

# KEMKO® 008 SP LIQUID BONDER

BONDER - SHORT POT LIFE, STRUCTURAL EPOXY

ADHESIVE LIQUID BONDING AGENT

## TECHNICAL DATA SHEET

PRODUCT IS ONLY AVAILABLE TO KEMKO® APPLICATORS  
IN U.S., CANADA, AND INTERNATIONAL CUSTOMERS

KEMKO® 008 SP Bonder is a liquid two-component, short pot life, structural epoxy adhesive designed for application on horizontal surfaces and in vertical, downward oriented holes. Primary uses include the structural bonding of plastic (fresh) concrete and other construction materials, e.g., hardened concrete, masonry, stone, steel, and wood to themselves or each other and anchoring bolts, dowels, and rebar into vertical, downward oriented holes in concrete, masonry, or stone. It offers vastly superior bond strength compared to acrylic/PVA emulsion bonding agents. It is used for filling small and large voids, with and without aggregate extensions. It is also used for repairing delaminations of hardened concrete to hardened concrete or delamination topping slabs. It can be used for bonding external steel reinforcement for changes in design loads and K-Bracing for seismic reinforcement. Its short working time makes it ideal for placing with plural component spray rig.

- Meets - ASTM C881, Type I, II, IV and V, Grade 2, Class B and C and AASTHO M235, Type I, II, IV and V, Grade 2, Class B and C.
- Meets - ACI 548.13-14 Specification for Bonding Fresh Concrete to Hardened Concrete with a Multi-Component Epoxy Adhesive.

### FEATURES

The physical properties of the product allow its use in applications requiring resistance to creep and stress relaxation, maintenance of mechanical properties at high ambient temperatures, and high-load bearing strength. Exceptional substrate wetting and water displacement properties ensure excellent adhesion under adverse application conditions, e.g., cold, wet concrete.

- Increase working life/cure KEMKO® 008 SP Bonder by blending its Part B with the Part B of the long pot life KEMKO® 001 LP Bonder.
- Increase viscosity of KEMKO® 008 SP Bonder by blending its Part B with Part B of the long pot life KEMKO® 029 SP Bonder.

### TYPICAL USES

- Bonding plastic (fresh) Portland cement concrete to hardened concrete.
- Bonding rigid construction materials to themselves or each other.
- Suitable for horizontal surface bonding of anchor bolts, dowels, and rebar to concrete, masonry, and stone.
- Adjustable viscosity and working time by blending of compatible products, such as KEMKO® 09 SP Paste SWL.

### LIMITATIONS

The recommended minimum substrate temperature during installation and for cure is 50°F (10°C).

- For installation and cure temperatures down to 40°F (4°C) or when a slower cure is needed, use KEMKO® 001 SP.
- The maximum in-service temperature should be 20°F (10°C) below the HDT (Heat Deflection Temperature) in bonding applications subjected to substantial and sustained shear stresses that may cause creep.
- When bonding plastic (fresh) concrete containing resinous

### TECHNICAL DATA

7 days 73°F (23°C) unless otherwise indicated. Compressive strength of cement mortar 4,500 psi (13.0 MPa)

