



TECHNICAL DATA SHEET FILE UNDER DIV. 4

1-800-425-2214

1. PRODUCT NAME

BONSTONE[®] 111 DUROPOXI F

2. MANUFACTURER

Bonstone Materials Corporation
(see address at top right of page)

3. PRODUCT DESCRIPTION

A two-component, 100% solids, chemical resistant, exterior grade epoxy adhesive. Non-sag gel epoxy. Flexible.

*See separate Data Sheet

Basic Uses:

- Bonding concrete, masonry, and stone
- Laminating stone to other construction materials
- Bonding stone to stone
- Structural patching concrete
- Setting stone pavers and tiles

Limitations:

Use on dry stone. Use on oil, grease, and coating free stone. This product will yellow on exterior exposure to sunlight.

4. TECHNICAL DATA:

(see reverse side)

5. INSTALLATION

General Instructions

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 15 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:

The unmixed epoxy components should be at or above 55°F. Combine the two ingredients at the following volume ratio: one part Duropoxi F A to one part Duropoxi F B. Mix thoroughly---ingredients must be blended homogeneously for proper cure. Best to mix using double mix method. See reverse side.

Temperature dependency:

Temperatures will affect the working properties of the material. Approximately every 15F results in doubling the speed of cure. Therefore, at 90F the set time is cut in half, and at 60F the set time is doubled. Do not use on a substrate at a temperature below 55F.

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 Duropoxi F 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.

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

TECHNICAL DATA**Bonstone DUROPOXI F**

Mixed Properties
Methods**Values****Test**

Mix Ratio:	1 part Duropoxi F Part A, to 1 part Duropoxi F Part B by volume	
Pot Life at 75°F:	15-30 minutes	

Cured Properties

Initial set time at 75°F:	2 hours	
Full cure time at 75°F:	within 24 hours	
Tensile Break Strength:	515 psi	ASTM D-638
Tensile Modulus:	7,012 psi	ASTM D-638
Tensile Elongation at break:	12.4 %	ASTM D-638
Compressive Yield Strength:	3,342 psi	ASTM D-695
Compressive Modulus:	12,723 psi	ASTM D-695

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.