FORSPEC PROTECTIVE COATINGS

CRACK PRO 1200PS.



Technical Data Sheet | **High-Strength Medium-Modulus Structural Epoxy Injection Adhesive** | **Issue date: 25 August 2026**

Description

CRACK PRO 1200PS is a high-strength, medium-modulus two-component epoxy adhesive engineered for structural crack repair by pressure injection and gravity feed, and for bonding freshly mixed concrete to hardened concrete. It seals and structurally reconnects cracks from 3 mm to 8 mm in width, fills voids in concrete and masonry, and cures to a thin impermeable layer that resists moisture ingress and a wide range of chemicals, making it suitable for industrial service environments.

The fast-cure formulation compresses programme: the repair is tack-free within 12–20 minutes at 24°C and can be ground smooth one hour after application. Combined with dry bagged aggregate it produces a high-quality spall repair mortar that is ready for grinding and return to traffic in under an hour. Beyond crack injection it serves as an anchoring adhesive, as the binder for epoxy mortar, and as the binder for high friction surface treatments on concrete and asphalt. Supplied in 600 mL dual cartridges.

Advantages

- High strength with medium modulus — robust structural bonding that retains a degree of flexibility.
- Fast curing — tack-free in 12–20 minutes and grindable one hour after application at 24°C.
- Forms a thin, impermeable barrier after curing, protecting the repair against moisture ingress.
- Excellent adhesion to concrete, masonry, asphalt and a wide range of substrates.
- Chemical resistant — suitable for industrial service environments.
- Temperature resistant across a wide service range.
- Durable under sustained heavy mechanical stress.
- With kiln-dried aggregate, produces a spall repair mortar open to traffic in under an hour.
- Simple 1:1 dual-cartridge application with a static mixing nozzle.

Uses

- Structural crack repair by pressure injection and gravity feed, 3 mm to 8 mm crack width.
- Port injection repair of vertical cracks within the FORSPEC epoxy injection procedure.
- Bonding freshly mixed concrete to hardened concrete.
- Void and cavity filling in concrete, masonry and other substrates.
- Binder for epoxy mortar and spall repair with kiln-dried aggregate.
- Anchoring adhesive for bolts and dowels.
- Binder for high friction surface treatments on concrete and asphalt.

Compliance Status

No accredited certificate is currently held on file for CRACK PRO 1200PS. All performance values are published as typical R&D characteristic values against their stated test method.

Potable water contact: the source data sheet claimed compliance with AS/NZS 4020 and suitability for contact with drinking water. No AS/NZS 4020 certificate is held on file. That claim is withheld from publication. Use in contact with potable water requires written confirmation from an authorised FORSPEC representative — refer to the Change Register.

STANDARD / TEST	STATUS	REFERENCE
ASTM D638-14 — tensile properties	Manufacturer data	Forspec R&D *
ASTM D695-15 — compressive properties	Manufacturer data	Forspec R&D *

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Compliance Status (continued)

STANDARD / TEST	STATUS	REFERENCE
ASTM D790-17 — flexural properties	Manufacturer data	Forspec R&D *
AS/NZS 4020 — potable water contact	No certificate held — claim withheld	To be commissioned
VOC certification	Not currently held	Certificate to be commissioned

Technical Data

Certified values are stated against their governing report. All other values are typical R&D characteristic values and are asterisked.

PROPERTY	VALUE	BASIS
Product type	Two-component structural epoxy injection adhesive	—
Mixing ratio	1:1, Part A to Part B †	—
Colour	Clear to light amber	—
Packaging	600 mL dual cartridge	—
Viscosity	2,210 cps at 25°C	*
Tensile strength	29.03 MPa	ASTM D638-14 *
Compressive strength	55.22 MPa	ASTM D695-15 *
Flexural strength	35.38 MPa	ASTM D790-17 *
Shrinkage on cure	0.2%	*
Heat deflection temperature	49°C	*
Gel time (60 g mass)	25–30 minutes	*
Tack-free time (at 23°C)	3–5 hours ‡	*
Tack-free time — thin gravity-feed repair (at 24°C)	12–20 minutes ‡	*
Full cure (at 24°C)	3 hours	*
Crack width range	3–8 mm	—
Minimum adhesive depth — gravity feed	12 mm	—
Application temperature	+5°C to +35°C	—
Service temperature after curing	−7°C to +50°C	—
Shelf life	24 months, unopened, stored at 5–35°C	—

† The spall patch procedure in the source data sheet specified a 2:1 mix ratio while the properties table specified 1:1. The product ratio of 1:1 is published; the spall patch ratio requires confirmation. ‡ The source recorded both a 3–5 hour tack-free time and a 12–20 minute tack-free time for gravity-feed repairs. Both are published with their governing condition pending confirmation. Refer to the Change Register for both items.

