

ABOWELD 8305-5 Dewatering System

2-Component Structural Adhesive Paste
to Install Water-Channelling Systems

*The original, most imitated, most advanced,
most versatile product of its kind.*



ABATRON, INC.

SUGGESTED USES:

- Bonding metal and plastic channels to floors and walls to divert leaking water into drains or sump-pumps.
- Basement and other underground water control.
- Proven permanent adhesion to dry and wet concrete, masonry, metal, wood, extruded vinyl or aluminum channels, most rigid surfaces.
- No-slump buildup of tough and chemical resistant surfaces on walls.
- Filling cracks, reshaping edges and corners, replacing missing volumes of eroded and corroded floors, steps, columns, banisters and other structural or decorative components.

SPECIFICATIONS

ABOWELD 8305-5:	Resin Blend	White	Thick Paste	12.5 lbs/gallon approx.
ABOCURE 8305-5:	Hardener Blend	Black	Thick Paste	10.3 lbs/gallon approx.

Proportioning: Equal volumes of ABOWELD and ABOCURE are mixed thoroughly for normal dewatering applications. This ratio offers the best balance of flexibility, adhesion and ease of use.

Mixed color: GRAY. Color shade and uniformity allow ratio and mixing control.

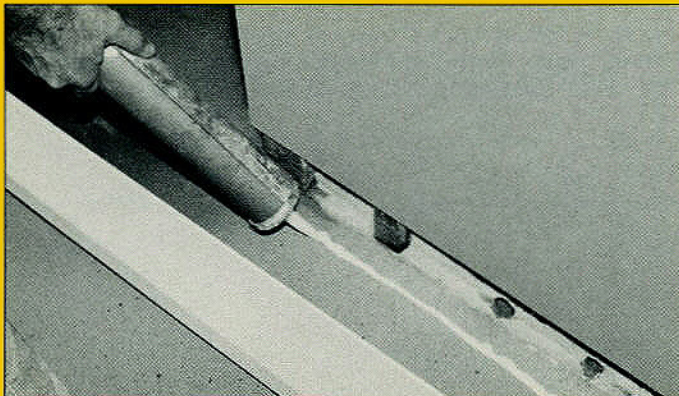
Pot life: 1 hour approx.

Hard: 6 hours at room temperature, much faster with heating. Thicker sections harden faster than thin layers. Cold weather retards hardening, which can become too slow below 10°C (50°F).

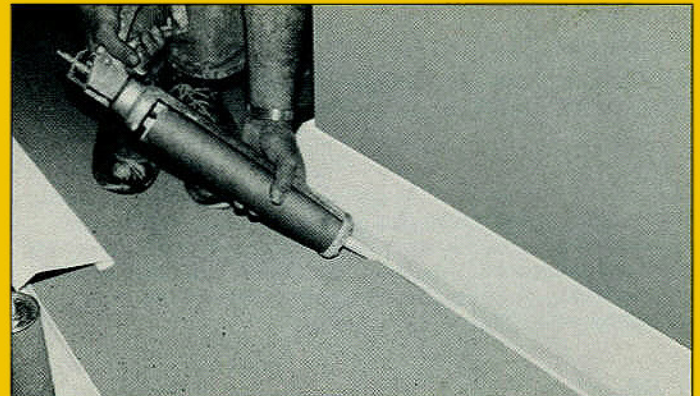
Full cure: 1-3 weeks at room temperature or 1-3 hours at 80-110°C (176-230°F). Heat cure optimizes rigidity, chemical and heat resistance, but is not needed in most cases.

CHARACTERISTICS

- Forms a permanent, stronger-than-concrete bond with: concrete, rigid vinyl and other plastics, metal, ceramics, masonry, bricks, wood, most rigid materials.
- Bonds to wet as well as dry surfaces.
- Exceptionally resistant to atmospheric and humidity conditions, soft and salt water, alkalis and diluted acids, many solvents, fuels, oils, greases and detergents.
- Thixotropic: easy to spread, yet it **does not sag** on horizontal and vertical surfaces.
- **Visual inspection:** the ABOWELD/ABOCURE blend has a uniform gray color. Streaks indicate insufficient mixing. Further, the shade of gray indicates the ratio actually used by the operator (lighter color means more resin, darker more hardener).
- Also available in other colors: White, Red, Green, Yellow, Buff, Brown, Black, Blue.

