ANCHOR BOND® 2500 EPOXY GROUT

PRODUCT DESCRIPTION:
Anchor Bond® 2500 Epoxy Grout is a three-component, troweled, epoxy mortar system. The system consists of an Epoxy resin, amine curing agent and selected, graded aggregates. It cures to an extremely hard, impact resistant mortar used under other overlayments. Anchor Bond® 2500 Epoxy Grout can be applied to establish pitch or fill holes up to 6" deep.

RECOMMENDED FOR:
- Protective overlay on new floors
- Repair and restore old, worn surfaces
- Traffic aisles
- Production, packaging and machine areas
- Chemical processing areas

SUBSTRATE:
Anchor Bond® 2500 Epoxy Grout with the appropriate primer, is suitable for application over concrete, wood, brick and quarry tile. Not recommended for use on asphalt, mastic, gypsum based products or painted surfaces. These must first be removed by mechanical means to expose the substrate prior to priming and overlayment.

SOLIDS BY WEIGHT:
100% (+ / - 1%)

COLORS AVAILABLE:
Gray, red, black and neutral. Other colors available upon request.

FINISH CHARACTERISTICS:
Gloss

MIX RATIO:
56 oz. Part A / 10 oz. Part B / 1 Part C (50#)

RECOMMENDED THICKNESS / YIELD:
16 sq. ft / kit @ 2" thickness (5 batch kit)
32 sq. ft / kit @ 2" thickness (10 batch kit)

PACKAGING INFORMATION:
5 batch kits
10 batch kits

STORAGE CONDITIONS:
Store all components in a dry area, in temperatures between 60 – 85 deg. F. Avoid excessive heat and do not freeze.

PHYSICAL PROPERTIES

PROPERTIES	TEST METHOD	ANCHOR BOND® 2500 EPOXY GROUT
COMPRESSIVE STRENGTH	ASTM C-579	14,000 psi
FLEXURAL STRENGTH	ASTM C-580	4,000 psi
TENSILE STRENGTH	ASTM C-307	1,750 psi
FLEXURAL MODULUS OF ELASTICITY	ASTM C-580	2.0×10^6 psi
COEFFICIENT OF THERMAL EXPANSION	ASTM C-531	1.5×10^{-5} in. / in.°C
WATER ABSORPTION	ASTM C-413	0.2%
IMPACT RESISTANCE	ASTM D-2794	> 160 in. / lbs.
HARDNESS	ASTM D-2240	85 – 90 Shore D
HEAT DEFLECTION TEMP	150.0 deg. F @ ASTM D648, ½" X ½" bar, span 4	

CURE RATE:
24 hours for normal operations. (At 75 deg. F)

PRIMER:
Anchor Bond® 100% Solids Primer.

TOPCOAT:
Depending on requirements of environment
Anchor Bond® 2500 Epoxy
Anchor Bond® Anchor Crete® QTA Urethane

SYSTEM OPTIONS:
This product can be used to fill deep holes as well as to establish pitch to drains.

TEXTURES:
Predicated by overlayment requirements.

SHELF LIFE:
Three (3) years in original, unopened containers.

ANCHOR BOND® 2500 EPOXY GROUT
MIXING AND APPLICATION INSTRUCTIONS

1) PRODUCT STORAGE:
Store product in an area so as to bring the material to normal room temperature before using. Continuous storage should be between 60 and 90°F. Low temperatures or great temperature fluctuations may cause product crystallization.

2) SURFACE PREPARATION:
The most suitable surface preparation would be a fine brush blast (shot blast) to remove all laitance and provide a suitable profile. All dirt, foreign contaminants, oil and laitance must be removed to assure a trouble free bond to the substrate. A test should be made to determine that the concrete is dry; this can be done by placing a 4'x4' plastic sheet on the substrate and taping down the edges. If after 24 hours, the substrate is still dry below the plastic sheet, then the substrate is dry enough to start coating. The plastic sheet testing is also a good method to determine if any hydrostatic pressure problems exist that may later cause disbonding.

3) PRODUCT MIXING:
- Measure 56 liquid oz. Anchor Bond® Slurry Broadcast Resin (Part A)
- Measure 10 liquid oz. Anchor Bond® Slurry Broadcast Hardener (Part B)
- 1 bag Anchor Bond® graded aggregate blend (50#)

Pour pre-measured Part A and Part B liquids into a Mortar mixer and allow tomix for one minute. While Mortar mixer is turning, pour entire contents of 1 (50#) bag of graded aggregate into the Mortar mixer. Allow to mix until all aggregate is fully wet in appearance.

4) PRIMING:
Anchor Bond® 100% Solids Primer

5) PRODUCT APPLICATION:
- While the Anchor Bond® 100% Solids Epoxy Primer is still wet, a Screed Applicator is used to apply the mixed Anchor Bond® 2500 Epoxy Grout to the floor. Material should be screed to allow for ¼" / 6 mm. thickness after material has been compacted and trowel finished.
- After Screeding the Anchor Bond® 2500 Epoxy Grout steel finishing trowels are used to compact and smooth the surface of the material. Use enough pressure to compact the Anchor Bond® 2500 Epoxy Grout to the required ¼" / 6 mm. thickness. Then, holding the trowel at a slightly lower angle, smooth out any trowel marks. If the mortar "pulls" creating a rough or open surface, either the trowel has become sticky or it is being held at the wrong angle. Keep the trowel clean by frequently cleaning it with scouring pads and warm, soapy water, remembering to wipe it dry before use again. The finished surface should be level, free of trowel marks and tightly closed to prevent a porous topping.
- In large, open areas, a power trowel is used to compact and smooth the surface of the material.
- The mixing, screeding, trowling procedure is repeated as needed until the entire area has been covered. Coverage and thickness can usually be judged by the eye but DO check the actual thickness at frequent intervals during the entire installation.
- Where Anchor Bond® 2500 Epoxy Grout does not abut a vertical surface, trowel the product into a chase (groove) cut into the concrete.
- It applying a cove, the cove should be trowled along with the floor to provide a seamless transition. The same Anchor Bond® 2500 Epoxy Grout material is used for the cove base and the floor.

6) RECOAT OR TOPCOATING:
This product does not require a topcoat however many topcoats are suitable for placement over this product including urethanes, epoxied and novolacs. When topcoating this product, you must first be sure that the material has tacked off before topcoating. Always remember that colder temperatures will require more cure time for the product before topcoating can commence. Before topcoating, check the coating to verify no epoxy blushes were developed (a whitish, greasy film or deglossing). If a blush is present, it must be removed prior to topcoating. A standard type detergent cleaner can be used to remove any blush.

7) CLEANUP:
Use xylol

8) FLOOR CLEANING:
Caution! Some cleaners may affect the color of the floor installed. Test each cleaner in a small area, utilizing your cleaning technique. If no ill effects are noted, you can continue to clean with the product and process tested.

9) RESTRICTIONS:
Restrict the use of the floor to light traffic and non-harsh chemicals until the coating is fully cured (see technical data under full cure). It is best to let the floor remain dry for the full cure cycle.