Technical Instruction Sheet

Characteristics:

AKEMI® Mixbond is a gel-like 2-component product based on unsaturated polyester resins dissolved in styrene. The product is distinguished by the following qualities:

- very good workability due to the gel-like consistency
- fast hardening (30-90 minutes)
- excellently polishable
- possibility of adjusting the color to match the complete spectrum of Engineered Stones
- improved protection against yellowing
- very good adhesion on natural and cast stone even at higher temperatures (60-70°C/140-158°F, for low loads also 100-110°C/212-230°F)
- resistant to water, petrol and mineral oils.

Field of Application:

AKEMI® Mixbond is mainly used to color-match the adhesive for bonding Engineered Stone such as e.g. CeasarStone®, Silestone®, Zodiaq®, Corian® and natural stone in the industry and handicraft.

Instructions for Use:

1. The surface to be treated must be clean, completely dry and roughened.
2. If necessary adjust the color, before adding the hardener.
3. Add 1 to 4 g hardener paste white (4 to 5 cm of paste pressed out of the screw tube correspond to 1 g) to 100 g Mixbond (1.5 cm of paste pressed out of the tube correspond to 1 g).
4. Mix both components thoroughly. The mixture can be worked for about 7 to 16 minutes (20°C/68°F).
5. After approx. 30 to 90 minutes (20° C/68°F) the treated parts can be futher processed (grinding, milling, drilling).
6. The hardening process is accelerated by heat and delayed by cold.
7. Tools can be cleaned with AKEMI® Nitro-Dilution.

Special Hints:

- Use AKEMI® Liquid Glove to protect your hands.
- Hardener portions higher than 4 % reduce adhesion and deteriorate surface drying.
- Hardener portions less than 1 % and low temperature (under 5°C/41°F) considerably delay hardening.
- The adhesive which is already thickened or just gelling should not be used anymore.
- The bonding layers should be as thin as possible (< 1 mm) due to shrinkage (approx. 5-8 %) caused by the high reactivity of the filler and development of heat during the hardening process.
- Limited durability of bondings which are frequently exposed to humidity and frost.
- Moderate adhesion on fresh, alkaline building materials (e.g. concrete, concrete bricks).
- The hardened Mixbond has a very slight tendency to yellowing.
- Once hardened, Mixbond can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).
- Being worked properly, the hardened Mixbond is generally recognised as not injurious to health.

Technical Information Sheet

Safety Measures: see EC Safety Data Sheet

Technical Data:

Color: different
Density: approx. 1.17 g/cm³

Working time / min.:

a) at 20°C / 68°F

1 % of hardener	14 - 16
2 % of hardener	10 - 12
3 % of hardener	8 - 9
4 % of hardener	7 - 8

b) with 2 % of hardener

at 10°C / 50°F	20 - 24
at 20°C / 68°F	10 - 12
at 30°C / 86°F	5 - 6

Mechanical Properties:

Tensile strength DIN 53455: 40 - 50 N/mm²
Bending strength DIN 53452:100 -110 N/mm²

Shelf life: 1 year approx. if stored in cool place free from frost in its tightly closed original container.

Notice: The above information is based on the latest stage of technical progress. t is to be considered as a non-binding hint and does not release the user from a performance test, since application, processing and environmental influences are beyond our realm of control.

AKEMI GmbH · Lechstraße 28 · D-90451 Nürnberg · Tel. +49(0)911/642960 · Fax +49(0)911/644456
www.akemi.com