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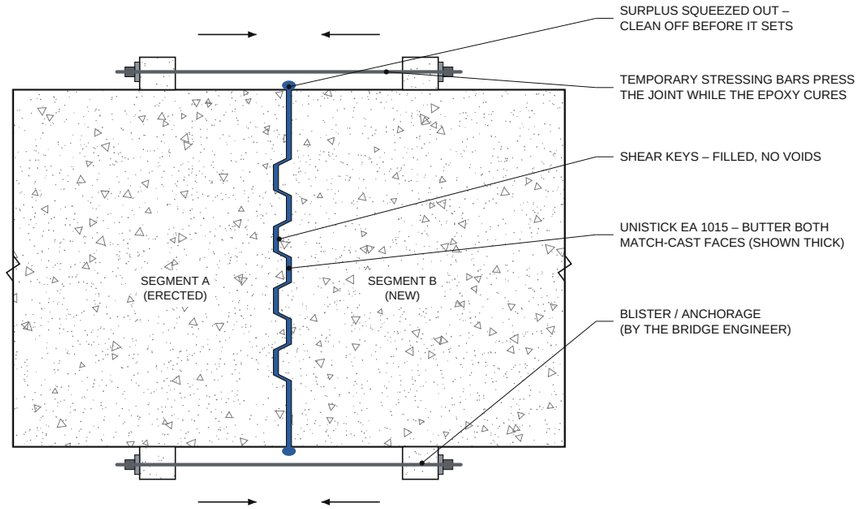
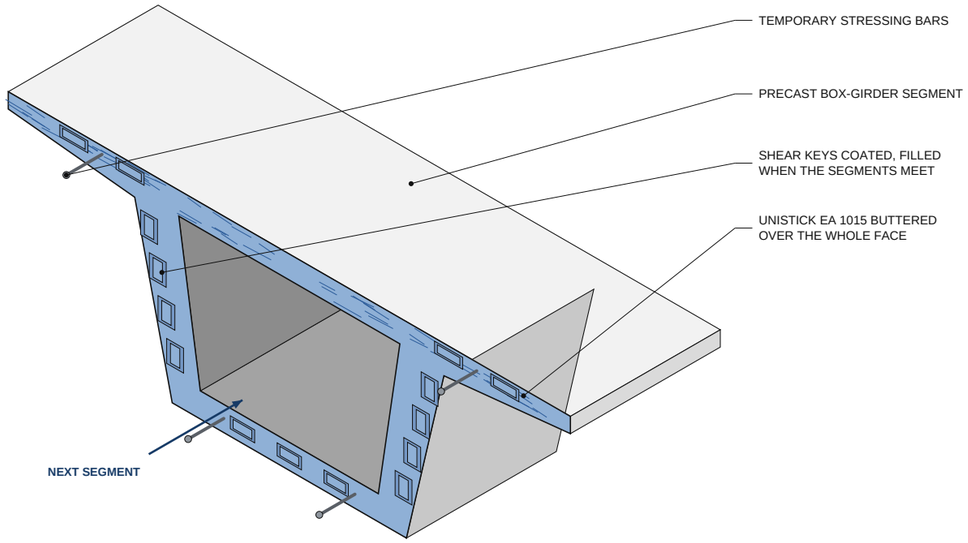


