

## Description

Flo-Gel 900 is a solvent free, two-part, epoxy-based adhesive designed for use with all types of stone, including marble, granite, or engineered stone. It has been specially formulated to have a short cure time and excellent structural strength. It also features an easy one to one mix ratio. Flo-Gel 900 is ideal for use on small jobs or in a production line where speed is needed most.

## Applications

Flo-Gel 900 is excellent for granite, marble, or engineered stone applications that include bonding stone to other stone or to materials such as concrete, glass, metal, and wood. They are also suitable for laminating slabs and mending broken or chipped stone.

Please Note: Epoxy products will have a slight tendency to yellow if exposed to UV rays or if exposed to direct sunlight, especially out of doors. We recommend doing a small test area before using any of our products to check for color stability, especially on light or white stone.

## Coloring

Flo-Gel 900 can easily be colored to match any stone using our Epoxy Coloring Pastes. The best shade can be obtained by mixing the product to a shade slightly darker than the actual stone color.

## Directions for Use

**Preparation:** All surfaces must be dry and free of grease, oil, efflorescence and dust. Flo-Gel 900 will bond to moist surfaces. However, a dry surface will provide the best results. Because our products do not bond with polyethylene plastics, containers of this material are ideal for mixing purposes.

**Application:** If needed, Epoxy Coloring Paste, should be added to Resin "A" before mixing with Hardener "B". The correct mixing ratio of Resin "A" to Hardener "B" is 1 to 1 by volume. Mix product carefully, scraping side of container often until a homogenous blend is achieved.

Note, too much or too little hardener can significantly impact the bonding strength properties and final color of the product.

Ambient temperature of the work area and the stone also affects curing time. Warmer temperatures speed the curing process, while lower temperatures will slow the curing process. Minimum application temperature recommended is 40°F (5°C).

When adding pigment, these products should be mixed thoroughly until color is uniformly blended. At 77°F (25°C) the mixture is workable for about 3.5 to 5 minutes (see physical properties table). **Flo-Gel 900 should not be worked once gelling has begun.** Once the product becomes rubbery, excess material may be removed with a razor blade or chisel.

When bonding stones, completely coat area to be bonded. Clamps and jigs should be used to ensure that a thin bond layer (less than 0.015 inches (0.4 mm)) is achieved, thereby providing the strongest, least visible bond. After curing, the stone piece may be further processed without damaging the material.

## Clean-Up

Unhardened product can be diluted with hydrocarbon compounds such as xylene, toluol and acetone, esters, and alcohol. Tools should be cleaned immediately after use. Hands should be cleaned with Waterless Hand cleaner.

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Physical Properties				
Characteristic	Method	Flo-Gel 900 Resin	Flo-Gel 900 Hardener	Mixed
Color	Visual	Transparent light blue	Light amber	Transparent light blue
Aspect		Liquid	Liquid	Liquid
Viscosity at 77° (25°C) (cps)	ASTM D2393	14,500 (Spl. 6 @ 10 rpm)	13,500 (Spl. 6 @ 10 rpm)	
Reacting ratio: by weight		100	98	
By volume		100	100	
Pot life at 77° (25°C) (198 grams, minutes)				8
Curing Time (Thin film, minutes)				<15
Sag Flow				yes

TYPICAL PROPERTIES OF CURED PRODUCT			
Shore D Hardness	ASTM D2240	Shore D	85
Glass Transition Temperature	TMA	°F (°C)	131 (55)
Compressive Strength	ASTM D695	psi (MPA)	12,500 (86)
Flexural Strength	ASTM D790	psi (MPA)	11,000 (77)
Flexural Modulus	ASTM D790	psi (MPA)	337,000 (2,320)

## STORAGE CONDITIONS

- *Always keep the container tightly sealed when not in use, and never expose the hardener to temperatures in excess of 100°F (38°C).*
- *Wood & Stone products are chemically inhibited to extend shelf life and improve product consistency. Storage temperature, however, is an extremely important factor in maximizing the shelf life of the products. The materials should be stored in a cool environment (50°F (10°C)) whenever possible and should never be exposed to direct sunlight or freezing.*
- *If these procedures are followed, the specialty polyesters should have a shelf life of at least one (1) year.*

## Precautions and Safety

*Observe all measures as described on the container and product MSDS. Avoid contact with skin, eyes, and respiratory system. Use protective gloves and work in a well ventilated area.*

**Disclaimer:** This information is presented in good faith to assist the user in determining whether our products are suitable for the application being considered. No warranty or representation, however, is intended or made, nor is protection from any lay or patent to be inferred, and all patent rights are reserved.

In addition, the information provided reflects our current research and is intended to increase the awareness of our products and their uses. They do not establish any liabilities on our part since application, processing, and environmental circumstances remain beyond our control. Our liability is limited to a full refund of the price of the products we supply. Specifications are subject to change. We warranty the quality of our products within the limits of our terms of sale.