PHYSICAL PROPERTIES		TEST METHOD	VALUE
<b>Mix Ratio by Volume</b>			2:1
<b>Mix Ratio by Weight</b>			100:35
<b>Color</b>	<b>Part A</b> <b>Part B</b> <b>Mixed</b>	Visual	White Black Blue Gray
<b>Weight per Gallon</b>	<b>Part A</b> <b>Part B</b> <b>Mixed</b>	ASTM D1475	12.1 lbs. (5.5 kg) 8.1 lbs. (3.7 kg) 10.8 lbs. (4.9 kg)
<b>Viscosity</b> <b>Poise,</b> <b>50°F (10°C)</b>	<b>Part A</b> <b>Part B</b> <b>Mixed</b>	ASTM D2393	300 10 80
<b>Viscosity</b> <b>Poise,</b> <b>73°F (23°C)</b>	<b>Part A</b> <b>Part B</b> <b>Mixed</b>	ASTM D2393	105 5 40
<b>Viscosity</b> <b>Poise,</b> <b>105°F (41°C)</b>	<b>Part A</b> <b>Part B</b> <b>Mixed</b>	ASTM D2393	35 1 10
<b>Gel Time, 1</b> <b>Quart,</b>	<b>50°F (10°C)</b> <b>73°F (23°C)</b> <b>105°F (41°C)</b>	ASTM C881	0.5 Hours 0.3 Hours 0.1 Hours
<b>Open Time</b>	<b>50°F (10°C)</b> <b>73°F (23°C)</b> <b>105°F (41°C)</b>	AASHTO T237	4 Hours 3 Hours 0.2 Hours
<b>Cure Time</b> <b>Hard Dry</b>	<b>50°F (10°C)</b> <b>73°F (23°C)</b> <b>105°F (41°C)</b>	AASHTO T237	10 Days 4 Days 1 Days
<b>Compressive Yield Strength</b>		ASTM D695	12,000 psi (82.7 MPa)

<b>Compressive Modulus</b>	ASTM D695	350,000 psi (2,413.2 MPa)
<b>Flexural Strength</b>	ASTM D790	11,000 psi (75.8 MPa)
<b>Flexural Modulus</b>	ASTM D790	450,000 psi (3,103 MPa)
<b>Heat Deflection Temp</b>	ASTM D648	120°F (48.9°C)
<b>Bond Pull-Off Strength to Concrete</b>	ASTM C1583	400 psi (2.8 MPa)
<b>Bond Strength, Slant Shear</b>	@ 60°F (15.6°C) @ 14 days	ASTM C882
		1,500 psi (10.3 MPa)
<b>Tensile Strength</b>	ASTM D638	6,500 psi (44.8 MPa)
<b>Elongation at Break</b>	ASTM D638	1.5 %

actual use.

- Do not add solvents or otherwise thin this product.

## PACKAGING

Standard package sizes of Part A + Part B are 3, 15, and 150-gallon (11.36, 56.79 and 567.9 l.) kits.

## SHELF LIFE AND SHIPPING

Three years minimum in unopened, original containers when stored between 50°F (10°C) and 90°F (32°C) in a dry place away from sunlight. Remixing of each component may be required upon prolonged storage.

## COLOR SELECTION

The standard color of the mixed components is concrete blue-gray. Custom colors are available and may require minimum quantities and/or slightly higher cost.

## CHEMICAL RESISTANCE

KEMKO® 008 SP Bonder has excellent resistance to a wide range of commonly encountered chemicals including acids and bases, aircraft and automotive fluids, petroleum fuels, cutting oils, etc. It has limited resistance to hydrocarbon solvents. Performance is a function of the specific chemical and concentration, ambient and solution temperatures, exposure times, and housekeeping procedures. For information on specific chemicals and exposure conditions, contact a ChemCo Systems technical representative.

## SURFACE PREPARATION

Substrate surfaces must be dry or damp, sound and free of all bond-inhibiting substances. Prepare surfaces in accordance with International Concrete Repair Institute, ICRI Guideline No. 310.2R Selecting and Specifying Concrete Surface Preparation for Sealers, Coatings, Polymer Overlays, and Concrete Repair, Concrete Surface Profile, CSP 2 to CSP 4. The concrete surfaces should have a minimum strength of 250 psi (1.72 MPa) in direct tension per ASTM C1583

Standard Test Method for Tensile Strength of Concrete Surfaces and the Bond Strength or Tensile Strength of Concrete Repair and Overlay Materials by Direct Tension (Pull-off Method). Steel surfaces should be cleaned to "white metal" according to SSPC-SP 5/NACE No. 1 White Metal Blast Cleaning is a standard used for white metal blast cleaning put forth by the SSPC (Special Society for Protective Coatings) and NACE (National Association of Chemical Engineers) international standards.