* Typical R&D characteristic values, not for engineering design without written FORSPEC confirmation.

Coverage and Yield

Demand is a direct function of the crack cross-section. Volume required = cross-sectional area (mm^2) × length (m) ÷ 1000 mL per litre. A minimum adhesive depth of 12 mm applies to gravity-feed repairs.

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Coverage and Yield (continued)

CRACK SIZE (WIDTH × DEPTH)	DEMAND PER LINEAR METRE	APPROX. METRES PER 600 ML CARTRIDGE
3 × 12 mm	36 mL *	16.7 m *
4 × 12 mm	48 mL *	12.5 m *
5 × 12 mm	60 mL *	10.0 m *
6 × 15 mm	90 mL *	6.7 m *
8 × 15 mm	120 mL *	5.0 m *
Spall mortar with aggregate	4–5 parts aggregate by volume to 1 part mixed epoxy *	Maximum 70 mm mortar thickness per layer

Allow for nozzle purge, static mixer waste, top-off and adhesive loss into the crack body. * Typical R&D characteristic values, not for engineering design without written FORSPEC confirmation.

Limitations

- Not for use in contact with potable water — the AS/NZS 4020 claim is withheld pending certification.
- Not a waterproofing membrane.
- Not for cracks narrower than 3 mm — specify CRACKLOCK E400L for 0.05–3 mm.
- Not for cracks wider than 8 mm — specify PROBOND 1100 for 3–20 mm.
- Not for application to damp, wet or frosted substrates — the substrate and the environment must be completely dry.
- Not for new concrete less than 28 days old.
- Do not apply below 5°C or above 35°C substrate and ambient temperature. Below 21°C, condition the product to 21–24°C before use.
- Do not dilute, extend, re-temper or add solvent under any circumstances.
- Extremely cold product will thicken and will not flow correctly; excessively warm conditions accelerate the reaction and shorten working time.
- Do not leave a partially used cartridge with a loaded static mixer — the material will harden in the nozzle.
- Spall mortar thickness must not exceed 70 mm per layer.

Surface Preparation

- New concrete must be a minimum of 28 days old before repair.
- Regardless of age, concrete surfaces must be clean, sound, completely dry and profiled or textured — moisture in the substrate will prevent bond development.
- Remove all dirt, dust, laitance, curing compounds, oils, grease, wax, surface sealers, coatings and any other bond-inhibiting contaminant by mechanical means, then vacuum thoroughly.
- Establish a roughened profile by rough-grinding, scarifying, bush hammering or equivalent mechanical preparation — a roughened profile is critical to adhesion.
- Mechanically roughen smooth surfaces with a wire brush or abrasive paper before application.
- Where the product is used as a bonding adhesive between two surfaces, confirm both surfaces are sound and free of dust, dirt, grease, wax, oil and all other contaminants.
- Confirm the substrate is dry and that no moisture is present in the crack or void before application.

Cartridge Set-Up

- Keep the cartridge upright throughout preparation to prevent material leakage.
- Shake the cartridge for one minute, then stand it upright for a further minute to allow entrained bubbles to rise.
- Remove the plastic cap and plug by unscrewing both components.
- Insert the cartridge into the FORSPEC Heavy Duty Dual Cartridge Gun, seating it securely.
- Dispense material into a disposable container until both resin and hardener flow evenly and the mixed colour is uniform — do not begin work on an unverified flow.
- Attach the flow control port and static mixing nozzle firmly, then dispense slowly through the nozzle.

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Cartridge Set-Up (continued)

- Aim to consume an entire cartridge without interruption to maintain consistent flow. Remove the mixing nozzle after use and store the cartridge correctly.

Gravity Feed Crack Repair — Horizontal Applications

- Confirm the substrate and the environment are completely dry before beginning.
- Clean the crack with a wire brush and remove all debris.
- For horizontal slabs, inject CRACK PRO 1200PS directly into the crack by placing the nozzle tip over the crack.
- Allow the adhesive to penetrate, and top off as required until the crack holds a full section.
- For wider cracks, insert backer rod or sand to control adhesive loss into the crack body.
- Maintain a minimum adhesive depth of 12 mm.
- Keep the adhesive flowing through the nozzle to prevent hardening in the static mixer.
- Remove excess material shortly after application, before it becomes tack-free.

