

# Eva-Pox Bonder No. 1

Eva-Pox Bonder No. 1 is a 100% solids two component, moisture insensitive, modified epoxy adhesive specifically designed for adhering pre-formed closed cell joint seals to a variety of substrates. Additional applications include bonding cured concrete to steel, cured concrete, wood and many other construction materials, for application at temperatures down to 38 °F (3 °C). Meets ASTM C- 1, Type I & II, Grade 2, Class B & C.

FEATURES	BENEFITS
Meets ASTM C-881	Adhesive for various construction materials
Excellent adhesion to closed cell foam	High performance adhesive for CEVA <sup>®</sup> closed cell foam expansion joint systems
30 minute pot life	Ideal working time when used as an adhesive for CEVA <sup>®</sup> Expansion joint system
Moisture Insensitive	Bonds to damp substrates

## MIXING

Separately mix Components A and B thoroughly. For smaller batches, mix 3 parts of Component A with 1 part of Component B in a clean plastic or metal pail. For full gallon batches, add the small container into the 1 gallon container. Mix for approximately 3 minutes or until there is no marbling. Only mix the required amount of material to ensure that the pot life is not exceeded. Warmer weather, as well as larger batches, decreases the pot life of the mixed material.

Grouting and Patching: Add a clean dry silica sand to the premixed resin at a 1:1 ratio, mixing it thoroughly while adding.

## USES

### Application

- Bonding pre-formed closed cell foam joint seals to substrates
- Primer for ECrete 57N (elastomeric concrete)
- Bonding typical construction materials together
- Grouting equipment/base plates

### Locations

- Bridges, Highways, & Tunnels
- Parking Structures
- Commercial Buildings
- Water Treatment Facilities

### Substrate

- Elastomeric Concretes
- Cured Concrete
- Steel
- Stainless Steel
- Wood

## SURFACE PREPARATION

### Concrete:

All oils, grease, dirt, waxes, existing coatings, curing compounds, heavy laitance and sharp edges or protrusions must be removed. New concrete should cure 80% of the design strength. Sandblasting of surfaces is highly recommended

### Steel:

Surfaces must be clean, sound, and sandblasted to a near white metal (SSPC-10) finish immediately before the application of the bonder and not the day before.

NOTE: Galvanized steel, aluminum, and any other specialty metal requires an acid etching primer after surface preparation.

TECHNICAL DATA			
Properties	Part A	Part B	Mixed
Color	Gray	White	Black
	Beige	White	Caramel
Mixing Ratio (by vol.)	3	1	3:1
Specific Gravity	1.47	1.15	
Density (lbs/gal) @25 °C	12.0±0.5	9.6±0.2	
Viscosity (cps) @ 25 °C	35,000±10,000	10,000±2,000	
Gel Time (200 gms.)			100±30 mins.
Initial Set, min @ 77°F (25°C)			1.5 – 2 hrs.
Initial Cure, hr @ 77°F (25°C)			8-12 hrs.
Full Chemical Cure, days			7
Compressive Strength, psi, ASTM D695			7000 psi.
Tensile Strength, psi, ASTM D638			3500 psi.
Elongation, ASTM D638			3-5%
Shore D Hardness, ASTM D2240			80 ± 5
Water Absorption ASTM D570			0.25%
Bond Strength ASTM D4541			430 psi min.

**APPLICATION**

Eva-Pox Bonder No. 1 may be applied by brush roller, trowel, caulking gun or by hand with rubber gloves. Apply an approximate finish of 40 to 60 mils (1016 – 1524 mm) covering the entire surface and filling holes or cavities. Prior to Eva-Pox Bonder No. 1 reaching the tack stage, place second material against the adhesive. If tack stage is reached prior to adhesion, re-apply Eva-Pox Bonder No. 1.

**COVERAGE**

When used as a bonding agent for construction products @ 70° F: 40 sq. ft./gallon @ 40 mils.

When used as an adhesive for pre-formed closed cell foam joint seal please use the chart below.

NOTE: A joint foot denotes coverage of both sides of joint material and both sides of the noted substrate.

When used as a primer for E-Crete #57 & 57N @ 70° F apply the bonding agent at 20 – 40 mils or 40 – 80 sq. ft./gallon on all exposed surfaces.

**Reference Coverage Chart:  
Material Joint Feet Per Gallon**

Depth	Concrete	Steel
1"	100.0'	120.0'
2"	50.0'	60.0'
3"	35.0'	40.0'
4"	25.0'	30.0'

**STORAGE**

Materials must be kept in a dry area at temperatures between 50° F and 95° F (10° C - 35° C) in the original unopened containers during all phases of delivery, storage and handling.

**DO NOT ALLOW PRODUCT TO FREEZE.**

**CAUTION**

Direct contact with skin should be avoided as it can cause skin irritation. Protective clothing, goggles and gloves are required.

In case of direct contact with the skin, wash with soap and water. In the case of accidental contact with eyes, flush immediately with plenty of water and report to a doctor. Fatal if taken internally. Keep away from open flame.

**LIMITATIONS**

Minimum substrate and ambient temperature is 38° F (3° C). Do not thin with solvents.

**KEEP OUT OF REACH OF CHILDREN!**

**AVAILABILITY**

Kit = 2 Part As and 2 Part Bs  
which makes 2 gallons of  
Eva- Pox Bonder No.1  
Color: Gray or Beige

**CLEAN UP**

Uncured material can be removed with an approved solvent. Follow solvent manufacturer’s instructions for use and warnings. Cured material can only be removed mechanically. In case of a spill, ventilate area and contain spill with absorbent materials. Dispose of in accordance with current and applicable local, state and federal laws.

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