



UNI EN ISO 9001:2008
Quality System Certified Company



TECHNICAL DATA SHEET PRODUCT

EPOXY 50 EXTRA EPOXY 400 EXTRA color

**THIXOTROPIC EPOXY ADHESIVE/GLUE
- DIFFERENT COLORS - in cartridge**

COMPOSITION

COMPONENT **A**: A/F bisphenol thixotropic epoxy resin with mineral fillers and pigments
COMPONENT **B**: (catalyst) Mix of catalysis agents containing adducts of cycloaliphatic amines, polyamides, tertiary amines, thixotropic, with mineral filler and pigments

USE

Permanent gluing/assembly of **natural stone, marble, granite, steel, wood, glass**, etc. between them or/and with other supports .

COLOUR

Different colours on demand

MIXING RATIO

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

COMPONENT **A** : COMPONENT **B** = **100 : 100**

(For example: 1 kg of component A mixed together with 1 kg of component B)

The cartridges are prepared so this ratio is already set and automatic.

MIXING

Resin and catalyst are automatically dosed and mixed inside the special mixer during the extrusion from the cartridge

PACKAGING

EPOXY 50 EXTRA	cartridge 50 ml.	(25 ml. comp. A + 25 ml. comp. B)	with static mixer
EPOXY 400 EXTRA	cartridge 400 ml.	(200 ml. comp. A + 200 ml. comp. B)	with static mixer

SURFACE PREPARATION

The pieces/surfaces to be treated must be porous, dry and free of any alien substance.

APPLICATION

Direct with the special mixer or by knife/spatula . To avoid the plugging of the exit holes of the cartridges because of the hardening of the texture inside the mixer, after ending the application the mixer must be eliminated. This ensures that the remaining resin in the cartridge can be used.

Application temperature between +10°C (50°F) and + 30°C (86°F) suggested.

Do not apply at temperature lower than +10°C (50°F).

EXTRUSION

IMPORTANT! The first 20 to 30 mm. of product coming out from the static mixer could be not perfectly mixed in the right proportion of 100:100. So, in order to avoid any problem of hardening, eliminate these first millimetres. This also when it used again a not ended cartridge with a new static mixer.

THICKNESS

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

CONSUMPTION

250 to 700 g/m²

POLYMERIZATION

The polymerization speed increases with the high temperatures but slows down with the low temperatures . In no case should the temperature be lower than +10°C (50°F).



HARDENING at 25°C (77°F)

25-30 minutes in mass; 80-120 minutes when applied in a thin layer

WORKABILITY

Estimated time in which the product can be worked: 4-6 minutes

STORAGE

Do not store at temperature lower than +10°C (50°F) or higher than +35°C (95°F)
Protect from frost the stored cans.

SHRINKAGE

Shrinkage coefficient 0,3%

TECHNICAL DATA

PROPERTIES	value	meas. unit	test method
MIXING TIME	immediate during extrusion	-	-
USE TIME	4 to 6	minutes	-
SHRINKAGE (volume/volume)	≤ 0.3	%	-
TENSILE STRENGTH	55 - 60	Mpa	DIN 53455
TENSILE ELASTIC MODULUS	35 - 36	Mpa	DIN 53457
TENSILE ELONGATION	1.8 - 2.0	%	DIN 53455
BREAKING ELONGATION	2.2 - 2.4	%	DIN 53455
WATER ABSORPTION test on samples 60x10x4mm. after 10 days at +20°C (68°F)	0.4 - 0.6	% (weight)	-
FLEXURAL STRENGTH	95 - 100	Mpa	DIN 53452
UV RESISTANCE	can turn yellow		

REMARKS

Epoxy adhesives adhere well, even on slightly damp surfaces. The low shrinking ratio (0.1-0.5%) creates only limited stress both during and after hardening, thus achieving greater stability between the glue and the material. Once cured, the resistance of these adhesives to freezing and water make them ideal for outdoor applications. Nevertheless, extensive exposure to direct sunlight can yellow the resin. Thanks to the great flexibility of this adhesive, different materials such as concrete, steel, wood, many plastics, natural and artificial stone can be glued together, even in alternating layers.

LIMITED LIABILITY

The information supplied has been taken from the bibliography and from our laboratory experience and is to be understood as general indication and not as formal guarantee. In particular, the liability for defective products, when ascertained, is limited to the product purchase price. The manufacturer cannot be held responsible for any implicit or explicit damages due to use of the product which remains beyond our direct control.

A PRELIMINARY TEST IS ALWAYS RECOMMENDED BEFORE THE APPLICATION