

1. Product Name

Miraclebond 1350 Multi Purpose Non Sag Bonding System

2. Manufacturer

Adhesives Technology Corp.
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3. Product Description

GENERAL DESCRIPTION

Miraclebond 1350 is a two component, 100% solids, high aspect ceramic blend epoxy. It is a solvent free, high strength, high modulus, moisture insensitive, non-sag epoxy system. **Miraclebond 1350** is ideal for use in temperatures ranging from 35°F - 110°F.

Quick Selection Guide	
Color	Concrete Gray
Consistency	Non-Sag Gel
Gel-Time (75°F.)	8 minutes
Cure Time	2 hours @ 75°F.
Application Temperature Range	35° F. – 110° F.

BASIC USE

Miraclebond 1350 is ideal for use as a bonding agent for almost any material, including metal, concrete, brick, wood, stone, block, and other substrates. **Miraclebond 1350** can also be used for repairing holes, spalls, and cracks in concrete, repairing rotted wood, install and repair anchor bolts, or hand rails, and as a high strength adhesive or projects that require a non-sag epoxy with a fast curing time. **Miraclebond 1350** is an excellent choice where a high strength adhesive with maximum field reliability is desired.

FEATURES

- Non-sag high strength epoxy
- Easy to use 1:1 ratio system
- Moisture insensitive epoxy

APPLICATIONS INCLUDE:

- Bonding fresh concrete to hardened concrete
- Bonding hardened concrete to hardened concrete
- Bonding traffic markers/road buttons to concrete/asphalt
- Crack Injection sealer around ports and cracks
- Vertical, horizontal and screen applications, non-sag / no drip
- Short term light duty anchoring of threaded rod and rebar dowels
- Mortar Repair Material (when mixed with dry silica sand)
- Non Sag spall and patching material

LIMITATIONS:

- Minimum substrate and ambient temperature 35°F (1.67°C)
- Do not thin with solvents; addition of solvents will prevent cure
- If preparing epoxy mortar, use oven dried silica sand only
- Maximum epoxy mortar thickness per lift is 1 inch (25 mm)

COLOR

"A" Component (resin): White

"B" Component (hardener): Black/dark gray

Mixed: Concrete Gray

SOLIDS: Weight: 100% Volume: 100%

SHELF LIFE: 24 Months

STORAGE: Store in unopened containers at 40°F – 95°F.

SIZE/PACKAGING

Cartridge Sizes: **Miraclebond 1350** is available in:

- 9 oz. cartridges; part number A9-MB1350HN

The resin and hardener are uniformly dispensed from a dual cartridge system and mixed simultaneously through a mixing nozzle, providing contractors with a self mix delivery system.

Bulk Sizes Include:

- 1 Quart Kit (1 pint A; 1 pint B); part number: B1Q-MB1350
- Bulk Unit Gallon (102 fl oz.); part number: BUG-MB1350

4. Technical Data

Technical Data		
Properties	ASTM	Results
Compressive Strength @ 65°F (7 days)	D695	8,000 psi
Bond Strength @ 2 days	C882	1,130 psi
Bond Strength @ 14 days	C882	1,690 psi
Heat Deflection Temperature	D648	135° F
Consistency	C 881	Non Sag Paste
Gel-Time (60 gram mass)	C881	8 minutes
Linear Coefficient of Shrinkage	D2566	.004 cm/cm

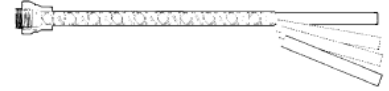
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5. Installation

Job site preparation and work flow – to achieve the desired results, carefully follow these procedures!

- Always be sure the bonding surfaces are prepared in advance before starting a new cartridge. If at all possible, schedule dispensing to consume an entire cartridge at one time with no interruption of epoxy flow.

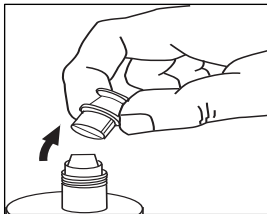
To achieve maximum flow and reduce fatigue, the tip of the nozzle can be snapped off at the narrowest point of the nozzle.



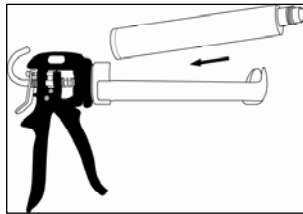
Surface Preparation and Cartridge Set up

Note: component "A" contains epoxy resin and is an irritant / sensitizer; component "B" contains amines and is a corrosive / sensitizer; prior to using the epoxy material, please consult the material safety data sheet for proper handling instructions. Always wear protective safety glasses and gloves when working with epoxies and chemicals.

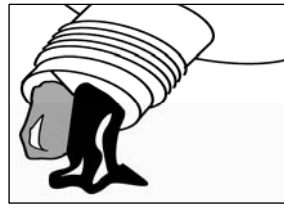
Before using Miracle Bond be sure that the surfaces to be bonded are sound and cleaned so there is no dust, dirt, grease, wax, oil or any other contaminants present. Smooth surfaces should be roughened with sandpaper or a wire brush before application.



