

**DESCRIPTION** Miracle Bond® 1350 is a multi-purpose, rapid cure, high strength epoxy bonding and repair adhesive system. It will bond almost any material together. Its specially formulated non-sag property is also perfect for overhead and vertical repairs.

**PROPERTIES** Gel Time: 8 minutes @ 75°F (24°C)  
Cure Time: 2 hours @ 75°F (24°C)  
Consistency: Non Sag Paste

COLOR	
Part A	White
Part B	Dark Gray
Mixed	Concrete Gray
Mix Ratio	1 : 1

### GENERAL USES and APPLICATIONS

- ❖ Bonds to a multitude of substrates
- ❖ Bonding hardened concrete to hardened concrete
- ❖ A capping paste sealer around ports and cracks for crack injection process
- ❖ Non-sag patching material for non-moving cracks and small spalls. Great for overhead and vertical repair.

### ADVANTAGES and FEATURES

- ❖ Ideal bonding agent for materials including concrete, brick, wood, stone, block, metal and other substrates.
- ❖ Ceramic blend that has high strength and high modulus.
- ❖ 100% solvent free system means low VOC content
- ❖ A moisture insensitive system and can be used on damp surfaces

### PACKAGING of Miracle Bond 1350

Cartridge or Bulk	Part #'s
.85 oz (25 ml) syringe	A1-MB1350
8.6 oz. (254 ml) cartridge	A9-MB1350HN
Quart Kit	B1Q-MB1350

**AVAILABILITY** ATC Miracle Bond products are available through select distributors who can provide you with all your construction needs. Please contact ATC at (800) 892-1880 for a distributor near you.

**WEBSITE** [www.ATCepoxy.com](http://www.ATCepoxy.com)

**SHELF LIFE / STORAGE** 24 month shelf life when stored in unopened containers in dry conditions and stored at 40°F-95°F (4°C-35°C)

Miracle Bond 1350 Technical Data			
Properties		ASTM	75°F 24°C
Gel time 60 gm sample @ 75°F (24°C)	minutes	C881	8
Working Time (nozzle)	minutes		20
Initial Cure Time- @ 75°F (24°C)	hours		2*
Pot Life (bulk 1 gallon only)			n / a
Compressive Yield Strength – psi (MPa)	7 day	D695	8,000 (55.2)
Bond Strength – psi (MPa)	2 day	C882	1,130 (7.8)
Bond Strength – psi (MPa)	14 day	C882	1,690 (11.7)
Consistency or Viscosity		C881	non-sag
Heat Deflection Temp		D648	135°F (57.2°C)
Linear Coefficient of Shrinkage %	cm / cm	D2566	0.004
Volatile Organic Compounds (VOC)	mixed		60 g / l

\*NOTE: Epoxy cure is affected by temperature. Low temperatures will increase cure time, higher temperatures with decrease cure time.

Miracle Bond can be used to replace a pool tile underwater. Apply adhesive to the dry tile and adhere to side wall or bottom surface of the pool. Hold in place for a few minutes. MB1350 is heavier than water and is not recommended for vertical crack or spall repair underwater.

**LEED:** Certificate is available upon request

*Manufactured In The U.S.A.*



*byAdhesives Technology Corp.*

**APPLICATION TEMPERATURE** Substrate and ambient air temperature between 40°F and 100°F ( 4°C and 38°C)

**CONDITION PRODUCT** When the work environment or substrate falls below 70°F ( 21°C) condition the product to 70-75°F ( 21°C – 24°C) prior to use. Temperature will affect the workability and cure time of epoxy.

**COVERAGE** The 8.6oz. (254 ml) cartridge will yield approximately 20 linear feet ( 6,1 m) when drawing a ¼ x ¼ inch (6,35 x 6,35 mm) 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)

**CHEMICAL RESISTANCE** A Chemical Resistance Chart for our Ultrabond, Miracle Bond and Crackbond epoxy products is available upon request. Contact a Technical Service Representative for details.

#### LIMITATIONS & WARNINGS

- ❖ Do not thin with solvents, as this will prevent cure

**SPECIFICATION** Bonding adhesive shall be a two component, 1:1 ratio, 100% solvent free, non-sag epoxy system. The adhesive material must have a minimum 2-day bond strength (ASTM C882) of 1,130 psi at 75°F (7,8 MPa at 24°C.), a minimum compressive strength (ASTM D695) of 8,000 psi at 75°F (55,2 MPa at 24° C.) Shelf life must be a minimum of 24 months. Adhesive shall be Miracle Bond 1350 manufactured by Adhesives Technology Corp., Pompano Beach, Florida.

**MPII MANUFACTURER'S PRINTED INSTALLATION INSTRUCTIONS** Use for spalls no deeper than 5/8" (15,9 mm) or no wider than 3" (76,2 mm) in diameter. Anything larger will result in high heat of reaction and will heave or crack. For larger spall repair, use slower cure formula Miracle Bond 1450. Use for capping and port adhesion for epoxy injection systems. For complete Installation Instructions for Miracle Bond 1350 see MPII on our Website, [www.atcepoxy.com](http://www.atcepoxy.com) or call ATC for more information at 1-800-892-1880.

**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.

**CLEAN UP** Clean tools and equipment with solvent such as xylene, toluene, MEK or WD-40.  
Do not allow epoxy to harden on equipment.

**SAFETY** Please refer to the MSDS for Miracle Bond 1350 published on our Website, [www.atcepoxy.com](http://www.atcepoxy.com) or call ATC for more information at 1-800-892-1880.

**WARRANTY** Adhesives Technology Corporation (ATC) warrants to the Buyer that this product is in good quality and conforms to the manufacturer's specifications in force on the date of manufacture and when used in accordance with the Installation Instructions and when stored as directed in the technical literature. Manufacturer cannot warrant or guarantee any particular method of use, performance or application under any particular condition and Buyer is responsible for determining the suitability of intended purpose and assumes all risks therein. ATC shall not be liable for any injury, loss, cost of labor or consequential damages either directly, indirectly or incidentally, arising out of the use or misuse of any product sold by ATC or another distributor. If the product is proven to be in nonconformance, the Buyers sole remedy shall be a refund of the purchase price or replacement of product.

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