

TECHNICAL DATA SHEET

FILE UNDER DIVISION 4

1. PRODUCT NAME

TOUCHSTONE™
WaterJet Epoxy

2. MANUFACTURER

Bonstone Materials Corporation

3. PRODUCT DESCRIPTION

A two-component, low viscosity, exterior grade, clear epoxy adhesive.

Basic Uses:

- Bonding adhesive for stone inlays in waterjet cutting applications
- Stone patching, mending and bonding
- Anchor bolt adhesive
- Bonding stone to other construction materials
- Laminating; bullnoses & aprons

Limitations:

Use on dry stone. Use on oil, grease, and coating free stone. Some yellowing and chalking may occur when exposed to ultra-violet light.

Color:

Clear product- use Touchstone tints for tinting

4. TECHNICAL DATA:

(see next page)

5. INSTALLATION

General Instructions

If using cartridges, additional usage directions are available. See our information sheet

labeled "Cartridge use directions". See separate doweling, - laminating, and patching instructions for more specific instructions. CSI format specifications are available.

Surface Preparation & Use:

Use gloves, wear eye protection, and avoid skin contact. When grinding cured joints, wear a dust mask. Substrate to be bonded must be completely dry and dust free. Mix only the amount of epoxy which can be used in 30 minutes. Avoid stressing joint before complete cure of epoxy. Mask areas which must be kept free of epoxy. Clean tools of uncured epoxy using toluene or xylene. Use caution, these solvents are flammable, and ensure local ventilation. 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 of WaterJet **Part A** to one part WaterJet **Part B**.

Temperature dependency:

Temperature will affect the working properties of the material. Every 15°F results in approximately 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 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.

6. AVAILABILITY

Packaging and storage:

WaterJet is available in quarts, gallons, 5 gallon pails and cartridges. Thickening powders are available for increasing viscosity.

7. WARRANTY

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

8. MAINTENANCE

Designed for application in areas inaccessible to maintenance procedures

9. TECHNICAL SERVICE

Specification Service

- specs for various applications
- spec writing dept. for unique applications

4. **TECHNICAL DATA** TOUCHSTONE™ WaterJet Epoxy

Values

Test Methods

Typical Mixed Properties:

Mix Ratio: Two parts A to one part B, by volume

Viscosity, mixed, 68° F: 4920 centipoise
Cannon MV2000 rotational viscometer, spindle 5, 50 rpm

Gardner Color, Mixed: Gardner 3
ASTM D-1544

Pot Life at 68°F: 40 minutes

Typical Cured Properties:

(Cured seven days at 68°F)

Initial set time at 68°F: 6-8 hours
Full cure time at 68°F: within 24 hours

Shore D hardness: 86
ASTM D-2240

Tensile Strength: 6205 psi
ASTM D-638

Tensile Modulus: 554,629 psi
ASTM D-638

Tensile Elongation at break: 1.2 %
ASTM D-638

Compressive Strength: 11,268 psi
ASTM D-695

Compressive Modulus: 269,277 psi
ASTM D-695

Flexural Strength: 9610 psi
ASTM D-790

Flexural Modulus: 378,679 psi
ASTM D-790