Port Injection Repair — Vertical Applications

- Inspect the crack and mark any locations where the crack is discontinuous.
- Lay plastic sheeting to protect the floor, then clean the crack and its surroundings thoroughly with a wire brush.
- Port placement — continuous cracks: space ports at approximately 450 mm centres, starting from the bottom of the crack.
- Port placement — discontinuous cracks: position a port immediately above every point of discontinuity, with additional ports where there are multiple discontinuities.
- Port installation: remove the port cap and set it aside, coat the entire flat edge of the port with PROBOND 1100 epoxy paste, confirm the port hole is not obstructed, and press the port firmly over the marked crack location.
- Crack coverage: apply PROBOND 1100 epoxy paste over the entire crack, feathering it approximately 50 mm or more on both sides, and surround each port until the port base is no longer visible.
- Allow the capping paste to cure before injection begins.
- Injection: load the gun with CRACK PRO 1200PS fitted with a static mixer, insert the mixer into the bottom port until it clicks, and dispense until resin emerges from the port directly above.
- Remove the gun, cap the port, and repeat working upwards port by port.
- Repeat the full procedure at any additional corner repairs.
- Clean-up: once the materials have fully cured, remove the ports from the wall mechanically and grind the capping paste flush.

Spall Patch Application

- Cut around the spall into sound concrete with a grinder or circular saw using a diamond or concrete abrasive blade — never feather the edge.
- Clear all loose concrete from within the spall and complete surface preparation.
- Estimate the required product quantity, mix Part A and Part B thoroughly, then add 4–5 parts by volume of kiln-dried sand or aggregate.
- Pour and trowel until smooth and level, to a maximum mortar thickness of 70 mm per layer.
- Allow to cure before grinding, coating or returning to traffic.

Drying, Curing and Testing Times

All times below are stated at 25°C and 50% RH except where a source reference condition is noted. Cure accelerates in warm conditions and extends markedly below 21°C.

STAGE (AT 25°C, 50% RH)	TIME
Gel time (60 g mass)	25–30 minutes *
Tack-free — thin gravity-feed repair	12–20 minutes at 24°C ‡
Tack-free — full section	3–5 hours at 23°C ‡

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Drying, Curing and Testing Times (continued)

STAGE (AT 25°C, 50% RH)	TIME
Excess material removal	Shortly after application, before tack-free *
Grinding smooth	1 hour after application *
Full cure	3 hours at 24°C †
Coating with paint or architectural coatings	After full cure
Return to full traffic	After full cure

† Stated at the source reference condition and to be restated at 25°C and 50% RH. ‡ Two tack-free values were recorded in the source data against different conditions; both are published pending confirmation. Refer to the Change Register. * Typical R&D characteristic values, not for engineering design without written FORSPEC confirmation.

Clean Up

Clean tools and equipment promptly with FORSPEC EPOXY CLEANER while the material remains uncured, where both component Safety Data Sheets permit the solvent in question. Never allow the epoxy to cure on tools, nozzles or equipment — cured material can only be removed by mechanical means. Do not flush epoxy into drains or sewers.

Container and Waste Disposal

Combine and allow residues to fully cure and harden before disposal, then dispose in accordance with State and local requirements. Route unused, uncured components to an authorised waste collection point per Section 13 of the Safety Data Sheet of each component. Spent cartridges and static mixers are disposed of as cured epoxy waste. Do not reuse contaminated packaging and do not discharge uncured product to drains, soil or waterways.

Quality Records

Record the batch numbers of every cartridge used, substrate preparation method and profile achieved, crack locations, widths and lengths, port spacing and locations for injection repairs, adhesive depth achieved, ambient and substrate temperature at application, product conditioning where the temperature was below 21°C, cure periods before grinding, coating or traffic, and final inspection results, as part of the project quality assurance records.

Storage

Store in original, unopened packaging in a dry place between 5°C and 35°C, protected from direct sunlight, frost and moisture. Shelf life: 24 months from the date of manufacture when stored as specified.

Safety Precautions and First Aid

Refer to the current Safety Data Sheets before use — both Part A and Part B are separately classified. Uncured epoxy resins cause serious eye damage and skin irritation, and hardener components may cause skin sensitisation and respiratory sensitisation in susceptible persons. Wear impermeable nitrile gloves, eye and face protection and long-sleeved protective clothing, and use respiratory protection where ventilation is inadequate or where the SDS and workplace risk assessment require it. Ensure good airflow in enclosed and confined areas. Avoid all skin contact with uncured material. The reaction is exothermic — never leave a full mixed kit standing confined in the mixing container. Do not eat, drink or smoke when handling; wash hands before breaks and after work; contaminated work clothing must not leave the workplace. The Chemwatch SDS numbers for this product are to be confirmed — refer to the Change Register.

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Safety Precautions and First Aid (continued)

First aid — Eyes: hold eyelids apart and flush continuously with running water for at least 15 minutes and transport to hospital or a doctor without delay. Skin: remove contaminated clothing and footwear and wash the affected area thoroughly with soap and water; seek medical advice if irritation, rash or sensitisation occurs. Inhaled: remove to fresh air and keep comfortable for breathing; seek medical attention if respiratory symptoms occur. Swallowed: do NOT induce vomiting; rinse mouth and seek immediate medical attention. POISONS INFORMATION CENTRE: 13 11 26 (Australia-wide, 24 hours). In an emergency, dial 000. KEEP OUT OF REACH OF CHILDREN. Read the Safety Data Sheet (SDS) before use — available at www.forspec.com.au.

