

## Stone Setting Epoxy

- PRODUCT DESCRIPTION:** **Stone Setting Epoxy** is a 2-part, high strength adhesive. It is intended for bonding of tile and stone to vertical surfaces. It is non sag or flow in normal conditions. Common applications include fireplace surrounds, stairs, feature stone walls, rockeries and indoor garden displays
- RECOMMENDED USES:**
- Bonding of Masonry, precast concrete, stone panels marble, granite, slate, ceramic tiles on walls or overhead in interior or exterior applications
  - Feature walls
  - Fireplace surrounds
  - Facades
  - Outdoor entertaining areas
  - Fabrication of head stones and other decorative stone items
  - Statues and fountains
  - Pipe and crack repair
- FEATURES & BENEFITS:**
- Permanent bond 5 – 6 hours
  - Cure time 12 hrs at 25°C
  - Non staining on all stone types
  - Non sag up to 30 mm thick
  - Mix ratio 1:1
  - Solvent free
  - Permanent bond – no performance decrease over time
- ACCEPTABLE SUBSTRATES:**
- Concrete, precast concrete, bricks, masonry, metal. Ensure all oil, rust or other deleterious matter is removed prior to application, marble, granite and ceramic tiles.
  - Always contact the manufacturer if in any doubt re substrates to be bonded
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- LIMITATIONS:**
- All surfaces to be bonded must be sound, dry and free of any deleterious matter
  - Surfaces must be rigid
  - Not suitable for blueboard, cement sheeting or any other compressed material – may cause substrate to internally delaminate under stress
  - Not recommended for sandstone and other fissile stones – these stones can be porous or veneered which will cause the bond to fail by delamination of the stone surface
  - Must be applied between 10°C and 35°C.
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- APPLICATION:**
- Preparation:**
- Best mixing temperature for product is between 20°C and 25°C
  - All surfaces must be clean, dry and free from any mould release compounds, oil, wax or other deleterious matter
  - All bonding surfaces shall be to bare stone – any backing materials must be removed
  - Where necessary grind back of stone to provide a clean bonding surface – ensure all dust or residue is removed before application of Stone Setting Epoxy

**Mixing:**

- Combine equal parts Part A and Part B by volume (1:1 mix)
- Small quantities can be mixed with spatula or putty knife – larger quantities should be mixed with high power drill (low speed)

Mix until colour is uniform (light grey) – make sure sides and bottom of container are scraped to ensure complete mixing. Incomplete or poor mixing may result in uncured areas.

- PACKAGING:** 4 lt kit comprises: 1 x 2lt Part A (white) and 1 x 2 litre Part B (grey)  
20lt kit comprises: 1 x 10 litre Part A (White) and 1 x 10 litre Part B (grey)
- CLEAN UP:** Clean up should be done as soon as possible after mixing using warm water with soap or detergent
- COVERAGE RATE:** 20 litres covers 25m<sup>2</sup> ;  
1 litre covers 2.5m<sup>2</sup>
- SHELF LIFE:** Product will remain usable for a period of 2 years if stored between 5°C and 35°C
- POT LIFE:** This product will be unworkable after 1 hour once Part A & B have been mixed
- SAFETY DIRECTIONS:** Avoid contact with skin and eyes and avoid breathing the vapour or spray mist. Store under cover, out of direct sunlight and in a well ventilated area. Keep away from all sources of ignition – no smoking.
- FIRST AID:** If poisoning occurs contact a doctor or Poisons Information Centre. If swallowed, DO NOT induce vomiting. Give a glass of water. If in eyes, hold eyes open, flood with water for at least 15 minutes and see a doctor. Refer to Material Safety Data Sheet for further information.
- TECHNICAL DATA:**

TEST	METHOD	RESULT
Consistency	Rebound Ace test	No sag or slump up to 30 mm thickness 20°C
Pot Life at 20°C	Rebound Ace test	45 mins to 1 hr
Cure time at 20°C	Rebound Ace Test	12 hours

\*Working Time

MIXED PROPERTIES AT 20°C	
Consistency	No slag or slump up to 25mm thick
Pot Life	45 mins to 1 hour
Cure Time	12 hours
Full Cure	24 hours

Temperature	Pot Life	Set Time
5°C	1.5 hours	24 hours
20 °C	45 mins	12 hours
30 °C	20 mins	2 – 2.5 hours
*Guide Only		

- BONDING:** Apply mixed Stone Setting Epoxy in dabs at each corner and centre of panel (minimum) to be bonded – dabs must be equivalent to 10% coverage tile area

Minimum dab sizes per tile to achieve 10% coverage with 5 dabs		Minimum dab sizes per tile to achieve 10% coverage with 3 dabs	
Tile Size	Dab Diameter	Stack Stone Size	Dabs & Diameter
300 x 300mm	50mm	400 x 100mm	3 dabs min @ 100mm in size
600 x 600mm	100mm	400 x 125mm	3 dabs min @ 100mm in size
900 x 900mm	150mm		