

TECHNICAL DATA SHEET (TDS)

IMPREPOX

ID Product Code 019



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LOW VISCOSITY EPOXY RESIN

Resin for filling and repair.

Product description:

Two component epoxy system used mainly in the stone processing field, to restore and consolidate natural stone surfaces, porous and leaky concrete and cement objects, and to reinforce rear of natural stone slabs subject to breakage.

IMPREPOX1000 is a thermo-hardening, very low viscosity resin based product that reticulates with epoxy specific hardener at room temperature, to be used as hard protective coating chemically resistant in civil engineering, with high solid content, extra transparent and without VOC.

IMPREPOX1000 is particularly suitable for the closing of capillaries and micro cracks, it offers hardness and flexibility, best resistance to chemicals and solvents, it gives particular adhesion and shining after polishing. It is completely transparent and does not turn in yellow. Its renewed formula makes it the best product to fill and seal imperfections on clear marbles and granites.

Chemical characteristics:

Appearance	Liquid
Color	Transparent
Odor	Characteristic
Specific gravity at 20°C (68°F)	
Part A - Resin	1,12 ± 0,02
Part B - Hardener	0,97 ± 0,02
Hydro-solubility	Not soluble
pH	N.D.
Brookfield Viscosity at 25°C (77°F)	180/290 mPas
Viscosity of A+B mix (Flux speed)	19" Cup DIN 4 at 25°C/77°F
Catalysis ratio	4 :1
Drying time	Grinding can be done after 24 hours at room temperature, or after 4 hours at 60°C/140°F
Adhesion on natural stone	Cohesive breaking of stone: 4 - 7 MPa
Pull-off strength ASTM D4541	30 kg/cm ² - 426,7 lbs/in ²
Flexure resistance UNI6133	670 kg/cm ² - 9529,6 lbs/in ²
Compressive stress resistance UNI6134	540 kg/cm ² - 7680,6 lbs/in ²
UV Resistance:	U.V. Lamp Spectronics ENF260CFE
Long wave 365 nm	Very good (no variation after 60 hours exposure)
Short wave 254 nm	Very good (no variation after 60 hours exposure)
Resistance to chemicals:	Solution of common salt at 10%
	Sea water
	Ammonia at 10%
	Sodium hydroxide at 10%
	Hydrochloric acid at 10%
	Hydrocarbons
Storage at 20°C (68°F) away from heat, moisture, sunlight :	24 months in original packaging

(*) indicative values relating to the hardened resin object of laboratory tests



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Instruction for use

The parts to be bonded or filled must be clean, completely dry and free of dust; if possible, roughen them slightly.

Mix thoroughly the two dosed components, in the ratio (by weight) of 4 : 1 (A : B), using small quantities of product in order to avoid waste from too fast curing (mass effect). For a good job, usually 250-300 grams (8-11 oz per mixing) at a time are sufficient per single catalysis.

The mix has a workable time of 20/30 minutes at 20°C/68°F, the time will be longer at lower rooms temperature and shorter at higher room temperature. Grinding can be done after 24 hours at room temperature (20°C/68°F), or it is possible to warm the slab to higher temperature in order to shorten drying time:

Substrate temperature	Full curing time
20°C (68°F)	24 hours
30°C (86°F)	12 hours
40°C (104°F)	6 hours
50°C (122°F)	4 hours
60°C (140°F)	3 hours

Finishing (smoothing) can be run after 6-7 hours (at 20°C/68°F) from jointing, after 14-16 hours (at 20°C/68°F) can be sanded. Complete polymerisation will be after 7 days from applications. Do not apply at temperatures below 10°C/50°F.

Highlights

- Very low tendency to yellowing thanks to U.V. filters in the formulation
- Transparent Clear
- Extremely low shrinkage
- Weatherproof gluing
- Excellent resistance to alkalis, therefore suitable for bonding with concrete
- Suitable for bonding material impermeable to gas, because product is free of solvents
- Excellent resin layering elements to create "sandwich" elements
- Suitable for bonding solvent sensitive materials
- No emission of V.O.C. (Volatile Organic Compounds) in accordance with European standards.

Suggestion for use and recommendations:

- Avoid to use the mastic at temperature below 10°C (50°F) because drying process could not be complete.
- Epoxy resins are sensible to humidity because could change reaction times, it is advised not to apply the product in situation of high humidity.
- Never catalyze the total quantity of the mastic at one time in order to avoid "mass effect" because the mastic will dry quickly.
- Do not use hardener in different ratio than indicated on the tin or in the present bulletin; it will prejudice catalysis time and could never dry, or change the color of catalyzed product.
- Do not use the coloring paste in quantity more than 5% as it could prejudice the adhesion.
- Part A and Part B should be taken only with different paddles/spatulas.
- Adhesive already thickened or in gel phase could no longer be worked.
- Tools can be cleaned with nitro solvent.
- Keep lid well closed and store product in a cool and ventilated place
- Avoid contaminating part A with part B.
- Before use read the recommendations printed on the label and always carry out a preliminary test.

Application surfaces

Granite, marbles, agglomerated and engineered stones, terrazzo and stones, concrete elements, bonding of different materials between them.



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Safety procedures

As far as the proper working procedures is concerned, we recommend to consult Material Safety Data Sheets issued according to E.U. rules and to follow your national laws concerning safety in the working place. MSDS is available on our web site www.bellinzoni.com

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Packing

Item N°	Part	Packing	Pieces for cardboard
019MEFLA001	Part A	Kg 1 (35,2 oz.)	6
019MEFLB00025	Part B	gr. 500 (17,6 oz.)	6

The tins are in Steel (ACC) after use will have to be recycled according to the regulations on waste disposal. The packages are approved under U.N. directives rules for inland transport (ADR) and by sea (IMO) for transportation via air refer to local regulations (IATA). For further information regarding transport please check MSDS.

Trademark and Origin of the good

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