## MIXING

KEMKO® 008 SP Bonder is a two-component adhesive. The resin to hardener (Part A : Part B) mix ratio is 2:1, by volume. Premix the individual components before drawing from bulk packaging. Wear safety glasses and clean neoprene rubber gloves when handling the material. Transfer the appropriate quantities of Part A and Part B into a mixing container. Use quantities that can be applied before the pot life of the material expires. Blend thoroughly using a Jiffy mixer blade attached to a low speed (350-750 rpm) electric or pneumatic drill. Proper mixing will take 2-3 minutes.

## INSTALLING

Pour mixed material onto the prepared substrate and spread to the specified coverage with a V-notch trowel, squeegee, or paint roller. For large areas, spray application of the material is recommended. When mating two solid surfaces, apply a bonding agent to both surfaces. Allow all coated substrate surfaces to rest for 5-10 minutes before pouring fresh concrete or mating with another surface. In plastic (fresh) to hardened concrete bonding applications, the bond line should be at least 15 mils (0.38 mm). Lightweight concrete may require a second coat of epoxy adhesive. In other bonding applications, bond line thickness is less critical but should be at least 4 mils (0.1 mm) above the peaks of the surface profile. For additional application information, see ACI 503R, Chapter 7, Applying Epoxy Compounds.

## AGGREGATE EXTENSION

One gallon of neat KEMKO® 008 SP Bonder yields 231 cubic inches, which can be extended with uniform size sand that has been washed, kiln dried, and bagged.

- Add up to two gallons of aggregate to one gallon of epoxy for a pourable aggregate extension, which yields approximately 500 cubic inches. Use 20 – 60 US Sieve Mesh, aggregate should be round or tending toward round for best flowability.
- Add up to five gallons of aggregate to one gallon of epoxy which yields approximately 1,100 cubic inches of epoxy mortar.
- For troweling or patching use a flooring mortar tri-blended, with the larger aggregate angular in shape.

Note: ChemCo Systems can recommend pre-coated aggregate when it is required for safety reasons.

## SAFETY

This bulletin does not accompany the product when sold. For hazard warnings, safe handling, and first aid instruction, CAREFULLY READ THE SAFETY DATA SHEETS AND CONTAINER WARNING LABELS.



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**Part A:** Liquid epoxy resin, HMIS Health Hazard Rating-2 (Moderate Hazard). Warning! Causes eye and skin irritation. May cause an allergic skin reaction, Harmful if swallowed. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling. Avoid prolonged or repeated contact with skin.

**Part B:** Liquid epoxy hardener, HMIS Health Hazard Rating-3 (Serious Hazard). Contains alkaline amines. Danger! Causes severe eye and skin burns. May cause allergic skin and respiratory reaction, combustible, corrosive. Do not get in eyes or skin or on clothing. Avoid breathing vapor. Keep container closed. Use only with adequate ventilation. Keep away from heat and open flame..

### CLEAN-UP / DISPOSAL

All tools and equipment must be cleaned before the mixed material cures. Cleaning can be facilitated with a solvent such as acetone or heavy-duty detergents. Cured material may be removed from equipment and tools by soaking in an epoxy stripper.

### TECHNICAL SUPPORT

Additional information, technical assistance, and management services are also available from a ChemCo Systems' Technical Consultant at [sales@chemcosystems.com](mailto:sales@chemcosystems.com) or 650-261-3790.

*The properties listed in this bulletin are typical and descriptive of the product and should not be used for specification purposes. For specification preparation, reference the specification of this product available from ChemCo Systems. This product is available only through KIP™ System (KEMKO® Injection Process) applicators.*



**Limited Warranty:** Please read all information in the General Guidelines, Technical Data Sheets, Guide Specifications and Safety Data Sheets (SDS) before applying material. These products are for professional use only and preferably applied by professionals who have prior experience with ChemCo Systems materials or have undergone training in application of ChemCo Systems materials. Published technical data and instructions are subject to change without notice. Contact your local ChemCo Systems representative or visit our website for current technical data, instructions, and project specific recommendations.

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