



UNI EN ISO 9001:2015
Quality System Certified Company



TECHNICAL DATA SHEET PRODUCTS

EPOXY 50

EPOXY 400

**EPOXY ADHESIVE/GLUE
in cartridge**

COMPOSITION

PART **A**: Thixotropic epoxy resin (molecular weight <700) with mineral fillers and pigments

PART **B**: Mixture of cycloaliphatic amine, polyamide and tertiary thixotropic amine, catalyzing agents with fillers and pigments

USE

For fixing / gluing marble or/and natural stone to each other or to other materials (metals, cement, concrete, etc.)

COLOUR

Beige (other colours under request)

MIXING RATIO

Epoxy glues/adhesives require exact mixing ratio, in weight between component **A** (resin) and component **B** (catalyst). In this particular case the ratio is:

$$\text{PART A : PART B} = 100 : 100$$

(for example: 100 gr. of component A mixed with 100 gr. of component B)
the cartridges are prepared so this ratio is already set and automatic during the extrusion

MIXING

Predetermined and automatic mixing while ejecting from the cartridge

PACKAGING

EPOXY 50 sbs cartridge of 50 ml (25 ml. part A + 25 ml. part B) and static mixer
EPOXY 400 sbs cartridge of 400 ml (200 ml. part A + 200 ml. part B) and static mixer

SURFACE PREPARATION

Surface to be treated to be porous, clean, dry and free from dust, grease or any other extraneous substances.

APPLICATION

Directly by the static mixer or with putty knife

APPLICATION TEMPERATURE

Do not apply at temperature lower than +10°C / 50°F

Suggested application temperature between +10°C/50°F and 30°C/86°F

THICKNESS

The best adhesive characteristics are obtained with thicknesses of adhesive from 0.3 to 1.0 mm

CONSUMPTION

250 to 700 g/m²

POLYMERISATION & HARDENING TIME

The rate of reaction increases with the temperature, which never should be below +10°C / 50°F

Laboratory testing showed the POT LIFE to be 20-30 minutes,

and the HARDENING TIME to be 180 to 300 minutes in thin layer (according to environment conditions)

PROPERTIES

see page no. 2

IMPORTANT

Based on the data reported, workability time is considered to be 10 to 30 minutes.
Do not store at temperature lower than +10°C (50°F) or higher than +35°C (95°F).
Protect from frost the stored cans.

WARNING! The prolonged exposure to UV rays causes the alteration of the initial colour of the product. The product is suitable for gluing/bonding and not for visible grouting, especially outdoors

SHRINKAGE COEFFICIENT

= 0,3%

NOTE

Epoxy adhesives have excellent adhesion characteristics even on surfaces that are lightly damp. The low shrinking rate (0,1 to 0,5%) creates very little tension both during and after the hardening process, enabling great stability of the adhesion and the materials. Once cured, the adhesive are absolutely resistant to freezing and water and are therefore recommended for outdoor application; however, prolonged exposure to direct sunlight can cause resin to yellow. Thanks to the very high adhesive flexibility, it is possible to affix a variety of material as concrete, steel, wood, many plastics, natural and artificial stone in any combination even in alternating rows.

PROPERTIES

DESCRIPTION	VALUE	UNIT	METHOD
MIXING TIME	instantaneous mixing during extrusion	-	
USING TIME / POT LIFE AT 20°C (68°F)	25 -30	minutes	-
GEL TIME AT 20°C (68°F)	250 -300	minutes	-
SHRINKAGE % (VOLUME/VOLUME)	≤0.3	%	-
TENSILE STRENGTH	55 - 60	Mpa	DIN 53455
TRACTION ELASTIC MODULUS	35 - 36	Mpa	DIN 53457
TRACTION ELONGATION	1.8 - 2.0	%	DIN 53455
BREAKING ELONGATION	2.2 - 2.4	%	DIN 53455
WATER ABSORPTION (TEST 60x10x4MM: AFTER 10 DAYS AT 20°C[68°F])	0.4 - 0.6	% (weight)	-
BENDING STRENGTH	95 -100	MPa	DIN 53452
UV RESISTANCE	yellowishing		

DISPENSERS

MD51 caulking gun for Epoxy 50 and 50 Mix



VBM200x caulking gun for EPOXY 400



LIMITATION OF LIABILITY The data provided derive from published information or from our own laboratory tests. The information provided here must be considered as a guideline and not as any form of performance guarantee. Liability for defective products, when verified, is limited to the refund of the purchase price since application of the product is beyond the control of the manufacturer or supplier.

A PRELIMINARY TEST IN A SMALL, HIDDEN, AREA IS RECOMMENDED BEFORE THE APPLICATION