



DATA SHEET

NAUTIPOXY™ NP Clear Gel Epoxy

MANUFACTURER

Bonstone Materials Corporation

PRODUCT DESCRIPTION

A two-component, non-sag, exterior grade, clear, gel epoxy.

Basic Uses:

- Adhesive/sealer/strengthener/waterproofer for boat construction.
- Fairing/filleting compound for boat construction
- Wood restoration
- General purpose structural marine adhesive

Limitations:

Use on dry substrates. Use on oil, grease, and coating free substrates.

TECHNICAL DATA

(see next page)

INSTALLATION

General Instructions : (If using cartridges, additional usage directions are available. See our information sheet labeled " Cartridge use directions".)

Surface Preparation & Use: Use gloves, wear eye protection, and avoid skin contact. When grinding cured mask. Substrate to be bonded must be completely dry and dust-free. Mix only the amount of epoxy which can be used in 10 minutes. Mask areas which must be kept free of epoxy. Clean uncured epoxy from tools with toluene or xylene. Remove cured epoxy mechanically.

Mixing instructions: All materials should be at or above 55°F. Combine the two ingredients at the following volume ratio: two parts A to one part B. Mix thoroughly--- ingredients must be blended homogeneously for proper cure.

Temperature dependency: Temperature will affect the working properties of the material. Approximately every 15°F results in doubling the speed of cure. Therefore, at 90°F set time is cut in half, at 60°F the set time is doubled. Do not use on a substrate at a temperature below 55°F.

Coverage: Approximately 30 square feet per gallon when applied at 50 mils (1/16th of an inch). 231 cubic inches per gallon.

AVAILABILITY

Packaging and storage: NP Clear Gel Epoxy is available in quarts, gallons, and 5 gallon pails, and cartridges. Shelf life is approximately one year if kept in unopened cans in a dry area at 75°F.

WARRANTY

This warranty is limited to replacement of defective material and freight charges to destination only. Bonstone Materials Corp. is not responsible for consequential damages.

TECHNICAL DATA ***NAUTIPOXY™ NP Clear Gel Epoxy**

<u>Typical Mixed Properties:</u>	<u>Values</u>	<u>Test Methods</u>
Mix Ratio:	Two parts A to one part B, by volume	
Pot Life at 75°F:	15 minutes	
<u>Typical Cured Properties:</u>		
(Cured seven days at 75°F)		
Initial set time at 75°F:	2 hours	
Full cure time at 75°F:	within 24 hours	
Tensile Strength:	2,044 psi	ASTM D-638
Tensile Modulus:	458,763 psi	ASTM D-638
Tensile Elongation at break:	1.2 %	ASTM D-638
Compressive Strength:	8,182 psi	ASTM D-695
Compressive Modulus:	106,191 psi	ASTM D-695
Ultimate Tg by DSC (°F)	155°F	