AKEPOX® 4005 Glass Fibre Adhesive

Technical Instruction Sheet

Properties:

AKEPOX® 4005 is a liquid two-component epoxy resin system with a modified amine hardener. It is used in combination with glass fibre mesh to strengthen the reverse side of natural stone. The product is characterized by the following properties:

- fast hardening
- excellent perfusion of the glass fibre fabric
- transparent
- solventless
- increases yield and productivity

Application area:

AKEPOX® 4005 Glass Fibre Adhesive is mostly used in the stone processing industry in combination with glass fibre mesh which is applied to the reverse side of fragile slabs of natural stone.

Instructions for use:

1. The surfaces which are to be treated must be clean and dry.
2. Two parts (by weight or volume) of component A are to be mixed with one part of component B until the mixture is free of streaks. It is recommendable to use the AKEPOX® dosing and mixing apparatus for larger amounts.
3. AKEPOX® colour pastes can be used to colour the adhesive (max. 5%).
4. The mixture remains workable for approx. 10 to 20 minutes (20° C) and is applied to the whole surface with a finely toothed spatula.
5. Then glass fibre mesh is applied. It must be completely perfused.
5. After approx. 4-6 hours at room temperature (20 °C) the surface is no longer sticky.
6. Tools can be cleaned using AKEMI® Universal Dilution.
7. Warmth accelerates, the cold slows down hardening.
8. Dispose of the container properly by emptying it completely first.

Special remarks:

- The optimum mechanical and chemical properties can only be attained if the mixing ratio is strictly adhered to. If you use too much of component A or component B it acts as a softening agent or can cause discoloration in the contact zone.
- When working with the adhesive you should use AKEMI® Liquid Glove to protect your hands.
- When taking out the required amounts of component A and B from their storage containers make sure you use separate vessels.
- Do not use resin which has begun to thicken or jellify.
- The product may not be used under a temperature of 15° C because it will not harden sufficiently.
- Resin which has already hardened can no longer be removed with solvents. This can only be achieved mechanically or at higher temperatures (> 200° C).
- If used in the correct manner the fully hardened adhesive presents no hazard to health.

Technical specifications:

Colour:	light transparent
Density component A:	1.12 g/cm³
component B:	0.97 g/cm³
Coverage:	approx. 100 to 200 g/m²

Working time at various temperatures and an amount of 150 g:

15 °C:	approx. 20-30 minutes
20 °C:	approx. 10-20 minutes
30 °C:	approx. 5-10 minutes

Storage: can be stored for approx. 1 year in the closed original container under cool conditions.

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Safety notices: Please refer to the EC safety data sheet

Notice: The above specifications were made on the basis of the present-day stage of technological development as well as the application research of our company. Because the ways and means of application are beyond our control, the manufacturer cannot be made liable for the contents of this specification sheet.

07/06