



Water Clear Polyesters

- *Water Clear Flowing*
- *Quick Water Clear Flowing*
- *Water Clear Knife Grade*

Preliminary Technical Data Sheet

Description

The Water Clear Polyester products are water clear polyester based adhesives and fillers designed for use with natural stone, especially marble and limestone. They cure without yellowing and are clear and translucent. The clear polyester products are two-part adhesives that are water clear and easy to apply. Clear Flowing is a water clear colored, medium viscosity liquid that is UV stable and non-yellowing. Quick Water Clear Flowing is a faster set version, offering a quicker tack-free time. Clear Knife Grade is a translucent, high viscosity paste that is very thixotropic, UV stable, and non-yellowing.

Applications

The clear polyester formulations are best suited for interior or exterior non-structural applications on natural or cast stone, especially white and lightly colored marble. Their water clear cure allows for the best color match with light colored marble. They may be used for consolidating or laminating slabs, mending or patching broken stones, and filling porous or chipped stones. Each individual product is best suited for the following applications:

Water Clear Flowing - Ideal for laminating or repairing horizontal surfaces.

Quick Water Clear Flowing – Ideal for small laminating or repairs on horizontal surface, or work in cooler temperatures

Water Clear Knife Grade - Specifically formulated for work with vertical surfaces.

Coloring

Our Water clear polyester formulas are easily colored to match any stone using our Polyester 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. Roughening the surface is recommended. Although our polyester products will bond moist surfaces, the resulting bond to the stone will be weaker.

These products will not bond to polyethylene plastics, making vessels and applicators of this material ideal for mixing purposes.

Application: If needed, Polyester Coloring Paste should be added to the mastic before mixing the mastic with the hardening liquid (MEKP). Mix thoroughly 50g of marble filler with 35-50 drops (1g) of hardener or 1 oz. of marble filler with 20-30 drops of hardener. Additional hardener can cause yellowing and reduces bond strength. Too little hardener results in a mixture that will not cure. Ambient temperature also affects curing time. Warmer temperatures speed the curing process, while temperatures below 32°F (0°C) will require heating the mixture to start the curing process.

The product should be mixed thoroughly. At 68°F (20°C) both the Flowing and the Knife Grade mixtures are workable for about 12-20 minutes while the Quick is workable for 6 - 12 minutes (until gelling occurs). The product should not be worked once gelling has begun. After 10 - 12 hours (6 - 8 hours for the Quick) at a temperature of 68°F (20°C) work can continue on the marble filler (e.g. grinding, milling, or drilling).

When bonding stones, clamps and jigs should be used to ensure that a thin bond layer (less than 0.015 inches or 0.4mm) is achieved, thereby providing the strongest bond.

After curing, the stone piece may be further processed without damaging the material.

Clean-Up

After use, equipment may be cleaned with toluene or acetone. Hands should be cleaned with Waterless Hand cleaner or an appropriate solvent such as Cupran.

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Physical Properties				
Characteristic	Method	Flowing	Quick Flowing	Knife Grade
Color	Visual	Slight green tint	Slight green tint	Translucent
Aspect		Syrup-like	Syrup-like	Thixotropic paste
Viscosity at 25°C (cps)	ASTM D2393	700	600	203,000
Pot life at 25°C (2% hardener, minutes), 102 grams		15 - 20	5 - 7	15 - 20
Curing Time (Thin film, hours)		8 - 10	5 - 7	8 - 10
Sag Flow		Yes	Yes	No

TYPICAL PROPERTIES OF CURED PRODUCT				
Shore D Hardness (ASTM D2240)	Shore D	82	84	79
Tensile Strength (ASTM D638)	psi (MPA)	4,900 (34)	TBD	3,600 (25)
Compressive Strength (ASTM D695)	psi (MPA)	17,900 (123)	TBD	12,600 (87)
Flexural Strength (ASTMD790)	psi (MPA)	7,200 (50)	TBD	7,600 (52)

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.*
- *If these procedures are followed, these products 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.

Guarantee: *The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.*

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