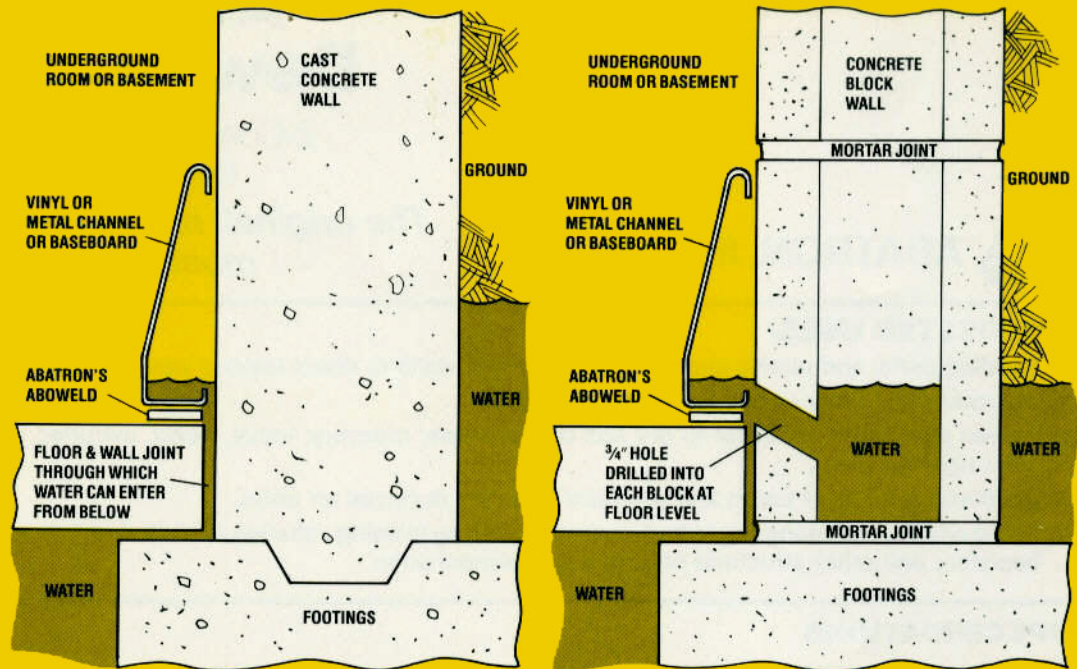


A bead or ribbon of ABOWELD (mixed with ABOCURE) is applied with caulking gun or other means on clean, sound surface where the vinyl or metal dewatering channel is to be bonded.



The baseboard-shaped channel is placed on the ABOWELD mix within an hour, before it hardens.

These drawings show the two general patterns of dewatering systems. Dewatering channels bonded with ABOWELD 8305-5 are the practical and inexpensive solution when digging drainage systems around the building and filling cracks and holes are too expensive or not feasible.



INSTRUCTIONS FOR USE

Surfaces must be thoroughly clean and free of foreign matter, dust or loose debris. Sandblasting, scarifying, roughening, washing, degreasing or muriatic acid etching are recommended as fitting the particular job. The "laitance" surface of new concrete must be removed with etching or mechanical means. Although the 8305-5 System bonds well to wet surfaces, it is easier to control its wetting and effectiveness on a dry surface.

Priming is not necessary with the 8305-5 System. However, in cases where the surface being bonded to is too porous or too difficult to wet, PRIMKOTE 8006-1 can be used to insure best adhesion.

ABOWELD/ABOCURE mixing must be thorough, or "soft spots" may result. A rod, paddle, stick or power mixer are all adequate if properly used. If cold, both materials should be stored at over 20°C (68°F) at least one day before use.

Pot life is the time the ABOWELD/ABOCURE blend remains workable in the mixing container, before hardening. Generally, it is measured in masses of 100-500 gms. Larger masses have a shorter pot life (they harden faster). Smaller masses or thin layers require a much longer time to harden.

An **induction period** (waiting period in the mixing container, after mixing) of at least 5-10 minutes may be necessary to avoid "tacky hardening" of thin surface layers exposed to high ambient moisture and CO₂ during hardening.

Application is easy. For dewatering systems, a bead is dispensed from a caulking gun on both the floor and wall areas

where the aluminum or vinyl channel must be bonded; then, the channel is immediately placed onto the beads (complete details will be given upon request). For general purposes, a trowel, scraper or any bladed tool could be just as appropriate as a caulking gun for filling, resurfacing or shaping.

Hardening, Temperature: The 8305-5 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 6 or more hours if spread in a thin layer. Heating accelerates hardening. For instance, the 8-hour hardening at room temperature can be reduced to 4-8 minutes at 80°C (176°F), or even less at higher temperatures. In a cold environment, ABOWELD and ABOCURE can be heated separately to reduce the viscosity and thereby facilitate mixing. This also accelerates hardening. Cold surfaces could also be heated for better wetting and adhesion.

Curing completes the reaction to the optimum of all properties (especially hardness, chemical and heat resistance). It occurs spontaneously at room temperature, and lasts 4-5 or more days. It can be reduced to just hours or minutes at higher temperatures. As explained above, heat cure is unnecessary for normal dewatering systems on floors and walls.

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 and adapt the above data in his own conditions and environment previous to product adoption. Specifications may be subject to state-of-the-art changes.



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