

# ZEROSET<sup>®</sup> W.J. ADHESIVE

- PRODUCT CODE:** 3544 - 800cc pack
- DESCRIPTION:** **ZEROSET W.J. ADHESIVE** is a 2 pack filled thixotropic epoxy system. It is formulated for the bonding of metal plates to concrete and/or the bonding of Hypalon membrane to concrete or metal.
- PACKAGING:** **ZEROSET W.J. ADHESIVE** is supplied in two lever lid plastic containers, one contains the base resin the other contains the curing agent the larger container being used for mixing.
- PREPARATION:** **Concrete** - the surfaces of all concrete must be sound and free from laitance oil or other deleterious substances.
- Steel** - should be free of oil, grease, rust and blue mill scale. For maximum adhesion the ideal preparation of the surface is grit blasting. However on occasions firm adherent rust is permissible.
- In the event that the prepared steel surface is to be exposed to the atmosphere for more than 30 minutes before being fully coated with the adhesive, then a suitable blast primer must be applied. The recommended primer is **PVB adhesion promoter**.
- Methods of achieving suitable preparation on the above substrates are either by high pressure water jetting, light needle gun techniques, controlled grit blasting (wet or dry) and controlled acid etching. If in doubt, please consult Rotafix Technical Department.
- Other substrates** - in the case of timber, stainless steel or other non-ferrous metals including galvanised steel, please consult our Technical Department for further information.
- Hypalon** - in the case of Hypalon strip, it is necessary to clean the Hypalon with a de-greasing agent such as Trichlorethylene, methylated spirits or acetone immediately prior to application of the adhesive. See diagrams overleaf for installation method.
- MIXING:** The 800cc pack may be mixed by hand using a suitable pallet knife, code 3642. Add the total contents of the hardener container to the contents of the base container and mix thoroughly to obtain a uniform grey colour.
- APPLICATION:** The mixed materials must be applied within 30 minutes of mixing, assuming an ambient temperature of 15°C. Methods of application are by spatula or plastic comb or, where large quantities are involved, using a steel float. In general aim for a minimum coverage of the surface(s) conducive with 100% wetting. In the case of plate bonding, the adherent layer should be a minimum of 1mm thick and, ideally, 3-4mm at each end of the plate. Anti-peel bolts should be tensioned after bonding and curing.
- CURED PROPERTIES:** Initial cure will be achieved within 24 hours at 15°C. Allow 7 days for full chemical cure. **ZEROSET W.J. ADHESIVE** will cure at temperatures down to -2°C. However the temperature of the mix must not be less than 10°C when installed. When fully cured the compressive strength will be > 60N/mm<sup>2</sup>. Tensile strength: 16N/mm<sup>2</sup>. Flexural strength: 32N/mm<sup>2</sup>.
- SPECIFIC USES:** Bonding of steel to concrete and the bonding of Hypalon strip to concrete.
- CLEANING OF TOOLS:** Uncured **ZEROSET W J. ADHESIVE** may be readily removed from tools and equipment with Rotafix **S200 PC** Solvent Cleaner. Mechanical methods are required to remove cured material.

Epoxy resins and their associated curing agents can cause irritation to some people. Please take the necessary precautions indicated in the COSHH details available from our offices. Please read our Users Safety Guide on the Handling of Resin and Polymer products.

The information in this document is based on practical tests, but given without guarantee inasmuch as methods of use by others is beyond our control. Due to continuing development and improvements, it may be necessary to change without notice the material specification. All goods are sold subject to our Standard Conditions of Sale.

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