



# TECHNICAL DATA SHEET

## FILE UNDER DIVISION 4

### 1. PRODUCT NAME

**BONSTONE™ ANCHOR**  
(hardener B-412X)

### 2. MANUFACTURER

Bonstone Materials Corporation

### 3. PRODUCT DESCRIPTION

A two-component exterior grade epoxy adhesive. Six hour initial cure. Flowing paste viscosity. ( Family includes **A-100, A-110, A-120, A-130, A-180, & A-190**)

#### Applications:

- Setting anchor bolts
- Laminating stone to other construction material
- Stone to stone bonding

#### Limitations:

Use on dry stone. Use on oil,-grease,- and coating-free stone. Some yellowing and chalking will occur when exposed to ultra-violet light.

#### Colors:

Four standard colors. Custom color matching available

#### Applicable Standards:

Indiana Limestone Institute specifications for units preassembled with thermosetting resin.

### 4. TECHNICAL DATA:

( On next page )

### 5. INSTALLATION

#### General Instructions

(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 toluol (toluene) or xylol (xylene). ( Use caution, these solvents are flammable. Ensure local ventilation.) Remove cured epoxy mechanically.

#### Mixing instructions:

All material should be at or above 60°F. Combine the two ingredients at the following weight ratio: One part of A to one part B-412X. Mix thoroughly--- ingredients must be blended homogeneously for proper cure. Best to mix using double mix method. See reverse side.

#### Temperature dependency:

The adhesive, substrate, and environment's temperature will affect the working properties of the material. Approximately every 15°F results in doubling the speed of cure. Therefore, at 95°F set time is cut in half, at 60°F the set time is doubled. Do not use on substrate at a temperature below 55°F.

### Coverage:

Approximately 30 square feet per gallon when applied at 50 mils (1/16th of an inch). One gallon equals 231 cubic inches.

### 6. AVAILABILITY

#### Packaging and storage:

Anchor is available in quarts, gallons, and 5 gallon pails. Shelf life is approximately one year if kept in unopened cans in a dry area at 75°F. \*\*If Bonstone Anchor part A is exposed to below room temperature conditions for extended periods of time, it may crystallize, giving it a stiff, grainy consistency. The product must be reconstituted before use by heating it to 150°F degrees. Stir until it becomes a homogeneous liquid.

### 7. WARRANTY

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

### 8. MAINTENANCE

Designed for application in areas inaccessible to maintenance procedures

### 9. TECHNICAL SERVICE

#### Lab Service

- Spectrophotometric color matching available
- Specification writing dept. for unique application

#### 4. **TECHNICAL DATA**

#### **BONSTONE™ ANCHOR with B-412X hardener**

<i>Mixed Properties</i>	<i>Values</i>	<i>Test Methods</i>
Mix Ratio:	1 part ANCHOR family to 1 part B-412X by weight	
Mixed viscosity at 75F	Creamy paste	
Pot Life at 75F:	35 minutes	
 <i>Cured Properties</i>		
Initial set time at 75F:	6 hours	
Full cure time at 75F:	within 24 hours	
<b>STRENGTHS</b>		
Tensile:	3,550 psi	ASTM D-638
Compressive:	9,210 psi	ASTM D-695
Flexural:	7,947 psi	ASTM D-790
<b>MODULUS</b>		
Tensile:	941,000 psi	ASTM D-638
Compressive:	126,604 psi	ASTM D-695
Flexural:	943,000 psi	ASTM D-790
<b>ELONGATION</b>		
Tensile: Elongation at break	0.4 %	ASTM D-638
 <b>Shore D Hardness:</b> 91 <b>ASTM D-1706</b>		
<b>Heat Distortion Temperature:</b> 120 F <b>ASTM D-648</b>		
<b>24 Hour Water Absorption:</b> 0.04% <b>ASTM D-570</b>		

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#### **DOUBLE MIX METHOD:**

The double mix method is used to completely and uniformly mix an epoxy product. The two components are mixed in one container, transferred to another, and remixed. This allows the contractor to scrape the final mixing container extremely clean without the possibility of using unmixed product.