Warranty

Standard Product and Performance Warranty: Forspec Protective Coatings Pty Ltd as Trustee for Forspec Protective Coatings (ABN 11 204 033 631) warrants that CRACK PRO 1200PS will be free from manufacturing defects and will not fail under normal usage for a period of ten (10) years from the date of purchase, when installed and used strictly in accordance with this Technical Data Sheet and Forspec's written instructions. This warranty covers the supply of the product only; it does not cover installation, application or workmanship. Remedies are limited, at Forspec's discretion, to replacement of the defective product (or defective portion) or a refund of the purchase price. The full terms, conditions and exclusions are set out in the Forspec Standard Product and Performance Warranty, available at www.forspec.com.au — key conditions include application by a suitably qualified and, where required by law, licensed applicator; use within shelf life; and installation as part of a Forspec approved system without non-approved third-party products.

Project and system warranties: extended project-specific warranties are available at the request of the applicator and must be applied for using the Forspec Warranty Request Form prior to commencement of works. Issue is subject to Forspec approval and is conditional on the use of the complete specified FORSPEC system, application in strict accordance with the current TDS by suitably qualified applicators, and completion of the project quality records described above. The warranty period and terms are as stated in the issued warranty certificate.

Claims: notify Forspec in writing within thirty (30) days of discovery of the alleged defect and within the warranty period, by post to 22/872 Canterbury Road, Roselands NSW 2196 or by email to info@forspec.com.au, including proof of purchase, installation details (date, location, installer), a description of the defect with supporting evidence, and your contact details. Forspec may inspect the site, perform testing and collect samples before determining a claim.

Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

Data Sheet Currency

This Technical Data Sheet (TDS) and the corresponding Safety Data Sheet (SDS) are subject to revision as necessary to ensure compliance with relevant Australian Standards and to incorporate technological advancement. Read the most current versions before use, as application and performance data may be updated. For the latest technical information, contact Forspec Protective Coatings on (02) 8021 3517 or info@forspec.com.au. The information provided is representative and does not serve as a comprehensive specification. For specific projects, consult directly with Forspec Protective Coatings for tailored specifications. This data sheet was issued on 25/08/2026 and is valid for three years from the date of issue unless superseded by a later revision — always confirm the current version at www.forspec.com.au before use.

CONDITIONS OF USE, PRODUCT DISCLAIMER, AND STATEMENT OF RESPONSIBILITY

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Data Sheet Currency (continued)

1. Accuracy of information. The information in this document is provided in good faith by Forspec Protective Coatings Pty Ltd as Trustee for Forspec Protective Coatings (ABN 11 204 033 631) ('Forspec Protective Coatings') and is, to the best of its knowledge, true and accurate at the date of issue. Forspec Protective Coatings reserves the right to amend this document without notice as part of its continuous product development.

2. Suitability and user responsibility. Substrates, site conditions, workmanship and conditions of use are beyond Forspec Protective Coatings' control. No representation or warranty is made as to the suitability of the product for any particular application. The user must determine the suitability of the product for the intended use by their own assessment and, where appropriate, testing prior to application.

3. Currency of document. It is the responsibility of the customer and the applicator to confirm that this document and the corresponding Safety Data Sheet are the current versions, available at www.forspec.com.au. This document supersedes all previous versions.

4. Compliant use and application. The product must be used strictly in accordance with this document, the relevant Australian Standards, the National Construction Code and all applicable laws and regulations, and must be applied by suitably qualified personnel.

5. Statutory guarantees. Nothing in this document excludes, restricts or modifies any consumer guarantee, right or remedy conferred by the Australian Consumer Law (Schedule 2 of the Competition and Consumer Act 2010 (Cth)) or any other statutory right that cannot lawfully be excluded.

6. Limitation of liability. To the fullest extent permitted by law: (a) all other warranties, conditions and representations, express or implied, are excluded; (b) the total liability of Forspec Protective Coatings for any claim arising out of or in connection with the supply or use of the product is limited, at its election, to the replacement of the product, the supply of an equivalent product, or the refund of the purchase price paid; and (c) Forspec Protective Coatings will not be liable for any indirect, special or consequential loss, including loss of profits, arising from the use of, or inability to use, the product.

7. Advice and recommendations. Any advice, recommendation, information or assistance provided by Forspec Protective Coatings, whether verbal or written, is given in good faith but without liability beyond that stated in clause 6.

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