

Technical Instruction Sheet

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Characteristics: AKEMI® Colour Bond 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 workable because of smooth, gel-like consistency
- fast hardening (30 – 60 minutes)
- excellently polishable
- easy dosing and mixing by using the cartridge system
- wide colour palette available for a seamless bonding of many Engineered Stone types
- improved protection against yellowing
- very good adhesion on Engineered Stone as well as on natural and artificial stones also at higher temperatures (60–70°C, in case of low exposure to strain: 100–110°)
- resistant to water, petrol and mineral oils

Field of Application: AKEMI® Colour Bond is mainly used for a colour adjusted bonding of Engineered Stone such as e.g. CeasarStone®, SileStone®, Zodiaq®, Corian® and natural stones in industry and handicraft.

Instructions for Use:

A. Product in cartridge system

- without mixing nozzle: dosing apparatus only
- with mixing nozzle: dosing and mixing apparatus at the same time

1. Thoroughly clean, dry and slightly roughen surfaces to be bonded.
2. Remove the clasp from the cartridge and put the cartridge in the gun; work the grip until material emerges from both openings; then eventually screw up the mixing nozzle. Do not use the first 10 cm pressed out of the mixing nozzle.
3. Both components must be thoroughly mixed when working without mixing nozzle.
4. The mixture remains workable for approx. 8-10 min (20°C/68°F).
5. After approx. 30-60 minutes (20°C/68°F) work can continue on the cured Colour Bond (grinding, milling, drilling).
6. The hardening process is accelerated by heat and delayed by cold.
7. Tools can be cleaned with AKEMI Nitro-Dilution.

B. Product in tins

1. The surface to be treated must be clean, completely dry and slightly roughened.
2. Add 1-4 g of white hardener paste to 100 g of Colour Bond (4 to 5 cm of paste pressed out of the screw tube correspond to 1 g).
3. Mix both components thoroughly. The mixture can be worked for about 7-16 minutes (20°C/68°F).
4. After approx. 30-90 minutes (20°C/68°F) work can continue on the cured Colour Bond (grinding, milling, drilling).
5. The hardening process is accelerated by heat and delayed by cold.
6. 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 temperatures (below 5°C/41°F) considerable delay hardening.
- An 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.

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- 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 Colour Bond has a very slight tendency to yellowing.
- Once hardened, Colour Bond can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C/392°F).
- When worked correctly, the hardened Colour Bond is not damaging to health.
- Cartridges: use AKEMI® original mixing nozzle only. It is recommended to Remove the mixing nozzle after use and close with the original clasp. Before you screw up a new mixing nozzle make sure that material emerges from both openings.

Safety Measures: see EC Safety Data Sheet

Technical Data: Colour: different
Density: approx. 1.17 g/cm³

Working Time / min.

a) at 20°C

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

b) with 2% of hardener		cartridge
at 10°C	20 – 24	16 – 20
at 20°C	10 – 12	8 – 10
at 30°C	5 - 6	4 - 5

3. Mechanical properties

Tensile strength DIN 53455:	40- 50 N/mm ²
Bending strength DIN 53452:	100-110 N/mm ²

4. 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. It 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.

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