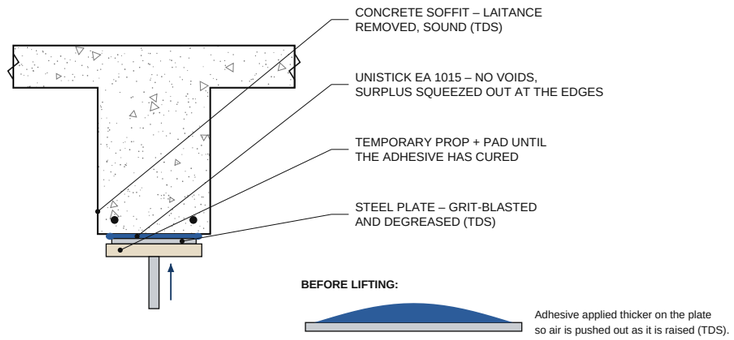

## 1 MATCH-CAST SEGMENT JOINT

SECTION THROUGH THE WEB – SEGMENTAL BRIDGE, NOT TO SCALE



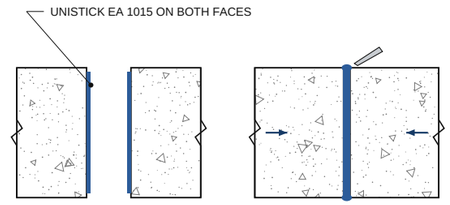

## 2 SEGMENT FACE READY FOR JOINING

3D VIEW – BOX-GIRDER SEGMENT



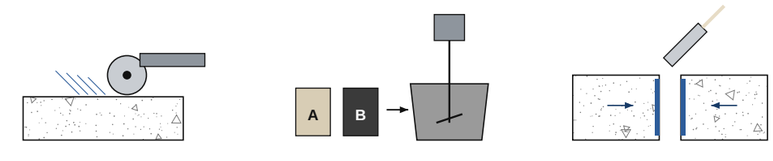

## 3 STEEL PLATE BONDING

SECTION – STRENGTHENING AT A BEAM SOFFIT




## 4 PRECAST ELEMENT JOINT

GENERAL – CONCRETE, STEEL, WOOD, GLASS OR RUBBER




**1 SURFACE PREPARATION**

Concrete: grit blast, scarify, bush hammer or wire brush; cured 14 days min.; pull-off test if in doubt.
Steel: grit blast / power brush, then degrease with solvent.

**2 MIXING**

Stir each part. Add one container of EA 1015-B to one of EA 1015-A (100 : 50) and mix to a uniform grey with a low-speed drill paddle.
Pot life 140 – 180 min at 25°C.

**3 APPLICATION**

Butter both surfaces where possible, press firmly together and clean off the excess. Plates: thicker layer on the plate so no voids form.

## 5 INSTALLATION STEPS

AS TDS

## UNISTICK EA 1015 – TECHNICAL PROPERTIES (TDS)

| PROPERTY | TEST | UNIT | RESULT |
|---|---|---|---|
| **Hardness** | ASTM D2240 | Shore D | approx. 90 |
| **Sag flow** | ASTM D4400 | mm | does not flow |
| **Tensile shear** | ASTM D1002 | N/mm² | approx. 18 |
| **Tensile strength** | ASTM D638 | N/mm² | > 30 |
| **Tg** | ISO 11357-2 | °C | approx. 40 |
| **Compressive strength** | ASTM D695 | N/mm² | > 80 |

Test specimens hardened 4 hours at 80°C (TDS).

## PHYSICAL PROPERTIES (TDS)

| PART | COLOUR | VISCOSITY | DENSITY |
|---|---|---|---|
| **EA 1015-A** | Sandy beige | 60 – 120K cps | 1.70 – 1.80 |
| **EA 1015-B** | Black | 50 – 100K cps | 1.65 – 1.75 |
| **Mixed A/B** | Grey * | Slightly paste | approx. 1.70 |

Viscosity at 25°C; density g/cm³. Mix ratio A : B = 100 : 50.

* TDS table gives N/A; the mixing step says uniform grey.

## GENERAL NOTES (FOR GUIDANCE ONLY)

1. UNISTICK EA 1015 is a two-component epoxy adhesive for dry and damp substrates: jointing precast elements incl. segmental bridges, steel plate bonding, and bonding concrete, steel, glass, wood and rubber (TDS).
2. Segment joints, shear keys, temporary stressing, plate size / anchorage and prop removal are designed by the engineer.
3. New concrete cured min. 14 days; remove laitance and contamination; steam-clean oily concrete (TDS).
4. Mix whole packs only (one A + one B container, 100 : 50). Use within the pot life: 140 – 180 min at 25°C (TDS).
5. Butter both faces where possible, press together and clean off excess before it sets (TDS).
6. Store at 18 – 25°C in sealed containers, keep the hardener dry; 12 months shelf life (TDS).
7. Epoxy resin can irritate skin – wear gloves; eye contact: rinse with water and get medical help. Refer to the SDS.

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**REVISIONS**

| REV | DATE | DESCRIPTION |
|---|---|---|
| 0 | 29/10/26 | FIRST ISSUE |

PRODUCT
**UNISTICK EA 1015**
**TWO-COMPONENT EPOXY ADHESIVE**

DRAWING TITLE
**UNISTICK EA 1015**
**EPOXY ADHESIVE**

DRAWING NO.
**UR-SK-01**

REV
**0**

| SCALE | SIZE | DATE | DRAWN |
|---|---|---|---|
| NTS | A3 | 29/10/26 | UR |

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