

TECHNICAL DATA SHEET

FILE UNDER DIV. 4

1-800-425-2214

1. PRODUCT NAME

**BONSTONE™ FLOW
A-124/B-414X**

2. MANUFACTURER

Bonstone Materials Corporation
(address see bottom of page)

3. PRODUCT DESCRIPTION

A two-component exterior grade epoxy adhesive, pourable liquid. Two hour set.

Basic uses:

- Setting anchor bolts
- Laminating stone to other construction materials
- Bonding stone to stone
- General purpose concrete bonding

Limitations:

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

Color:

Concrete

4. TECHNICAL DATA:

(On reverse side)

5. INSTALLATION

General Instructions

(See separate Doweling, Laminating and Patching instructions for more specific instructions. CSI format specifications 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, as these solvents are flammable. Ensure local ventilation. Remove cured epoxy mechanically.

Mixing instructions:

All material should be at or above 45°F. Combine the two ingredients at the following weight ratio: One part of A-124 to one part of B-414X. Mix thoroughly--ingredients must be blended homogeneously for proper cure. Best to mix using double mix method. See reverse side.

Temperature dependency:

Temperature will affect the working properties of the material.

Every 10°F results in doubling the speed of cure. Therefore, at 85°F set time is cut in half, at 65°F the set time is doubled. Do not use on substrate at a temperature below 45°F.

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

6. AVAILABILITY

Packaging and storage:

BONSTONE™A-124 and B-414X are available in quarts, gallons, and 5 gallon pails. Shelf life is approximately one year if kept in a dry area at 75°F.

** If Bonstone A-124 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

Specification Service

- Specifications for various applications
- Specification writing dept. for unique applications

4. **TECHNICAL DATA**

BONSTONE™ FLOW A-124/B-414X

<i>Mixed Properties</i>	<i>Values</i>	<i>Test Methods</i>
Mix Ratio:	1 part A-124 to 1 part B-414X by weight	
Mixed viscosity at 75°F	Creamy paste	
Pot Life at 75°F:	10 minutes	
 <i>Cured Properties</i>		
Initial set time at 75°F:	2 hours	
Full cure time at 75°F:	within 24 hours	
STRENGTHS		
Tensile:	4,816 psi	ASTM D-638
Compressive:	29,000 psi	ASTM D-695
Flexural:	13,800 psi	ASTM D-790
MODULUS		
Tensile:	37,000 psi	ASTM D-638
Compressive:	154,000 psi	ASTM D-695
Flexural:	375,000 psi	ASTM D-790
ELONGATION		
Tensile: Elongation at break	10.5%	ASTM D-638
Shore D Hardness:	89	ASTM D-1706
Heat Distortion Temperature:	132°F	ASTM D-648

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 container extremely clean without the possibility of using unmixed product.