UNI EN ISO 9001:2015
Quality System Certified Company

TECHNICAL DATA SHEET
PRODUCT

EPOXY T.S.E.

TRANSPARENT SOLID
EPOXY ADHESIVE/GLUE

COMPOSITION
PART **A**: Tixotropized pure epoxy resin with pyrogenic silica
PART **B**: Tixotropized mix of catalysis agents containing adducts of amines, tertiary amines

USE
Permanent gluing of marbles, granites and natural stones between them or with other supports (metals, concrete, terracotta, wood, etc…)

MIXING RATIO
The epoxy adhesives/glues need exact mixing ratio in weight between the part A (resin) and part (catalyst). In this case:

PART **A** : PART **B** = **100 : 50**

(i.e. 100 gr. of part A mixed with 50 gr. of part B)

COLOUR
TRANSPARENT opaque

PACKAGING

EPOXY T.S.E.	part A	metal tin of 1.o kg.
EPOXY T.S.E.	part B	metal tin of 0,5 kg.

SURFACE PREPARATION
The pieces/surfaces to be treated/glued must be porous, dry and clean, free from dust and alien substances

MIXING
Dose and mix in the best careful way. Take from the can the needed quantity of the two components (keep the ratio 2A:1B in weight) and mix carefully some minutes.

APPLICATION
By putty knife or spreading. Do not apply at temperature lower than +10°C(50°F)
Suggested temperature of application 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 - 700 g/sq.meter

POLYMERIZATION
The hardening is a progressive reaction in the time of bond development and strengthening; cold and heat dispersions slow down (some times, very much) this reaction.
Do not apply at temperatures lower than +10°C (50°F); below this temperature the hardening of small quantities or thin layers can highly slow down and becomes difficult.
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HARDENING at 25°C (77°F)
80 - 100 minutes in mass; 200 - 300 minutes in thin layer (applied). Work time is considered to be 30 to 50 minutes

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SHRINKAGE

≤ 0.3% (in volume)

IMPORTANT

The operations of grinding, honing, polishing, piercing, sand-papering need a complete and total curing and are to be effected at least 24 - 36 hours after the application.

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

NOTE

Do not store at temperature lower than 8°C (46.4°F) and higher than 35°C(95°F).
Protect from frost the stored tins/cans

PROPERTIES

description	value	unit	method
MIXING TIME	2 - 3	minutes	-
WORKABLE TIME AT 20°C (68°F)	30 - 50	minutes	-
GEL TIME AT 20°C (68°F)	80 - 300	minutes	-
SHRINKAGE (VOLUME/VOLUME)	±0.3	%	-
TENSILE STRENGTH	50 - 60	Mpa	DIN 53455
TENSILE MODULUS OF ELASTICITY	3200-3400	Mpa	DIN 53457
TENSILE ELONGATION	2.0 - 2.2	%	DIN 53455
BREAKAGE ELONGATION	2.3 - 2.5	%	DIN 53455
WATER ABSORPTION (PIECE 60x10x4MM. AFTER 20 DAYS AT 20°C[68°F])	0.4 - 0.6	% (weight)	-
BENDING STRENGTH	95 – 100	Mpa	DIN 53452
UV RESISTANCE	yellowing	-	-
CONTINUOUS USE MAX. TEMPERATURE	50-55 (122-131)	°C (°F)	-

REMARKS

Epoxy adhesive compounds have excellent setting characteristics even on slightly damp surfaces. The low shrinkage (0.1 - 0.5%) causes only limited stress both during and after hardening, thereby favouring greater gluing and material stability. Once cured they are totally resistant to frost and water so they are also ideal for exterior use. The prolonged direct sunlight action can however causes the resin to turn yellow. Thanks to the great adhesive flexibility, heterogeneous materials such as concrete, steel, wood, many plastic materials, natural and artificial stones can be glued together, including in alternate layers.

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. Since the application of product is beyond the control of the manufacturer or supplier, our liability for defective products, when verified, is limited to refund of the purchase price.

A PRELIMINARY TEST IS ALWAYS RECOMMENDED BEFORE THE APPLICATION

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