



4070 STRUCTURAL ADHESIVE

TECHNICAL DATA SHEET

Product Description: Xtreme Epoxy 4070 is a two-component, 1:1 mix ratio by volume, high performance epoxy supplied in 9 oz and 22 oz cartridges. It is used to install the Crack Stitch® to form a Carbon Fiber Reinforced Polymer (CFRP) system to structurally repair cracks in concrete. It has an extended ambient and substrate application temperature range between 38°F and 110°F (3°C and 43°C).

FEATURES & BENEFITS

- Used to install the Crack Stitch® to form a Carbon Fiber Reinforced Polymer (CFRP) system to structurally repair cracks in concrete
- Concrete gray color & non-sag formula for troweling
- Moisture tolerant, can be applied on damp concrete
- Fast curing; full cure is 7 hours at 75°F (24°C)
- High compression strength, tensile strength, and bond strength to hardened concrete
- Extended application temperature range between 38°F and 110°F (3°C and 43°C)
- Formulated for horizontal, vertical, and overhead installations of the Crack Stitch (CFRP system)

STANDARDS & APPROVALS

- ASTM C881-15, meets Type I, II, IV, & V Grade 3 Class A, B, & C

CARTRIDGE DISPENSING

- Condition the cartridge to 70-80°F (21-27°C) prior to dispensing for optimum results
- Remove the protective cap, insert the cartridge into the correctly sized dispensing tool, and screw on the mixing nozzle to the cartridge
- Dispense enough material to ensure a uniform gray color is achieved first (discard this material) prior to filling the crack and slots
- If working time is exceeded in the mixed material in the nozzle, remove nozzle, clean opening, and install a new nozzle

APPLICATION TEMPERATURE RANGE

Ambient: 38°F to 110°F (3°C to 43°C)

Substrate: 38°F to 110°F (3°C to 43°C)

CFRP SYSTEM INSTALLATION

Refer to the Crack Stitch Technical Data Sheet for installation instructions

CSI SPECIFICATION (CFRP SYSTEM)

A CSI Specification is available to engineers, architects, specifiers, and contractors upon request

PACKAGING

9 oz (8.6 oz actual) & 22 oz (21.2 oz actual) Cartridges

COLOR & RATIO

Part A (Resin): White; Part B (Hardener): Dark Gray
Mix Ratio: 1:1 by volume; Mixed Color: Gray

LIMITATIONS

Do not thin with solvents as this will prevent cure

SHELF LIFE & STORAGE

24 months when stored in dry and dark conditions;
store between 40°F (4°C) and 95°F (35°C)

SAFETY & CLEAN-UP

- Wear appropriate personal protective equipment; refer to the Safety Data Sheet (SDS) for Xtreme Epoxy 4070
- Clean tools and equipment using a mild solvent
- Cured material may only be removed mechanically using a sander or grinder
- Collect with absorbent material and flush area with water; dispose of in accordance with local, state and federal disposal regulations

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PHYSICAL PROPERTIES (ASTM C881-15 TESTING)

Property	Cure Time	ASTM Standard	Units	Sample Conditioning Temperature				
				Class A	Class B	Optional	Optional	Class C
				38 °F (3 °C)	50 °F (10 °C)	75 °F (24 °C)	110 °F (43 °C)	125 °F (52 °C)
Gel Time - 60 Gram Mass	----	C881	min	14	13	10	2 ⁴	2 ⁴
Consistency or Viscosity	----	C881	----	Non-sag				
Compressive Yield Strength	7 day	D695	psi (MPa)	12,980 (89.5)	13,280 (91.6)	14,480 (99.8)	14,500 (100.0)	13,430 (92.6)
Compressive Modulus			psi (MPa)	534,900 (3,688)	506,100 (3,489)	475,900 (3,281)	599,600 (4,134)	585,600 (4,038)
Bond Strength Hardened to Hardened Concrete	2 day	C882	psi (MPa)	2,700 (18.6)	2,770 (19.1)	2,780 (19.2)	3,150 (21.7)	2,050 (14.1)
	14 day		psi (MPa)	2,860 (19.7)	2,950 (20.3)	3,110 (21.4)	3,050 (21.0)	2,080 (14.3)
Bond Strength Fresh to Hardened Concrete				psi (MPa)	2,730 (18.8)			
Tensile Strength ⁵	7 day	D638	psi (MPa)	6,780 (46.7)				
Tensile Elongation ⁵			%	1.0				
Heat Deflection Temperature			D648	°F (°C)	148 (64)			
Water Absorption	14 day	D570	%	0.02				
Linear Coefficient of Shrinkage	----	D2566	%	0.0003				

1. Product testing results based on representative lot(s). Average results will vary according to the tolerances of the given property.
2. Full cure time is listed below to obtain the given properties for each product characteristic.
3. Results may vary due to environmental factors such as temperature, moisture and type of substrate.
4. Gel time may be lower than the minimum required for ASTM C881.
5. Optional testing for ASTM C881 Grade 3.

CURE SCHEDULE

Base Material Temperature °F (°C)	Working Time min	Full Cure Time hr
43 (6)	45	144
50 (10)	35	72
75 (24)	16	7
90 (32)	12	4
110 (43)	3	2

1. Working and full cure times are approximate, may be linearly interpolated between listed temperatures.
2. Application Temperature: Substrate and ambient air temperature should be between 38-110°F (3-43°C) during application.
3. When the ambient or substrate material temperature falls below 70°F (21°C), ensure to condition the cartridge to 70-80°F (21- 27°C) prior to use.

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