



UNI EN ISO 9001:2008
Quality System Certified Company



TECHNICAL DATA SHEET

PRODUCT

GENERAL

POLYESTER ADHESIVE/GLUE
FLUID or VERTICAL/SOLID or/and SEMISOLID
For MARBLE, TERRAZZO and NATURAL STONE
colours: **STRAW, WHITE, BLACK, GREY, RED, etc**

DUAL- COMPONENT POLYESTER RESIN BASED ADHESIVE FOR MARBLE, NATURAL STONE, TERRAZZO

Main characteristics of the polyester resins are high reactivity, fast hardening, modest shrinkage (1 to 6%) during the hardening, long lasting and good chemical inertia.

The choice of raw materials of high quality and a severe selection of the suppliers, grant constant physical and mechanical characteristics and one of the higher quality grade on the market. The mineral fillers used are carefully monitored to ensure purity, inertia and proper granular dimensions to grant a greater chemical inertia, strength and homogeneity to the product. A constant research of new formulations allows, by a wide range of products, flexible and specific answers to the many requirements of the market.

GENERAL is available in the following formulations:

FLUID	(GF)
VERTICAL/SOLID or/and SEMISOLID	(GV)

TECHNICAL DATA

PHYSICAL STATE	paste (GV),	fluid (GF),
COLOUR	straw/beige, white, black, grey, red, marfil, etc. (special colours on demand)	
DENSITY at 25°C (77°F)	1,65 g/cm³ (GV)	1,4 g/cm³ (GF)
VISCOSITY at 25°C (77°F)	250.000 - 300.000 cPs (Vertical/Solid) 150.000 - 250.000 cPs (Semisolid) 30.000 - 60.000 cPs (Fluid)	
STABILITY	6 months	in well closed original container, stored in dry place at temperature of 15-25°C (59-77°F)

PREPARATION

For best results mix 2% to 3% of the catalyst (dibenzoyl peroxide) with the adhesive. The paste formula makes easy to measure. A homogeneous mixing will facilitate uniform catalysis. The catalysis rate is effected by temperature and by the proportion/quantity of catalyst. An excess of hardener/catalyst will increase the hardening speed, but weakens the adhesive seal. Surfaces to be treated/glued must be clean and dry; porosity and light roughness of the surface favour the best adhesion.

NOTE

To obtain the right colour or shade of the material to be treated/glued the proper colouring pastes **Base Colore** can be used to be mixed to the adhesive. The adhesive that can be coloured is the **straw** colour (It is the basic formulation of the adhesive). Never colour white adhesive. Colouring can weaken the performance of the adhesive. The hardened/cured adhesive is completely workable (grinded, polished, sanded, buffed etc.) after 4 to 5 hours (better is after 24 hours).

Laboratory tests evidence that the adhesive, once hardened and properly cured, resists also to temperatures lower than 0°C (32°F). Because of the difference of dilatation or/and contraction between the support (marble, granite, stone), temperature well below 0°C (32°F) can anyway be cause of weakening or separation of the material.



MIXING AND USING TIME - HARDENED/CURED PASTE MECHANICAL CHARACTERISTICS

		FLUID	VERTICAL SOLID
MIXING	minutes	1	1
APPLICATION TIME (pot life)	minutes	1 - 4	1 – 4
GEL TIME (after Pot Life)	minutes	5 - 7	5 – 7
SHRINKAGE	%	1,9	1,6
DISTORTION TEMPERATURE (HDT)	°C (°F)	> 80 (176)	> 80 (176)
TENSILE STRENGTH (ASTM D 638)	MPa	45	42
TENSILE ELASTICITY MODULUS	MPa	2900	3000
BREAKING ELONGATION	%	2,1	2,1
BENDING STRENGTH (ASTM D790)	MPa	84	76
BENDING ELASTICITY MODULUS	MPa	3010	3090

LIMITATION OF LIABILITY The data provided derive from published information or from our own laboratory tests. The information provided here must be considered as a guideline and not as any form of performance guarantee. Since the application of the product is beyond the control of the manufacturer or supplier, our liability for defective products, when verified, is limited to the refund of the purchase price.

A PRELIMINARY TEST IN A SMALL, HIDDEN, AREA IS RECOMMENDED BEFORE THE APPLICATION