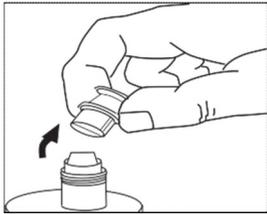


## Surface Preparation

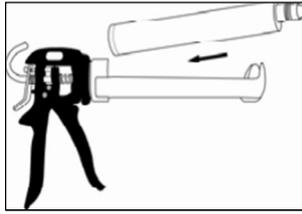
Miracle Bond® is an ideal bonding agent to multiple surfaces including concrete, brick, wood, stone, block, and metal. Surfaces must be clean and profiled or textured. New concrete must be a minimum of 28 days old. All dirt, oil, debris, wax, grease or dust must be removed. Prepare the surface mechanically using a scarifier, sandblast, shotblast, bushhammer or other equipment that will give the surface profile needed for the application. A roughened surface is imperative to good adhesion.

- Always be sure the bonding surfaces are prepared in advance before starting a new cartridge or mixing product. If at all possible, schedule dispensing to consume an entire cartridge at one time with no interruption of epoxy flow. For quart kit, mix only enough Miracle Bond Easy Flow that can be used within 8 minutes at 75°F (24°C).
- When bonding two surfaces together, make sure to completely fill all the gaps between the mating surfaces.
- To achieve maximum flow and reduce fatigue, the tip of the nozzle can be snapped off at the narrowest point of the nozzle.

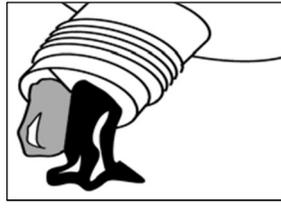
## Cartridge Set up



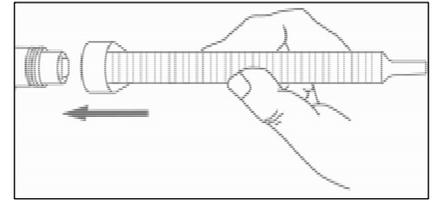
**I.** Remove plastic cap and plug from threaded end of cartridge.



**II.** Place cartridge into any standard caulking gun.



**III.** Dispense small amount of adhesive into a disposable container until both flow from cartridge.



**IV.** Attach mixing nozzle to cartridge and dispense a small amount of material into same waste container until a consistent color with no streaks is obtained.

## Spall Patching Application

**WARNING:** Use Miracle Bond Easy Flow for **SMALL SPALL REPAIRS ONLY**. A deeper or larger mass than recommended will generate excessive heat resulting in undesirable reactions such as bubbling and cracking.

(\*\*\*For larger spalls use slower cure Miracle Bond® 1450)

For Miracle Bond® Easy Flow, the spall should be ground to a depth of ½” (1.27cm) to 5/8” (1.6cm) deep and width no greater than 3” (7.6cm). Avoid a feathered edge by cutting around the spall into sound concrete with a grinder or circular saw

using a diamond or concrete abrasive blade so the entire depth of the spall is consistent. For patching concrete or wood surfaces, fill the void with the Miracle Bond epoxy to just above the surface level and trowel flush.

## Crack Injection Repair

- I. Place and secure injection ports with the Miracle Bond capping gel taking care not to leave any pin-holes. Port spacing should be approximately 6-12” (15.2 – 30.5 cm) apart (typically the width of the concrete member). **Do not allow the epoxy to block the passage between the port and the crack face.**
- II. Place additional Miracle Bond between the ports making sure the entire face of the crack is sealed off and ports are securely fastened to the concrete. If the crack is evident and accessible on the back side of the concrete member seal with capping gel.
- III. Allow the Miracle Bond® to cure before injecting the crack with an ATC Crackbond product such as Crackbond LR321.

### NOTE:

Epoxy cure is affected by temperature. Low temperatures will increase cure time, higher temperatures will decrease cure time.



*Capping cracks*



*Securing ports*

**Safety Note:** Component “A” contains epoxy resin and is an irritant / sensitizer; component “B” contains amines and is a corrosive / sensitizer; prior to using the epoxy material, please consult the material safety data sheet for proper handling instructions. Always wear protective safety glasses and gloves when working with epoxies and chemicals.

**Coverage:** The 8.6 oz/ 266 ml cartridge will yield approximately 20 linear feet (6.1 m) when drawing a 1/4" x 1/4" (.64 x .64 cm) bead. When used as a capping material for crack injection estimate roughly 5-7 linear feet per cartridge. The quart kit will yield approximately 1/3 sq. ft. (309.7 cm<sup>2</sup>) at 1 inch depth (2.54 cm)