

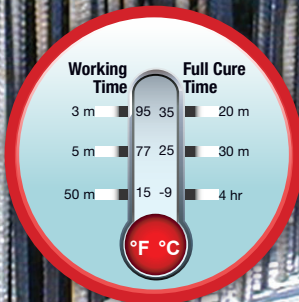


ULTRABOND® ASF-1000

Fast Cure Acrylic Adhesive



Use in Temperatures
between 15 °F to 95 °F



GENERAL USES & APPLICATIONS

- Adhering dowel bars and tie bars for full depth concrete repairs
- Short-term tensile anchoring and shear loading conditions in accordance with allowable stress design (ASD)
- Wide service temperature range between -40 °F to 176 °F (-40 °C to 80 °C)
- Moisture insensitive allowing installation and curing in damp water-saturated environments
- Bonding agent for fresh concrete to hardened concrete and hardened to hardened concrete

ADVANTAGES & FEATURES

- Ultra-fast 30 minute full cure time at 77 °F (25 °C) in dry concrete
- Fast mortar repair for panels and other concrete surfaces
- High bond strength with fast cure times
- Easily dispensable, even at low temperatures
- Styrene free
- Non-sag



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ULTRABOND ASF-1000 PERFORMANCE TO ASTM C881^{1,2,3}

Property	Cure Time	ASTM Standard	Units	Sample Conditioning Temperature		
				Class A	Class B	Class C
				15 °F (-10) °C	50 °F (10) °C	95 °F (35) °C
Gel Time - 60 Gram Mass ⁴	----	C881	min	50	10	4
Compressive Yield Strength	7 day	D695	psi (MPa)	5,930 (40.9)	5,630 (38.8)	3,450 (23.8)
Compressive Modulus			psi (MPa)	357,300 (2,464)	273,000 (1,882)	274,200 (1,891)
Bond Strength Hardened to Hardened Concrete	2 day	C882	psi (MPa)	3,050 (21.0)	3,020 (20.8)	2,480 (17.1)
	14 day		psi (MPa)	3,210 (22.1)	3,040 (21.0)	3,090 (21.3)
Bond Strength Fresh Concrete to Hardened Concrete				psi (MPa)	2,120 (14.6)	
Consistency or Viscosity	----	C881	----	Non-sag		
Heat Deflection Temperature	7 day	D648	°F (°C)	145 (62.8)		
Water Absorption	14 day	D570	%	0.42		
Linear Coefficient of Shrinkage	48 hr	D2566	%	0.014		

1. Results based on testing conducted on a representative lot(s) of product. Average results will vary according to the tolerances of the given property.
2. Full cure time is listed above to obtain the given properties for each product characteristic.
3. Results may vary due to environmental factors such as temperature, moisture and type of substrate.
4. Gel time may be lower than the minimum required for ASTM C881.

ULTRABOND ASF-1000 CURE SCHEDULE^{1,2,3}

Base Material Temperature Range	Working Time	Full Cure Time Dry Concrete	Full Cure Time Damp Concrete
°F (°C)			
15 (-9)	50 min	4 hr	8 hr
23 (-5)	40 min	3 hr	6 hr
41 (5)	20 min	90 min	3 hr
59 (15)	9 min	60 min	2 hr
77 (25)	5 min	30 min	60 min
95 (35)	3 min	20 min	40 min

1. Working and full cure times are approximate, may be linearly interpolated between listed temperatures and are based on cartridge/nozzle system performance.
2. Application Temperature: Substrate temperature should be from 15 - 95 °F (-9 - 35 °C).
3. When ambient or base material temperature falls below 23 °F (-5 °C), condition the adhesive above 68 °F (20 °C) prior to use.