

Technical Data Sheet

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Properties:

AKEPOX® Panel Adhesive 7030 is a creamy-stable, solvent-free, two-component adhesive with filling agents based on an epoxy resin containing a modified polyamine hardener. The product is characterized by the following properties:

- very fast hardening (2 - 4 h at 20°C)
- excellent workability
- very good stability for horizontal and vertical applications
- low shrinkage during the hardening process and therefore low tensions in the bonding layer
- good dimensional stability of the bonding layer
- very good alkali stability, therefore excellently suitable for cement-bound bondings
- excellently suitable for bonding of gas-impermeable materials as it is a solvent-free product
- suitable for bonding materials which are sensitive to solvents (e.g. expanded polystyrene)

Application Area:

AKEPOX® Panel Adhesive 7030 is mainly for surface area bonding of natural stone (marble, granite), artificial stone (quartz, Agglo) or ceramics on cement-coated rigid foam building boards on horizontal and vertical surfaces. Also excellently suited for sandwich bondings, especially on GRP-coated aluminium honeycomb boards. The product is also suited for bonding other materials such as wood and paper. AKEPOX® 7030 is not suitable for bonding of polyolefines (polyethylene, poly-propylene), silicones, hydrocarbon fluorides (Teflon), soft PVC, soft polyurethane, butyl rubber and metal.

Instructions for Use:

1. Surfaces to be bonded must be clean, dry, load-bearing and roughened.
2. Thoroughly mix 3 parts (volume or weight) of component A with 1 part (volume or weight) of component B until a homogeneous shade of colour is achieved.
3. AKEPOX® Colouring Pastes or Concentrates can be added up to max. 5 %.
4. The mixture remains workable for approx. 20 - 30 minutes (20°C).
5. After approx. 2 - 4 hours (20°C) the bonded parts may be moved, after 8 - 10 hours (20°C) approx. they may be further processed. Maximal stability after 7 days (20°C).
6. Tools can be cleaned with AKEMI® Cleaner A.
7. The hardening process is accelerated by heat and delayed by cold.

Special Notes:

- Only if the right mixing ratio is kept, optimal mechanical and chemical properties can be obtained. A surplus of adhesive or hardener has the effect of a softener and can cause discolouration in the marginal zone.
- Two separate spatulas should be used for the adhesive and the hardener.
- An adhesive is no longer to be used if it has already thickened or is jellying.
- The product is not to be used at temperatures below 10°C because it will not sufficiently harden.
- Already hardened adhesive can no longer be removed by solvents, but only mechanically or by treatment with higher temperatures (> 200°C).

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|---|--|--------------|--------------|--------------|--------------|--------------|---------------|---------------|---|----|----|----|----|----|----|----|--|
| 1. Colour comp. A and B: | grey | | | | | | | | | | | | | | | | |
| 2. Density comp. A and B: | approx. 1.8 g/cm ³ | | | | | | | | | | | | | | | | |
| 3. Working time: | | | | | | | | | | | | | | | | | |
| a) mixture of 150 g component A +
50 g of component B: | at 10°C: 40 - 60 minutes
at 20°C: 20 - 30 minutes
at 30°C: 10 - 15 minutes
at 40°C: 5 - 8 minutes | | | | | | | | | | | | | | | | |
| b) at 20°C and varying amounts: | | | | | | | | | | | | | | | | | |
| 150 g comp. A + 50 g comp. B: | 20 - 30 minutes | | | | | | | | | | | | | | | | |
| 300 g comp. A + 100 g comp. B: | 15 - 25 minutes | | | | | | | | | | | | | | | | |
| 4. Hardening process (shore D-hard-
ness of a 2 mm layer at 20°C: | | | | | | | | | | | | | | | | | |
| <table border="0"> <tr> <td><u>2 hrs</u></td> <td><u>3 hrs</u></td> <td><u>4 hrs</u></td> <td><u>5 hrs</u></td> <td><u>6 hrs</u></td> <td><u>7 hrs</u></td> <td><u>8 hrs</u></td> <td><u>24 hrs</u></td> </tr> <tr> <td>-</td> <td>41</td> <td>69</td> <td>79</td> <td>81</td> <td>81</td> <td>82</td> <td>84</td> </tr> </table> | <u>2 hrs</u> | <u>3 hrs</u> | <u>4 hrs</u> | <u>5 hrs</u> | <u>6 hrs</u> | <u>7 hrs</u> | <u>8 hrs</u> | <u>24 hrs</u> | - | 41 | 69 | 79 | 81 | 81 | 82 | 84 | |
| <u>2 hrs</u> | <u>3 hrs</u> | <u>4 hrs</u> | <u>5 hrs</u> | <u>6 hrs</u> | <u>7 hrs</u> | <u>8 hrs</u> | <u>24 hrs</u> | | | | | | | | | | |
| - | 41 | 69 | 79 | 81 | 81 | 82 | 84 | | | | | | | | | | |
| 5. Mechanical properties: | | | | | | | | | | | | | | | | | |
| Bending strength DIN EN ISO 178: | 40 - 45 N/mm ² | | | | | | | | | | | | | | | | |
| Compressive strength DIN EN ISO 604: | 70 - 80 N/mm ² | | | | | | | | | | | | | | | | |

Storage:

If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 24 months from production.

Health & Safety:

Read 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.