

# TECHNICAL DATA SHEET

## FILE UNDER DIVISION 4

### 1. PRODUCT NAME

**TOUCHSTONE™  
INVISIBOND**

### 2. MANUFACTURER

Bonstone Materials Corporation

### 3. PRODUCT DESCRIPTION

A two-component, exterior grade, clear epoxy adhesive. Two hour set, flowing liquid.

#### Basic Uses:

- 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. Minimal yellowing and chalking will occur when exposed to ultra-violet light. **Color:**

Clear product - use Touchstone tint 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 10 minutes. Avoid stressing joint before complete cure of epoxy. Mask areas which must be kept free of epoxy. Clean tools with 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 **A** to one part **B**.

#### Temperature dependency:

Temperature will affect the working properties of the material. 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 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:

**Touchstone InvisiBond** is available in quarts, gallons, 5 gallon and cartridges. Thickening powders are available for increasing viscosity.

\*\* If **InvisiBond A & B** is exposed to below room temperature conditions for extended periods of time, it may crystallize, giving it a stiff, grainy consistency. The product must be reconstituted before use by heating it to 150°F degrees. Stir until it becomes a homogeneous liquid.

### 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 INVISIBOND**Mixed PropertiesValuesTest Methods

Mix Ratio: 2 parts A to 1 part B by volume

Pot Life at 75°F: 30 minutes

Cured Properties

Initial set time at 75°F: 2 hours

Full cure time at 75°F: within 24 hours

**STRENGTHS**

Tensile: 3058 psi ASTM D-638

Flexural: 8713 psi ASTM D-790

Shear -academy black granite  
(Shear by compressive loading) 4736 psi (stone failure) ASTM D-905-89

**MODULUS**

Tensile: 573,157 psi ASTM D-638

Flexural: psi 374,423 ASTM D-790

**ELONGATION**

Tensile: Elongation at break 0.63% ASTM D-638

Shore D Hardness: 80 ASTM D-1706

Heat Distortion Temperature: 135°F ASTM D-648