

DURAL 618/22

EPOXY MORTAR FOR COVING AND GROUTING



EUCLID CHEMICAL

PACKAGING

DURAL 618/22 is packaged as follows:

1 Litre Resin + 6kg Stonhard 622

Aggregate = 3.64 litres

5 Litre Resin + 5 x 6kg Stonhard 622

Aggregate = 18.20 litres

APPROXIMATE YIELD

Screed: 0.73m²/litre at 5mm thick

Cove: 3.6 linear metres 3mm x 100mm x 100mm x 25mm radius

Tile Grout: 20 linear metres per litre for 10mm x 5mm tile gap

CLEAN-UP

Clean equipment immediately after use with Pro-Struct 105 Cleaner and rinse with clean water.

SHELF LIFE

24 Months if stored between 15°C to 35°C

DESCRIPTION

DURAL 618/22 is a three-component, solvent-free epoxy aggregate filled grout designed to have excellent surface wetting properties with a long working time. In its wet uncured state, the grout can be cleaned off tiles with water. The cured mechanical properties achieved make it the ideal construction site general purpose repair and grouting compound.

PRODUCT CHARACTERISTICS

FEATURES / BENEFITS

- Versatile site grouting compound
- Low exotherm & long working time
- Non-slump vertical applications
- Water smoothable, low toxicity

PRIMARY APPLICATIONS

- Grouting reinforcing bars and anchors
- Bearing pads and machine base supports
- Floor joint and honeycomb concrete repair
- Cove skirting and tile joint grout
- Sealing cracks and correcting levels on floors
- Bonding construction products to concrete

TECHNICAL INFORMATION

The following are typical values obtained under laboratory conditions. Expect reasonable variation under field conditions.

TYPICAL PROPERTIES	AT 25 °C
Colour	Dark Amber
Consistency	Trowelable Mortar
Volume Solids	100%
Number of Components	3
Mix Ratio By Volume (Base:Activator)	2:1 + 6kg # 622 Aggregate
Pot Life	60 to 90 Minutes
Apply Over	Prepared concrete or steel
Apply By	Trowel
Initial Set	8 Hour
Service	24 Hours
Full Cure	7 Days
Application Temperature Range	15 °C to 35 °C
Maximum Service Temperature	60 °C
Compressive Strength	>90 MPa at 7 days Refer to aggregate:resin loading graph
Concrete Bond Strength	Breaks concrete
VOC	<3 g/l

Dural 618/22 (2) July 2026 replaces February 2025

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DIRECTIONS FOR USE

Surface Preparation: Surfaces must be clean, sound and dry. Exposed concrete surfaces must be sandblasted or chipped to show the well-bonded main aggregate. Steel should be grit-blasted, clean, free of rust, paint or foreign matter likely to affect the bond or performance of the repair.

Mixing: Pre-condition material to between 15°C to 25°C before using. Premix each component of the kit. Add the Activator component to the Base component and mix thoroughly for 3 minutes with a slow speed drill. Do not aerate or mix more material than can be placed in 30 minutes. To prepare an epoxy mortar, slowly add pre-packaged Stonhard 622 dry graded aggregate to a kit of mixed resin and mix to a uniform consistency.

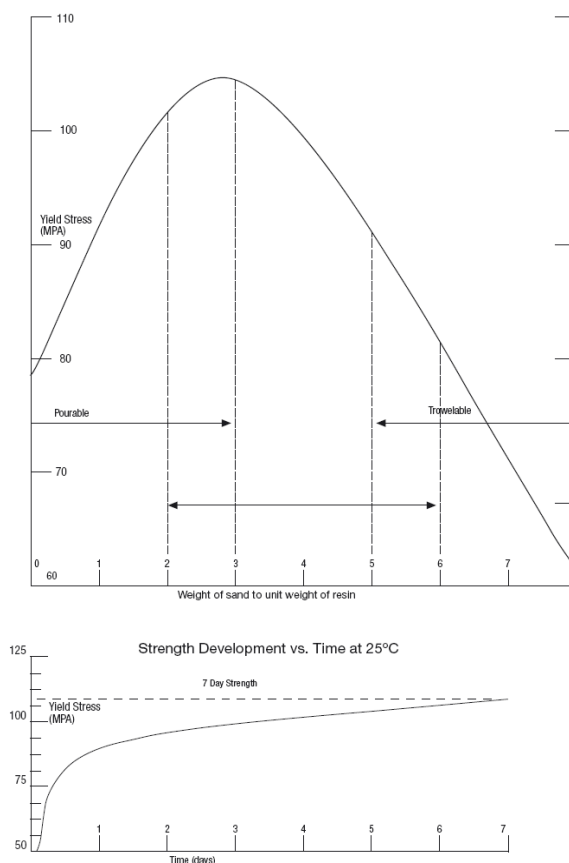
Application: Using a wooden float, apply the mixed mortar to the surfaces, ensuring full contact with base and sides of the cavity. Using a steel trowel or, in the case of tile grouting, a pointing trowel compact and smooth the surface, wiping the trowel with a sponge a water to remove resin tack.

