

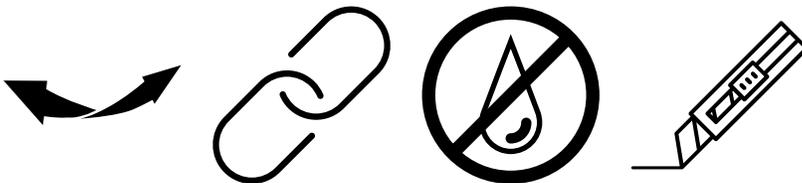
# STONE BOND™

**Stone Bond is a super flexible, dripless/non-sag, low shrink, hard surfacing adhesive designed for the nearly seamless bonding of an assortment of trending countertop surfaces.**

Stone Bond has a working time of 10–15 minutes and achieves nearly 90 percent of its ultimate strength within 45–60 minutes at room temperature curing.

Stone Bond can be applied to surfaces vertically as well as horizontally without dripping. After gelling, Stone Bond allows 5–10 minutes to trim the excess from the stone slab with a razor blade.

Take the Stone Bond challenge and test it for yourself.

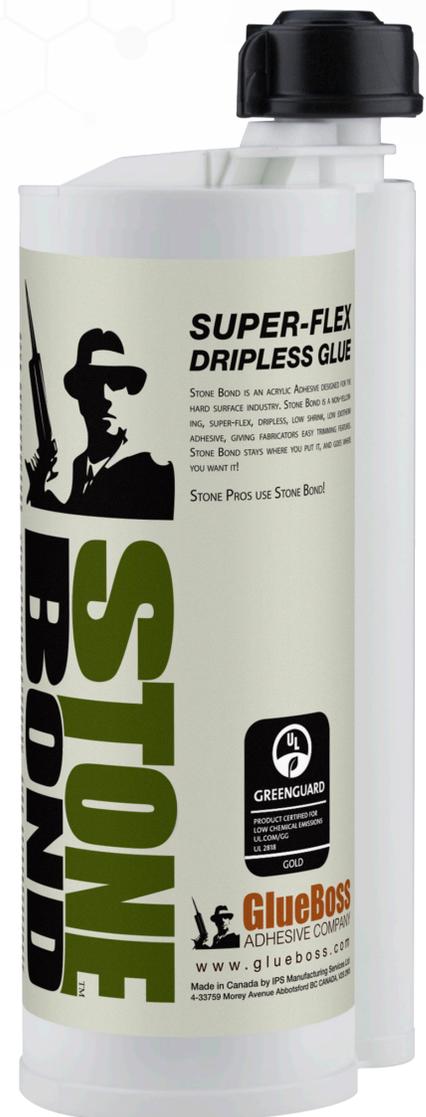


**Super  
Flexible**

**Strong Bond  
to Stone**

**Dripless  
Non-sagging**

**Trim for easy  
fabrication**





# Technical Data Sheet

## Product Description

Stone Bond is a two-part methacrylate, super flexible, dripless/non-sag, low shrink, low exotherm, ultra violet light stable, non-yellowing hard surfacing adhesive designed for the fabrication of mitered edges, laminations and deck seams on most hard surfacing materials.

Combined at a ratio of 10:1 (10 parts resin, one part activator), Stone Bond has a working time of 10 to 15 minutes, with a 5 to 10 minute De-Roping Time, and achieves nearly 90 percent of its ultimate strength in 45 to 60 minutes at room temperature curing.

Stone Bond offers a combination of high strength, stiffness, and toughness as well as the ability to bond very strongly to a wide variety of hard surface or inorganic materials.

Stone Bond permits the seasoned fabricator the opportunity to apply the adhesive to vertical surfaces, as well as horizontal surfaces, without dripping, and upon gelation, gives the fabricator an extended window (5 to 10 minutes) to de-rope, or trim with a single bladed straight edge razor blade, the excess from the stone slab without ripping the adhesive out of the joint, nor damaging the surface of the stone.

## Application

To assure maximum bond strength, surfaces must be mated together within the specified working time, and all clamps affixed within that time. Use sufficient material to ensure that the joint is completely filled when parts are mated and clamped. Avoid over clamping parts, which may cause a dry joint or a joint starved of adhesive. All adhesive application, part positioning, fixturing, and clamping should occur before the working time of the adhesive has expired. After the indicated working time, parts must remain undisturbed until the fixture time is completed. Sheet, adhesive, and shop temperature can have a significant effect on the work and fixture time of the adhesive. Application of Stone Bond adhesive at temperatures between 65°F and 85°F (18°C and 30°C) will ensure proper cure. Temperatures below 65°F (18°C) will slow cure and fixture speed. Stone Bond will still react, but will take longer. Temperatures above 85°F (30°C) will increase cure and fixture speeds, and there's a risk that the adhesive will be hardened or too thick to pull a tight seam. The viscosity of Stone Bond is affected by temperature.

## Handling and Storage

The shelf life of Stone Bond is one (2) years from the date of manufacture based upon continuous storage at room temperature (77°F or 25°C). Storage of Stone Bond in refrigerated compartments will extend the shelf life even more. Do not store Stone Bond or any other adhesives in a refrigerator which has food or lunch products in them. Be sure to bring Stone Bond to room temperature for 24 hours before use, otherwise longer cure and fixture times may be expected. Long-term storage at temperatures above room temperature will shorten the shelf life of Stone Bond, especially the activity of the catalyst. Storage at temperatures above 100°F or 38°C could shorten the shelf life to less than one month. Stone Bond contains no water, so freezing of the adhesive for short periods is permissible, but is not encouraged.

## Applications

Non drip adhesive for the fabrication of mitered edges, laminations and deck seams on most hard surfacing materials.

## Advantages

- Non Drip / No Sag
- Flexible/Trimmable Adhesive
- Auto-dispense system
- Invisible seams
- Pre-mixed colors
- High strength
- UV resistant
- GreenGuard Certified

Characteristic	Attribute
Working Time	10 – 12 minutes
De-roping time	5 – 10 minutes
Fixture time	20 – 30 minutes
Routable	45 – 60 minutes
Operating Temperature	65°F – 85°F (18°C – 30°C)
Gap Filling	0.250 inches – 5mm
Mixed Density	8.6 lbs/gal (0.98 g/cm³)
Viscosity — Adhesive	200,000 – 350,000 cps
Viscosity — Activator	75,000 cps
Color — Adhesive	Various
Color — Activator	Colorless / Translucent
Mix ratio	10:1
Tensile Strength — Natural Stone	4,000 – 5,000 PSI / Substrate Failure
Tensile Strength — Quartz	4,500 – 6,000 PSI / Substrate Failure
Flash Point	51°F (11°C) See SDS for more Information
Shelf Life	2 years
Recommended Operating Temperature	60°–85°F (15°–30°C) * Use at temperatures below 55°F(12°C) or above 90°F(32°C) may cause incomplete cure, yellowing and poor bonding strength.
Resistances to:	Susceptible to:
Hydrocarbons, Acids and Bases, Vinegar, Wine and condiments, Most household foods	Polar solvents, Super strong acids and bases

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