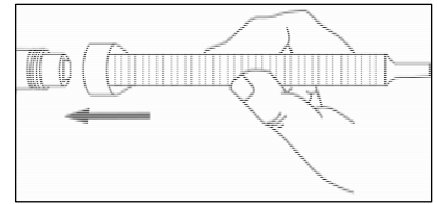
I. Unscrew plastic cap and remove plug from threaded end of cartridge.



II. Place cartridge into a 10 oz. caulk gun. ATC's TM9HD is recommended.



III. Dispense a small amount of adhesive into a disposable container until both materials flow from cartridge.

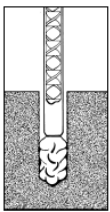


IV. Attach mixing nozzle to cartridge and dispense a small amount of material into same disposable container until a consistent color with no streaks is obtained.

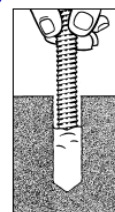
Bonding & Patching Applications

Apply an even coat of the mixed **Miraclebond** to the clean and prepared surfaces. When bonding two surfaces together, make sure to fill all gaps between the mating surfaces. For patching concrete or wood surfaces, fill the void with the Miraclebond epoxy to just above the surface level and trowel flush.

Anchoring Into Concrete – Short Term / Light Duty Anchoring Only



V. Dispense the material from the bottom of the hole. Fill approximately 1/2 – 5/8 of the hole depth while slowly withdrawing the nozzle. Fill completely full for holes totally submerged in water.

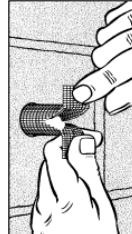


VI. Insert the threaded rod or rebar to the bottom of the hole while turning clockwise. The threaded rod or rebar should be free of dirt, grease, oil, or other foreign materials. Do not disturb or bolt-up until minimum bolt-up time has passed.

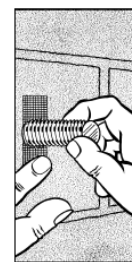
Anchoring Into Hollow Block or Unreinforced Masonry (Repeat steps I through IV as shown above).



V. Insert the mixing nozzle into the bottom of the screen and completely fill while withdrawing the nozzle. Fill the screen completely all the way to the end to insure that the epoxy completely fills the screen from top to bottom when threaded rod is inserted.



VI. Insert the epoxy-filled screen into the hole.



VII. Insert the threaded rod or dowel to the bottom of the screen while turning clockwise. The threaded rod or rebar should be free of dirt, grease, oil or other foreign material. Do not disturb or bolt-up until minimum bolt-up time has passed.

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Sample Specification – Bonding adhesive shall be a two component, 1:1 ratio, 100% solids, epoxy system supplied in pre-measured containers. The adhesive material must have a minimum gel-time of 8 minutes, a minimum compressive strength of 8,000 psi. Shelf life must be a minimum of two years. Adhesive shall be **Miraclebond 1350** manufactured by Adhesives Technology Corp., Pompano Beach, Florida.

IMPORTANT: DO NOT USE ELECTRIC MIXER FOR COMBINING BULK MIRACLE BOND AS THIS ACCELERATES CURE TIME. USE ONLY SMALL QUANTITIES OF MATERIAL. DO NOT MIX ENTIRE CONTENTS TOGETHER AT ONE TIME



BUILDING CODES

Installation of Ultrabond epoxy must comply with applicable local, state and national code requirements

SITE CONDITIONS

Material shall be delivered in original unopened containers and stored in a dry environment at a temperature between 40° and 90°F.

PRECAUTIONS

- Wear safety glasses
- Avoid prolonged contact with skin.
- Keep out of reach of children
- Do not take internally
- If Ingested seek medical attention immediately.
- Eye contact. Flush with water for at least 15 minutes. Call a physician immediately.

6. Availability and Cost

AVAILABILITY

Ultrabond epoxy is available through select distributors who can provide you with all of your construction needs. Please contact Adhesives Technology Corp. at (800) 892-1880 for a distributor near you.

COST

Cost information is available from your local distributor.

7. Warranty

All warranties of the product listed herein, in the corresponding ATC catalog, and in any other current literature, expressed or implied, including warranties of merchantability and fitness for a particular purpose are specifically and expressly excluded, with the following exception: At its sole discretion, ATC will repair or replace any product which it considers to be defective in material or workmanship, excepting normal wear and tear within sixty (60) days from the date of purchase from ATC. ATC shall not be liable for any injury, loss or damage, direct, indirect, incidental or consequential or arising out of use of, misuse of, negligence, accident or inability to use any ATC product.

8. Technical Services

For technical support contact Adhesives Technology Corp. at (800) 892-1880.

9. Maintenance

None required.

10. Filing System

Additional product information and specifications are available either on line at www.atc.ws or contact Adhesives Technology at (800) 892-1880 to get copies mailed to you.

Actual user performance and data may differ due to variations of base material, installation procedures and personnel, weather conditions and other factors. Adhesives Technology Corp. reserves the right to change specifications or information printed in this Tech Data Sheet without notice or liability for these changes. Adhesives Technology Corp. will not be liable for any claim based on the use of data or other information printed in this Tech Data Sheet.

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