,000 psi (34.5 MPa). Wet surfaces must be dried. Remove all visible water with a heater and/or oil-free air compressor. Any dust that may have accumulated between cleaning and application of DURAL 100 should be removed by an oil-free air compressor.

Mixing: Do not begin mixing until the segment is prepared for installation. Mix DURAL 100 using a low-speed drill and a mixing paddle. Pre-mix Part A and Part B separately for approximately 1 minute each. Combine all of Part A with all of Part B, then mix thoroughly for 3 to 5 minutes. 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: Use a trowel, brush, mop or gloved hand to apply DURAL 100 on both segments to be joined. Apply at minimum and uniform thickness of 1/16 inch (1.6 mm). A visible bead line must be observed on all exposed contact areas. DURAL 100 should be applied completely around the pre-stressing ducts but not within 3/8 inch (9.5 mm) of the ducts. Use DURAL 100 Class D, E or F depending on the temperature range prevailing at the time of installation. DURAL 100 should be applied within the first half of its gel time (approx. 15 minutes). Erection, assembly, and temporary post tensioning must be completed within the contact time of DURAL 100, which is approximately 60 minutes from the time the epoxy is mixed. The segments should be joined with a minimum provisional stress of 30 psi (0.21 MPa) across the entire cross section. If the segments have not been joined within 70% of the contact (open) time, the operation should be discontinued, the DURAL 100 removed and fresh DURAL 100 applied. After the segments have been joined, excess DURAL 100 should be removed from the joints, where accessible. Tendon ducts should be swabbed immediately after stressing to remove or smooth out any epoxy in the conduit and to seal any pockets or air bubble holes that may have formed at the joint.

PRECAUTIONS/LIMITATIONS

- Store DURAL 100 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 40 °F and 115 °F (4 °C and 46 °C). This range covers all three classes of DURAL 100 epoxy, and the proper class must be chosen based on the prevailing temperature at the time of installation.
- Material temperatures should be at least 40 °F (4 °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 100
- DURAL 100 will discolor upon prolonged exposure to ultraviolet light and high-intensity artificial lighting.
- Apply DURAL 100 to dry concrete surfaces only
- DURAL 100 is not intended for use in areas that are subject to prolonged and/or strong chemical attack
- Do not apply to frozen or frost-filled substrates, or when the temperature is below 40 °F (4 °C) or expected to fall below that temperature within 24 hours of application
- In all cases, consult the product Safety Data Sheet before use

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