NOTE: The generic chemistry of this product renders the resin prone to solidification when exposed to colder temperatures. This solidification can be reconstituted by gently warming the container (using a warm water bath) and stirring with a spatula until all solidified material has “melted” to a uniform consistency. This will have no detrimental effect on the performance of the product. If unsure, please consult Euclid Technical Services for further advice / guidance.

PRECAUTIONS / LIMITATIONS

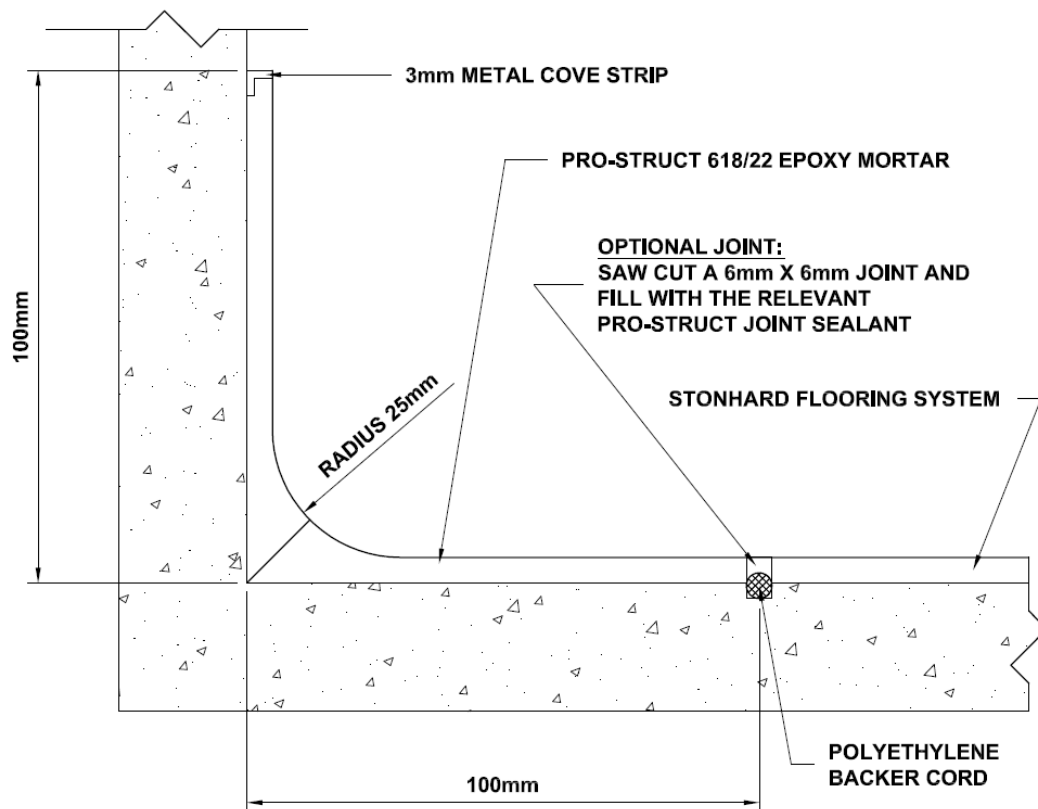
- Application temperature of substrate to be 15°C and rising. Low temperatures adversely affect application spread rates and time to achieve bond.
- Hot temperatures decrease working time.
- Do not apply over wet surfaces.
- Do not thin with solvent.
- Use materials in strict accordance with the manufacturer’s Safety Data Sheet.
- Protective clothing and equipment will significantly reduce risk of injury.
- Body coverage apparel, safety goggles and impermeable gloves are recommended.
- In case of contact, flush with copious amounts of water and seek medical attention.
- Dispose of waste materials and containers in strict accordance with Government regulations.

DURAL 618/22 GROUTING COMPOUND



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APPLICATION PROCEDURE FOR EPOXY MORTAR COVERED SKIRTINGS

- Epoxy mortar covered skirtings shall be installed prior to the installation of the flooring system.
- Install the metal cove strip to the wall to the desired height using contact adhesive, taking care to mask above the cove strip for neatness.
- Prime the prepared plastered / concrete surfaces with Dural 618R at a theoretical coverage of 15 linear metres x 200mm wide per 1 litre kit and broadcast Stonhard 6222 Aggregate into the wet resin. Allow to cure between 6 to 8 hours at 25°C.
- Mix the 1 litre kits of Base and Activator of Dural 618/22 for 2 minutes using a JB Blender. Add the 6kg bag of Stonhard 622 Aggregate and mix for a further 2 minutes. The yield of this kit is 3.64 litres. Using a steel trowel, apply the Dural 618/22 Mortar to the primed concrete and plastered surfaces to a theoretical spreading rate of 3.6 linear metres for a 100mm x 100mm x 25mm radius.
- Form the cove to the desired radius using a suitable coving trowel, and allow to cure for 18 to 24 hours at 25°C.
- Abrade the vertical surface of the cove to remove surface imperfections.
- Overcoat the coving with the proposed flooring sealer.

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