



TECHNICAL PRODUCT BULLETIN

GENERAL DESCRIPTION

AL800 is an Epoxy adhesive for raised highway markers requiring the optimum bond strength properties. AL800 is a two-part, solvent less, 100% reactive rapid cure epoxy adhesive. The AL800 has been designed and engineered to meet the following specifications:

- The American Association of State Highway and Transportation officials' (AASHTO) specification M-238-82
- State of California Department of Transportation, specification 8040-51B-09
- State of Texas Department of Highways and Public Transportation, specific D-9-6100 (1, 1M, 11, 111).
- State of Hawaii Highways, specification 712.41 Section B
- State of Oregon Highways, specification 44.2.02 B4

AL800 is a marked improvement over present adhesives in fast setting wet strength, cold temperature cure properties, bond strength, and gel time control. Wet strength tests using AL800 in accordance with AASHTO T-237-32.1 exhibit a three-fold improvement over typical highway marker adhesives.

AL800 reduces coning times to as low as 15 minutes.

Moisture Absorption, % weight increase, 1/4 in x 2 in disc immersed in distilled water @ 25°C:

1 day	1.0
2 days	1.12
3 days	1.28
4 days.....	1.38
5 days	1.90
6 days.....	2.0
7 days	2.19
14 days.....	2.68
21 days	3.05
28 days	3.3

SPECIFICATIONS

HANDLING CHARACTERISTICS

Catalyst Number	Catalyst AL800
Mix Ratio Catalyst to Resin	Weight: 1:1 Volume: 1:1
Gel Time	12 min.
Color	Resin Part A: White Catalyst Part B: Black Mix: Grey
Brookfield Viscosity @ 25°C, poise:	Resin: 1000-3000 Hardener: 1,000-3,000
Shear Ratio, minimum @25°C	2
Density gm/cc	Resin: 1.37 Hardener: 1.43
Storage Stability: Resin and hardener will retain more than 85% of the viscosity and shear ratio for 3 weeks in a closed container at 49°C	
Skinning (original container)	Resin: None Hardener: None

PHYSICAL CHARACTERISTICS

Resin, pounds / gallon:	11.5-11.8
Catalyst, pounds / gallon:	11.5-12.1
Tensile Strength, psi:	7,300
Compressive Strength, psi:	16,000
Elongation, %:	3.4
Flexural Strength, psi:	15,500
Izod Impact, ft · lb / in:	0.35
Heat Distortion, °C:	55

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