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**Technical Data Sheet**

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**Properties:**

AKEMI® Colour Bond is a gel-like 2-component product based on epoxyacrylate resins dissolved in styrene. The product is distinguished by the following qualities:

- very good workable because of very smooth, slightly gel-like consistency, does not form filaments
- very fast hardening (15 – 40 minutes)
- very good surface drying
- excellently polishable
- easy dosing and mixing by using the cartridge system
- cartridge system both available with working time 6 minutes and 12 minutes
- wide colour palette available – more than 50 colours - for a seamless bonding of many Engineered Stone types
- improved protection against yellowing
- very good adhesion on Engineered Stone as well as on natural and artificial stones also at higher temperatures (60–70°C/140-158°F, in case of low exposure to strain: 100–110°C/212-230°F)
- resistant to water, petrol and mineral oils
- after hardening the product is harmless to health upon contact with food products – certified by an external German testing institute
- COV contents according to ASTM D2369: 12 g/L; determined by an external testing institute; fulfils LEED v4 EQc2 SCAQMD Rule 1168 for Multipurpose Construction Adhesives

**Application Area:**

AKEMI® Colour Bond is mainly used for a colour adjusted bonding of Engineered Stone such as e.g. CaesarStone®, Silestone®, Zodiaq®, Corian®, natural stones, ceramics and large-size techno ceramic (e.g. Dekton®, Lapitec®, Neolith®, Laminam®, Kerlite®, Maxfine) in industry and handicraft.

**Instructions for Use:**

- without mixing nozzle: dosing apparatus only
  - with mixing nozzle: dosing and mixing apparatus at the same time
1. Thoroughly clean, dry and slightly roughen surfaces to be bonded.
  2. Remove the clasp from the cartridge and put the cartridge in the gun; work the grip until material emerges from both openings; then eventually screw up the mixing nozzle. Do not use the first 10 cm pressed out of the mixing nozzle.
  3. Both components must be thoroughly mixed when working without mixing nozzle.
  4. The mixture of Colour Bond 6 min remains workable for approx. 5-7 min (20°C/68°F), mixture of Colour Bond 12 min remains workable for approx. 10 – 12 min (20°C/68°F).
  5. After approx. 20-30 minutes (Colour Bond 6 min) resp. after approx. 30 – 40 minutes (Colour Bond 12 min) at 20°C/68°F work can continue on the cured Colour Bond (grinding, milling, drilling).
  6. The hardening process is accelerated by heat and delayed by cold.
  7. Tools can be cleaned with AKEMI Nitro-Dilution.

**Special Notes:**

- Use AKEMI® Liquid Glove to protect your hands.
- An adhesive which is already thickened or just gelling should not be used anymore.

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- The bonding layers should be as thin as possible (< 1 mm) due to shrinkage (approx. 5-8%) caused by the high reactivity of the filler and development of heat during the hardening process.
- Non-durable resistance of bondings which are frequently exposed to humidity and frost.
- Moderate adhesion on fresh, alkaline building materials (e.g. concrete, concrete bricks).
- The hardened Colour Bond has a very slight tendency to yellowing.
- Once hardened, Colour Bond can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C/392°F).
- Colour Bond 12 min should not be worked at temperatures below 20°C/68°F.
- Use AKEMI® original mixing nozzle only.
- It is recommended to remove the mixing nozzle after use and close with the original clasp. Before you screw up a new mixing nozzle make sure that material emerges from both openings.

**Technical Data:**

Colour: different  
Density: approx. 1.10 g/cm<sup>3</sup>

Working time / min.:

Colour Bond	<u>6 min</u>	<u>12 min</u>
at 10°C	10-16	-----
at 20°C	5- 7	10-12
at 30°C	3- 5	5- 7

Mechanical properties:

Bending strength DIN EN ISO 178: 70 - 80 N/mm<sup>2</sup>  
Tensile strength EN ISO 527: 40 - 50 N/mm<sup>2</sup>  
Compressive strength DIN EN ISO 604: 100 – 110 N/mm<sup>2</sup>

**Storage:**

1 year approx. if stored in cool place free from frost in its tightly closed original container.

**Health & Safety:**

Read Material Safety Data Sheet before handling or using this product.

**Important Notice:**

The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trails of the product, in an inconspicuous area or fabrication of a sample piece.