

# X-Roc EpoxyBond

## Epoxy Resin Bonding Agent

### Product Description

X-Roc EpoxyBond is an epoxy bonding agent used to bond fresh concrete to hardened concrete or steel. It can also be used as primer for concrete repair.

### Composition

X-Roc EpoxyBond is a solvent free epoxy resin containing acid resistant fillers and wetting agents.

### Advantages

- Meets SCAQMD Rule 1113 & LEED VOC Limits
- Formaldehyde free
- Can be applied to steel and concrete
- Long open time
- Waterproof

### Typical Uses

- Bonding of fresh concrete to hardened concrete
- Bonding of fresh concrete to steel
- Primer for concrete repair mortars

### Standards Compliance

SCAQMD Rule 1113  
LEED NC2009 IEQ 4.2  
ASTM C881-02

### Laboratory Test Data

Property	Typical Results
Compressive strength (ASTM C579 –01)	60-65 MPa (9427.5 psi)
Solid content	98%
Density ASTM (D1475 – 13)	1.35 ± 0.05
Tensile strength (ASTM C307- 03)	20 MPa
Flexural strength (ASTM C580-02)	30 MPa
Slant shear strength ASTM (C882 – 13a)	25 MPa

### Application Properties

Application temperature	5 to 35C (41 to 95F)
Pot life	3 hours at 30C (86F)
Maximum overlay time	24 hours at 20C (68F) 12 hours at 30C (86F)

### Volatile Organic Content

VOC < 50 g/L

### Theoretical Coverage

X-Roc EpoxyBond: 4 to 5 m<sup>2</sup>/Ltr at 200 μ DFT

Actual coverage will depend on wastage and surface profile and can be up to 50% higher than theoretical coverage.

### Packaging

1 & 5 Kg packs.

### Shelf Life

18 months when stored below 35C (95F) under shade in a dry environment.

### Installation Guidelines

X-Roc EpoxyBond should be applied by experienced personnel. NCC X-Calibur provides detailed method statements on all its products for use in various applications. These must be referred to prior to starting work. The information below is a summary intended for guidance only.

### Surface Preparation Concrete

The substrate must be structurally sound. Loose or unsound concrete should be removed and made good. Surfaces must be entirely free of oil, grease, paint, corrosion deposits, dust, laitance or other surface deposits. The surface should be prepared by scabbling, scarifying, deep profile shot blasting or high pressure water blasting to produce an exposed aggregate surface with a deep profile.

---

## Steel

The surface should be grit blasted to minimum SA 2½ with a minimum surface profile of 200 microns. X-Roc EpoxyBond must be applied immediately after the grit blasting has been completed.

## Mixing

Add the hardener 'Part B' into the base 'Part A' and mix using a slow speed drill (350rpm) with an X-Shield Coating Mixer Paddle for 3 minutes, or until both components have fully dispersed and are uniform in color. Be sure to rotate the mixer throughout the drum. Mix only full packs.

## Application

Apply in a single coat by brush, taking care to work the mixed material with the substrate. Ensure a uniform coating is achieved and make sure no ponding occurs when applied horizontally. When used as an anti-chloride barrier two coats will be required. Pour concrete within the overlay times stated above. Clean equipment using X-Shield Solvent.

## Limitations

Do not apply below 5C (41F).  
Avoid excessive application.  
Do not exceed overlay times.  
Avoid skin contact.  
Do not discard into the water system.

## Health and Safety

**This product is for industrial use only by trained operatives. It is potentially hazardous if not used correctly. Please refer to the Material Safety Data Sheet (MSDS) prior to the purchase and use of this product. The MSDS can be obtained via our website [www.ncc.com.eg](http://www.ncc.com.eg)**

## Authorized Technical Specialist

Please note that only NCC X-Calibur Authorized Technical Specialists (ATSSOs) are permitted to change any of the information in this data sheet or to provide written recommendations concerning the use of this product. Visit [www.ncc.com.eg](http://www.ncc.com.eg) for a full list of NCC X-Calibur ATSSOs.

## Datasheet Validity

NCC X-Calibur makes modifications to its product datasheets on a continuous basis. Please check the datasheet update section on [www.ncc.com.eg](http://www.ncc.com.eg) to ensure you have the latest version.

## Warranties

NCC X-Calibur supplies products that comply with the properties shown on the current datasheets. In the unlikely event that products supplied are proved not to comply with these properties, then we will replace the non-compliant product or refund the purchase price. NCC X-Calibur does not warrant or guarantee the installation of the products as it does not have control over the installation or end use of the products. Any suspected defects must be reported to NCC X-Calibur in writing within five working days of being detected. NCC X-Calibur Construction Chemicals **makes no warranty as to merchantability or fitness for a particular purpose and this warranty is in lieu of all other warranties express or implied.** NCC X-Calibur Construction Chemicals shall not be liable for damages of any sort including remote or consequential damages, down time, or delay.