



ISO 9001/2008 Registered

ABOWELD 55-1™



Technical Data:

Pull-off Strength ASTM 4541	1112.5 psi (7.67MPa)
Pot life time minutes, 100g @ 25°C	65 min.
Tensile Strength ASTM D 638	1,080 psi
Compressive Strength ASTM D 695	5,000 psi
Hardness Shore D	81
Chemical Resistance ASTM D 543	Excellent
% Solids by Weight	100%
Impact Resistance ASTM 4226	95.0
VOC (EPA method #24)	Negligible
Coverage : sq. ft./gal. Mils wet/mils dry	1 gallon- 231 cubic inches
Hardening Time @ 72°F	1-6 hours.

No-slump epoxy adhesive paste for building up vertical and overhead surfaces without forms or molds. This product fills cracks and permanently bonds concrete, wood, masonry, stones, metals, glass, fiberglass, and most rigid materials. Much stronger than concrete.

USES

Aboweld 55-1 is excellent for restoring columns, walls, ceilings, rails, stair risers and treads, and sculptures. Also great for installing machinery, posts, precasts, and other structural components.

FEATURES AND BENEFITS

Aboweld 55-1 has tenacious adhesion and structural strength that make it suitable for even the most punishing environments. Bonds to wet and dry surfaces, and hardens underwater. Will not sag. Easy to apply. Resists atmospheric and humidity conditions, salts, alkalis, diluted acids, solvents, fuels, oils, and greases. 100% solids. Will not shrink. 1/1 ratio. Gray (white/black). ASTM C881, TP I, III, Grd 3, Clss C.

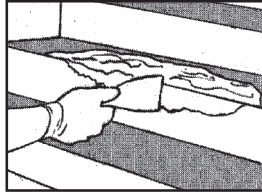
For cold/sub-freezing weather: Aboweld 55-1 (A) can be mixed in a ratio of 2 parts by volume with 1 part by volume Abocure 55-1 (B) CLD.

Greenguard Certified for Indoor Air Quality.



APPLICATION

Surfaces must be thoroughly clean and free of foreign matter, dust or loose debris. Sandblasting, muriatic acid etching, roughening, degreasing or washing are recommended as fitting for each job. The "laitance" surface of new concrete must be removed by etching, mechanical abrasion or blasting. Although ABOWELD 55-1 bonds well to damp surfaces, it is easier to control its wetting on a dry surface. A primer is not necessary. However, on surfaces which are too porous or difficult to wet, PRIMKOTE can be used to insure best adhesion. ABOWELD/ABOCURE mixing must be thorough, or "soft spots" may result. Mix in a container that is deeper than it is wide using a paddle or power mixer. The mixing temperature should be above 60°F (16°C). Colder material should be stored at least 24 hours at 60-86°F (16-30°C) before mixing.



Application is easy. In most cases, any bladelike tool, such as a trowel or scraper, is used to spread and fill. Note: After applying ABOWELD a dampened scraper can be used to smooth the surface, being careful not to mix water into the unhardened product.

Hardening, Temperature: The 55-1 system hardens by chemical reaction rather than by drying. It is virtually free of shrinkage and can be applied in any thickness. The hardening reaction generates heat and is accelerated by heat. Larger masses harden much faster (their bulk retains the reaction heat) than smaller masses or thin layers. The same quantity that hardens in 1 hour in a full pint can at room temperature, may need 5 or more hours to harden if spread in a thin layer.

Finishing: After hardening ABOWELD can be smoothed with a sander or grinder.

Curing continues after hardening and completes the reaction to the optimum of all properties, especially hardness, chemical and heat resistance. It occurs spontaneously at room temperature. It can be reduced to just hours or minutes at higher temperatures.

Coating: For best results, sanding and priming with Primkote 8006-1 is recommended before coating.

AVAILABILITY

ABOWELD 55-1 is available in 2 quart, 2 gallon and 10 gallon kits.

RELATED PRODUCTS

ABOCRETE™: Epoxy patching and resurfacing compound.

BestBond® Crack Repair: Epoxy crack-repair compound in convenient 10 fl. oz. cartridge.

BestBond® Joint Sealant: Flexible joint sealant in convenient 10 fl. oz cartridge.

BestBond® Anchor: Epoxy anchoring compound in convenient 10 fl. oz. cartridge.

Primkote 8006-1™: Epoxy primer for applying ABOWELD 55-1 on surfaces which are too porous or difficult to wet.

LIMITED WARRANTY

The above information is the result of accurate laboratory and field tests. However, no guarantee is offered, as uses and applications are beyond our control. The user is urged to test this product under his own conditions. All warranties, including the implied warranties of merchantability and fitness for a particular purpose, are excluded. In the event of manufacturing defects in the product, purchasers' remedies are limited to the replacement of the product or its purchase price.

TECHNICAL HELP

Technical assistance is available by phone at 262-653-2000, by fax at 262-653-2019, or e-mail at info@abatron.com.

FILING

File under Division 3 using CSI master format.



Manufactured by:

ABATRON, INC.

5501-95th Avenue • Kenosha, Wisconsin 53144 USA • 1-800-445-1754

www.abatron.com