

TECHNICAL DATA

KBOND POLY-EPOXY

APPLICATIONS

KBOND POLY EPOXY (Knife Grade) is a premium quality vinyl ester blend adhesive. It has been designed with the stone fabricator and installer in mind. Kbond POLY-EPOXY (Knife Grade) has been engineered to have the best possible ratio of working time to curing speed possible with increased bonding strength compared to standard polyester adhesives. Uses include bonding, laminating, installation of pieces, and repairs.

PROPERTIES

- 4 – 6 minutes of working time
- Tack-Free in 10-20 minutes
- Machinable in 20 - 30 minutes
- Clear Formulation with better UV Stability
- Gel won't sag on vertical surfaces

PROCESSING CONDITIONS

- Make sure stone surfaces are clean of any substance and dry.
- Measure out the appropriate amount of polyester resin, then measure out the appropriate amount of hardener.
- Next carefully mix the components together. Be careful to scrape the sides and bottom of mixing cup to ensure thorough mixing. Do not 'stir' product. This can trap air and cause bubbles.
- Over-working of product can cause the product to become thinner
- Do not use once gelling has begun.

PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves and safety glasses

For further information, please consult the Material Safety Data Sheet.

STANDARD PACKAGING

* All information is based on 100 grams (approximately 3.6 oz) of product being used at a room temperature and stone temperature of 77°F. Times may vary based on room temperature, stone temperature, amount of hardener used, or other environmental factors.

Properties of the Uncured Product*

Composition - Polyester Cream Hardener Mixed Product

Mix Ratio by Weight – 2 – 4% hardener to adhesive -

Physical Appearance - Thixotropic Gel Paste - Color - Neutral Translucent

Density lbs/gal 9.5 10.0 - Specific Gravity - 1.14 1.20 -

Polyester Resin BPO Hardening Paste

1 -1 Quart 1 - 1 oz Tube

1 -1 Gallon 1 – 4 oz Tube

1 -5 Gallon 5 – 4 oz Tubes

STORAGE

The shelf life of both parts is twelve (12) months in a dry place and in the original unopened containers at a room temperature of 59°-77°F/15°-25°C. Do not allow product to freeze.

Properties of the Cured Product

Test Method

Final Hardness ASTM D-2240 Shore D 86-88

Glass Transition - °F/°C 149/65

Tensile Strength ASTM D-638 psi 12,000 – 14,000

Compressive Yield Strength ASTM D-695 psi 20,000 – 22,000

Flexural Strength ASTM D-790 psi 12,000 – 14,000