

# GI 168-004

## EP-Adhesive

- Universally useable
- Usable on fresh concrete
- Pigmented
- Total Solid according to the test method of Deutsche Bauchemie



<b>Product description:</b>	GI 168-004 is a mineral based, filled reaction plastic based on epoxy resin.
<b>Usage area:</b>	<ul style="list-style-type: none"><li>• Gluing of synthetic tapes for the purpose as sealant; repair of mineral based substrates; gluing of concrete and natural stones</li></ul>
<b>Usage:</b>	<ul style="list-style-type: none"><li>• Construction adhesive for minerally bound substrates</li><li>• Filler for sealing of wide cracks</li><li>• Repair of damaged joints in industrial floor surfaces</li><li>• Flex band glue for expansion and movement joints as well as for moving cracks</li></ul>
<b>Properties:</b>	<ul style="list-style-type: none"><li>• Thixotropic and adjusted for filling</li><li>• Good adhesive strength, high stability and little shrinkage</li><li>• Applicable vertically, horizontally and overhead</li><li>• Fulfils requirements according EN 1504-4</li></ul>
<b>Substrate:</b>	<ul style="list-style-type: none"><li>• Mineral-based substrates</li><li>• Residual moisture on cement-based substrate: &lt; 6 % (by CM method)</li></ul>

## Technical Data

<b>Colour:</b>	Grey
<b>Pack size:</b>	6 kg; other units on request
<b>Storage life:</b>	From production date 12 months; store in original containers; dry, cool, frost free
<b>Density at 23°C / 50 % air humidity: EN ISO 2811-1:2011</b>	Approx. 1.5 g/cm <sup>3</sup>
<b>Adhesive pull strength: EN 1542</b>	> Concrete fracture
<b>Compressive strength: EN 12190</b>	> 30 N/mm <sup>2</sup>
<b>Flexural strength: EN ISO 178</b>	≥ 2000 N/mm <sup>2</sup>
<b>Solid parts</b>	Approx. 100 %
<b>Viscosity (25 °C, V03.4): EN ISO 2884-1:2006</b>	Componente A: paste-like Componente B: paste-like
<b>Mixing ratio:</b>	3 : 1 (by weight)
<b>UV-resistance:</b>	A slight change in colour and some chalking is expected.

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<b>Chemical resistance:</b>	When completely cured resistant against: Water, sea and wastewater, numerous brines, diluted acids, saline solutions, mineral oils, lubricants, fuels and many solvents (with some materials a change in colour is possible). We advise to carry out suitability tests in advance.
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### Processing Data:

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<b>Material usage:</b>	Approx. 1.5 kg/m <sup>2</sup> /mm layer thickness 0.8 – 1.1 kg per running meter flex tape (width 200 mm) These values are dependent on how the product is processed and on the substrate. The values are therefore only for a rough estimate.
<b>Processing time (50 % air humidity):</b>	20 – 30 minutes (30 °C) 40 – 60 minutes (20 °C) 90 – 120 minutes (10 °C)
<b>Revision time (at 50 % air humidity)</b>	Min. 4 - 15 hours at 30 °C Min. 8 - 24 hours at 20 °C Min. 12 - 30 hours at 10 °C
<b>Curing time (complete mechanical stress at 50 % air humidity):</b>	3 days (30 °C) 7 days (20 °C) 10 days (10 °C)
<b>Processing temperature:</b>	10 – 30 °C

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### Processing:

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<b>Preparation of the substrate:</b>	<ul style="list-style-type: none"><li>• Substrate must be dry, clean, rough, stable and free of separating substances like oil, fats etc.</li><li>• Must be grinded or blasted. Depending on the preparation work, the surface may be rough in some places which will influence the consumption.</li><li>• The concrete parts to be bonded must be a minimum of 28 days old.</li><li>• We advise to do some testing yourself depending on the intended use.</li></ul>
<b>Tools:</b>	<ul style="list-style-type: none"><li>• As required: trowel, smoothing trowel, roller etc.</li></ul>
<b>Mixing:</b>	<ul style="list-style-type: none"><li>• The single components have to be stirred before use.</li><li>• Curing compound to be poured into resin compound.</li><li>• Mix intensively with slow turning mixer (we advise a double-stirrer with the stirring units turning the opposite direction to each other).</li><li>• Fill into another vessel and mix again.</li><li>• Before applying to the substrate make sure to have an even and smear-free mixture.</li></ul>
<b>Application:</b>	<ul style="list-style-type: none"><li>• Depending on application the product has to be uniformly applied onto the parts which have to be glued via trowel, smoothing trowel, scraper with toothed blades or similar.</li><li>• Pay attention that the bonding is carried out holohedral and free of hollow spaces.</li><li>• Directly after applying the adhesive, the two to be bonded components need to be pressed against each other.</li><li>• At bonding on vertical and overhead areas the construction parts have to be fixed for at least 12 hours depending on temperature and layer thickness.</li></ul>

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- By application as flex tape adhesive the tape is directly pressed onto the freshly spread adhesive GI 168-004 and will be levelled out afterwards again with GI 168-004.

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**Processing conditions:**

- The material, air and ground temperature must be between 10 °C and 30 °C during the processing, installation and curing time.
  - The substrate temperature must be at least 3 °C above the dew point.
  - The air humidity should not be above 80 % at any time. The application should take place when temperature is at a constant or falling value to avoid blisters because of the extension of air inside the substrate. It is important to keep an eye on the ventilation during and after the application. The area must be protected from any direct water contact during the whole curing time.
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**Further information:**

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**CE label:** EN 1504-4:2004

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**Safe Handling:** The product is intended for professional use.  
DGV Rule 113-012: Handling with Epoxy resins  
Please note the current safety data sheets.

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**Disposal:** Disposal with the assistance of a disposal specialist under consideration of the current safety data sheets.

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**GISCODE:** RE 30

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**Data base:**

The determination of all the data and application information is based in laboratory tests. Measured values in practice may differ because of influences beyond our control.

**Legal foundation:**

The following specifications as well as the recommendations for handling and use of our products are based upon our knowledge and experience under normal conditions, at proper storing and application. Because of different materials, substrates and working conditions other than given normal values, a warranty of a working result or a liability – for whatever legal relationship - cannot be justified from these instructions or a verbal guidance respectively, unless intent or gross fault can be imputed to us. Here, the user has to prove that he had transferred in written form, in time and completely every knowledge that is necessary for an appropriate and promising estimation. The user is obliged to test the products on their suitability for the intended purpose. Incidentally our respective terms and conditions of business are valid. You get these on [www.gremmler.de](http://www.gremmler.de). Only the newest edition of this technical data sheet is valid.