

TECHNICAL DATA SHEET

**DESCRIPTION**

Pro-Poxy™ 204 is a 100% solids, fast setting, two component, high modulus, medium viscosity, moisture tolerant structural epoxy adhesive that meets the requirements of ASTM C-881 and AASHTO M-235. The Pro-Poxy™ 204 is slightly thinner than the Pro-Poxy™ 200.

**USE**

The primary use of the Pro-Poxy™ 204 is for bonding fresh concrete to hardened concrete. Pro-Poxy™ 204 has excellent adhesion to most construction materials. Pro-Poxy™ 204 may be used for anchoring bolts, dowels and reinforcing steel in concrete.

**FEATURES**

- High strength structural adhesive meeting ASTM C-881 and AASHTO M-235
- Ideal for bonding fresh concrete to hardened concrete
- Secondary use for anchoring dowels, bolts and reinforcing steel
- Medium viscosity pumpable formula
- Moisture tolerant
- Excellent adhesion to most materials

**PROPERTIES**

Meets Specifications: ASTM C-881 (Except for Gel Time), AASHTO M-235, Types I, II, IV, V, Grade 2, Classes B & C

Mix ratio – 1:1, part A to part B by volume

Color (mixed) – Gray

Viscosity (D-2393) – 5800 cps

Gel time – 18 min. @ 73°F (23°C)

Compressive Yield Strength - ASTM D-695:  
7Days: 12,800 psi (88.5 MPa)

Concrete Bond Strength – ASTM C-882:  
2 days: 3,000 psi ( 20.7 MPa)  
14 days 4,300psi (29.6 MPa)

Tensile strength – ASTM D-638:  
7,200 psi (49.6 MPa)

Modulus of Elasticity (ASTM D-695):  
230,000 psi (1585.8 MPa)

Elongation at break – ASTM D-638: 3.5%

Water Absorption – ASTM D-570: 0.52%

Heat Deflection (ASTM D-648): 125 F (51.67 C)

**VOC**

Pro-Poxy™ 204 has a VOC content of 0 g/L. Compliant with all Canadian and US VOC regulations including Federal EPA, OTC, LADCO, SCAQMD & CARB.

**Estimating Guide**

Apply Pro-Poxy™ 204 at a thickness of approximately 20 mils [80 sq. ft. /gal., 1.96 sq m /L].

**Packaging**

PRODUCT CODE	PACKAGE	SIZE	
		Gallons	Liters
140127	Cartridge	0.159	600 ml
140112	Unit	1	3.8
140117	Unit	2	7.6
140123	Unit	10	37.9

**STORAGE**

The material should be stored at 40° -95°F (5°-35°C). Shelf life of properly stored cartridges is 12 months and 24 months for all other unopened units.

**Surface Preparation:**

Surface to be bonded must be clean and sound. Remove oil, dirt, grease, laitance, curing compounds and other foreign matter that may cause a problem with bond. Abrasive blast cleaning and mechanical removal methods are recommended. All drilled holes must be cleaned with a cylindrical bristle brush to remove all loose material. Use clean, oil free, compressed air to blow out any remaining dust or debris prior to installation.

**Mixing:**

Condition material to 65°- 85°F (18°- 29°C) before using. Premix each component then place 1 part by volume of Component A and 1 part by volume of component B into a clean pail and mix for three minutes with a low speed drill using a Jiffy mixer or paddle until uniformly blended. Mix only what can be used within the pot life. Air, material, and surface temperatures must be 40°F (5°C) prior to mixing or installation.

**Placement:**

As a structural adhesive and for bonding fresh concrete to hardened concrete, apply the Pro-Poxy™ 204 material neat by brush, roller or spray and work into substrate. While Pro-Poxy™ 204 is still tacky, place the fresh concrete. For anchoring dowels, bolts, reinforcing steel, etc., the depth of the hole should be approximately 9 to 15 times the bolt diameter. The space (annulus) around the bolt in the hole should not exceed 1/8 in. (0.3 cm). Always dispense the Pro-Poxy™ 204 into the anchoring hole filling from the bottom up. Insert the bolt, dowel or anchor turning slowly during insertion. After insertion, the hole should be completely full of epoxy.

To produce a mortar for interior patching repairs, mix 1 to 4-1/2 parts by volume clean, dry, well graded silica sand to 1 part by volume of mixed Pro-Poxy™ 204. Mix thoroughly until all of the sand is wet and evenly dispersed. First, apply a prime coat over the area to be repaired with the neat Pro-Poxy™ 204. Place the mortar working it well into the surface of the concrete before the prime coat becomes tack free. Lifts should not exceed 1 in. (2.5 cm) in thickness.

