



DATA SHEET

BONSTONE™ 404

MANUFACTURER

Bonstone Materials Corporation

PRODUCT DESCRIPTION

A two-component, exterior grade, clear, low viscosity epoxy.

Basic Uses:

- Stone or concrete crack injection, patching and mending
- Bonding stone or hardened concrete to hardened concrete
- Bonding new concrete to existing concrete
- Anchor bolt adhesive
- Bonding stone and concrete to other construction materials
- Bonding stone to stone
- General purpose adhesive for wood, concrete, metal

Limitations: Use on dry - oil, grease, and coating free - substrates.

Applicable Standards: Meets ASTM C-881, Types I and II; Class C, Grade 1

TECHNICAL DATA

(see next page)

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 uncured epoxy from tools with toluene or xylene. 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 404 Part A to one part 404 Part B. Mix thoroughly--- ingredients must be blended homogeneously for proper cure.

Temperature dependency: Temperature will affect the working properties of the material. Approximately 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 a 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.

AVAILABILITY

Packaging and storage: BONSTONE 404 is available in quarts, gallons, and 5 gallon pails, and 300ml & 150ml cartridges. Shelf life is approximately one year if kept in unopened cans in a dry area at 75°F.

WARRANTY

This warranty is limited to replacement of defective material and freight charges to destination only. Bonstone Materials Corp. is not responsible for consequential damages.

MAINTENANCE

Designed for application in areas inaccessible to maintenance procedures.

TECHNICAL SERVICE

Specification Service: Specifications for various applications and specification writing dept. for unique applications.

TECHNICAL DATA

Mixed Properties

Values

Test Methods

Mix Ratio: 2 parts 404 Part A, to 1 part 404 Part B by volume

Pot Life at 75°F: 25 minutes

Cured Properties:

Initial set time at 75°F: 3 hours

Full cure time at 75°F: within 24 hours

Tensile Strength: 7,457 psi ASTM D-638

Tensile Modulus: 414,614 psi ASTM D-638

Tensile Elongation at break 1.8% ASTM D-638

Compressive Strength: 12,212 psi ASTM D-695

Compressive Modulus: 278,638 psi ASTM D-695

Flexural Strength: 15,540 psi ASTM D-790

Flexural Modulus: 463,000 psi ASTM D-790

Shore D Hardness: 80 ASTM D-2240

Heat Distortion Temperature: 130° F ASTM D-648