
Fast Bonding Epoxy Adhesive

Description: HS-410F is a two component 100% solids, structural epoxy paste adhesive that combine to form a tough, creep resistant, fast grout with a wide range of job-site uses. Its high viscosity, non-sag, creamy consistency makes it ideal for surface filling, bonding agent, bolt grouting and capping cracks. With a 7-minute gel time and quick strength gain upon cure, gives workers maximum application time and reduces wasted product. HS-410F is moisture insensitive and will adhere to moist or damp surfaces. (For maximum bond, it is better to work on a dry surface.)

Uses and Advantages: Anchor grouting threaded rod, rebar dowels into concrete and masonry
Surface patching
Excellent high strength durable coating for concrete, block and brick
Bonding concrete, wood and masonry
Decorative stone/tile adhesive
Mounting injection ports and capping cracks
Reliable and easy to use 1:1 by volume mix ratio
Moisture insensitive and may be used in damp environments
Negligible shrinkage

Packaging: HS-410F is available in a bulk sizes including 1 (102 oz.), 2, 10 and 100 gallon kits.

Yield: 1 Gallon yield 231 cu. in. of epoxy, 1.8 cu. in. = 1 fl. oz.
BUG Unit yields 184 cu. in. of epoxy,

Coverage

Thickness (1000 mils = 1 in.)	Coverage / Gallon
1/4" = 250 mils	6.4 sq. ft.
3/16" = 187 mils	8.5 sq. ft.
1/8" = 125 mils	12.8 sq. ft.
1/16" = 62.5 mils	25.5 sq. ft.

Manufactured In The U.S.A. by Adhesives Technology Corp.

How To Use:

BULK USE: Measure out equal volumes of hardener (black part B) and resin (white part A). Mix only the amount of material that can be used within 6 – 8 minutes. Mix together until the entire mixture is uniform and consistent gray color with no streaks (approximately 2 – 3 minutes). The epoxy may be completely hand mixed or for larger quantities the material may be mixed with an electric drill and standard mud-mixing paddle. The mixing process should not add air to the epoxy. Do not whip or stir air into the mixture. Begin to use the mixed epoxy as soon as it is thoroughly mixed.

CAUTION: Mixed epoxy must be used before the stated gel time or pot life has elapsed. Failure to do so will result in hardened and unusable epoxy that must be discarded.

TECHNICAL DATA FOR HS-410F

Shelf Life		2 years
Storage Conditions		Below 95° F
Color		Concrete Gray
Consistency	ASTM C881	Non-sag @ 78° F Non-sag @ 95° F
Temperature Range		40° F - 115° F
Mixing Ratio A:B (Volume)		1:1
Gel Time (60 gram mass @ 78° F)	ASTM C881	7 minutes ¹
Compressive Yield Strength - 7 days	ASTM D695	8,500 lbs
Bond Strength	ASTM C882	2,450 psi
Tensile Strength	ASTM D638	1,850 psi
Heat Deflection Temperature	ASTM D648	139° F
Linear Shrinkage	ASTM D2566	0.002 cm/cm
Water Absorption – 24 hrs	ASTM D570	0.46 %

1. Gel and Bolt Up Times lengthen as temperatures decrease and shorten as temperatures increase.

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