



DATA SHEET

NAUTIPOXY™ Penetrating Epoxy Sealer

MANUFACTURER

Bonstone Materials Corporation

PRODUCT DESCRIPTION

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

Basic Uses:

- Wood penetrating/ sealing/strengthening/ waterproofing/ for boat construction.
- Penetration of deep thin cracks in wood
- Wood restoration

Limitations:

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

TECHNICAL DATA

(see next page)

INSTALLATION

Surface Preparation & Use: Use gloves, wear eye protection, and avoid skin contact. Substrates must be completely dry and dust-free. Mix only the amount of epoxy which can be used in 15 minutes. Mask areas which must be kept free of epoxy. Clean uncured epoxy from tools with toluene or xylene. (WARNING! These solvents are highly flammable!) Remove cured epoxy mechanically. When grinding cured material, wear a dust mask.

Mixing instructions: All materials should be at or above 55°F. Combine the two ingredients at the following volume ratio: two parts A to one part B. Mix thoroughly--- ingredients must be blended homogeneously for proper cure. For maximum penetration of wood, add Xylene to the mixed epoxy. Suggested ratio is 1 part xylene to 1 part mixed epoxy. Apply by brush or roller. Note: after curing, there may be a slight residue of amine exudation on the surface. This is normal, and can be easily removed by washing with warm water and/or soap solution. If topcoating with another product, such as NautiKing Nautithane, it is highly recommended to remove this exudation to ensure good intercoat adhesion.

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: Penetrating Epoxy Sealer is available in quarts, gallons, and 5 gallon pails, and 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.

TECHNICAL DATA * NAUTIPOXY™ Penetrating Epoxy Sealer

Typical Mixed Properties:**Values**

Mix Ratio:	Two parts A to one part B, by volume
Viscosity, mixed, 75°F:	260 centipoise
Pot Life at 75°F:	40 minutes
Initial set time at 75°F:	6-8 hours
Full cure time at 75°F:	within 24 hours

Typical Cured Properties*:**Values****Test Method**

(Cured seven days at 75°F)

Shore D hardness:	78	ASTM D-2240
Tensile Strength:	6,902 psi	ASTM D-638
Tensile Modulus:	315,225 psi	ASTM D-638
Tensile Elongation at break:	3.0%	ASTM D-638
Compressive Strength:	10,562 psi	ASTM D-695
Compressive Modulus:	141,090 psi	ASTM D-695

* These results are for the product as supplied. If xylene is added the properties will be affected.