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**CLEAN UP**

Tools and Equipment: Clean before the epoxy sets up.  
Use Xylene or Unitex Citrus Cleaner.

**LIMITATIONS****FOR PROFESSIONAL USE ONLY**

Minimum age of the concrete must be 21-28 days from date of placement depending on curing and drying conditions. If the Pro-Poxy™ 204 is no longer tacky during bonding operations, and within 16 hours after application of the bonder, clean and solvent wipe the area and re-apply the Pro-Poxy™ 204 epoxy. If more than 16 hours has lapsed since application, the area must be lightly sanded or abraded and solvent wiped clean prior to re-application of the Pro-Poxy™ 200. Always test a small amount of Pro-Poxy™ 204 to ensure that the product is mixed properly and thoroughly and that the material will harden properly before proceeding with the installation. Do not thin with any solvents.

Surface, ambient air, and material temperatures must be 40°F (5°C) or above.

Do not expose stored or uncured product to cold temperatures below 35°F (2°C), for any length of time. Epoxies may yellow, discolor, or chalk upon exposure to strong sources of Ultra-Violet radiation such as from sunlight, and some types of industrial artificial lighting.

Note: High temperatures will accelerate the setting time and cool temperatures will slow the setting time. As a general rule, the gel time of the epoxy will be cut in half for each 10° to 15° increase in temperature above 75°F (24°C).

**PRECAUTIONS****READ SDS PRIOR TO USING PRODUCT**

Component A – Irritant

Component B – Corrosive

Product is a strong sensitizer

Use with adequate ventilation

Wear protective clothing, gloves and eye protection (Goggles, Safety Glasses and/or Face Shield)

Keep out of the reach of children

Do not take internally

In case of ingestion, seek medical help immediately

May cause skin irritation upon contact, especially prolonged or repeated.

If skin contact occurs, wash immediately with soap and water and seek medical help as needed

If eye contact occurs, flush immediately with clean water and seek medical help as needed

Dispose of waste material in accordance with federal, state and local requirements

Cured Epoxy Resins Are Innocuous

**MANUFACTURER**

Dayton Superior Corporation  
1125 Byers Road  
Miamisburg, OH 45342  
Customer Service: 888-977-9600  
Technical Services: 877-266-7732  
Website: [www.daytonsuperior.com](http://www.daytonsuperior.com)

**WARRANTY**

Dayton Superior Corporation ("Dayton") warrants for 12 months from the date of manufacture or for the duration of the published product shelf life, whichever is less, that at the time of shipment by Dayton, the product is free of manufacturing defects and conforms to Dayton's product properties in force on the date of acceptance by Dayton of the order. Dayton shall only be liable under this warranty if the product has been applied, used, and stored in accordance with Dayton's instructions, especially surface preparation and installation, in force on the date of acceptance by Dayton of the order. The purchaser must examine the product when received and promptly notify Dayton in writing of any non-conformity before the product is used and no later than 30 days after such non-conformity is first discovered. If Dayton, in its sole discretion, determines that the product breached the above warranty, it will, in its sole discretion, replace the non-conforming product, refund the purchase price or issue a credit in the amount of the purchase price. This is the sole and exclusive remedy for breach of this warranty. Only a Dayton officer is authorized to modify this warranty. The information in this data sheet supersedes all other sales information received by the customer during the sales process. THE FOREGOING WARRANTY SHALL BE EXCLUSIVE AND IN LIEU OF ANY OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, AND ALL OTHER WARRANTIES OTHERWISE ARISING BY OPERATION OF LAW, COURSE OF DEALING, CUSTOM, TRADE OR OTHERWISE.

Dayton shall not be liable in contract or in tort (including, without limitation, negligence, strict liability or otherwise) for loss of sales, revenues or profits; cost of capital or funds; business interruption or cost of downtime, loss of use, damage to or loss of use of other property (real or personal); failure to realize expected savings; frustration of economic or business expectations; claims by third parties (other than for bodily injury), or economic losses of any kind; or for any special, incidental, indirect, consequential, punitive or exemplary damages arising in any way out of the performance of, or failure to perform, its obligations under any contract for sale of product, even if Dayton could foresee or has been advised of the possibility of such damages. The Parties expressly agree that these limitations on damages are allocations of risk constituting, in part, the consideration for this contract, and also that such limitations shall survive the determination of any court of competent jurisdiction that any remedy provided in these terms or available at law fails of its essential purpose.