

## Technical Data Sheet

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- Properties:** AKEPOX® 1006 Solid is a gel-like, two-component, epoxy resin system with a modified amine hardener which is used for block strengthening. The product is characterized by the following properties:
- long working time
  - gel-like consistency, therefore easy to be filled
  - light transparent, best suitable for light natural stones
  - free of solvents
  - weather-resistant
  - excellent grinding and polishing properties
  - increases the yield and the productivity
  - classification according to the Berufsgenossenschaft der Bauwirtschaft (Accident Prevention and Insurance Association of the German Building Industry): GISCODE: RE 01
- Application Area:** AKEPOX® 1006 Solid is mainly used in the stone-working industry for block strengthening of brittle blocks in combination with glass fiber fabrics as well as for filling of holes in slabs and strips made of natural stone, concrete and concrete ashlar. The hardened product shows a minimal tendency to yellow if exposed to ultraviolet light or to warmth.
- Instructions for Use:**
1. The surfaces to be treated must be clean and dry.
  2. Four parts by weight of Component A are to be thoroughly mixed with one part by weight of Component B (e.g. 100 g and 25 g).
  3. AKEPOX® colouring concentrates or Stone Ink can be used for colouring if required (max. 5%).
  4. The mixture remains workable for approx. 5 – 8 hours at 20°C and is applied to the whole surface with a fine-toothed spreader.
  5. The surfaces can be ground and polished after approx. 2 days at room temperature. Pre-warmed natural stone slabs can be polished and grind after approx. 7 hours at 50°C and subsequent cooling.
  6. The contact pressure of the grinding and polishing segments should be 1 to 1.5 bar at the most.
  7. Tools can be cleaned with AKEMI® Universal Dilution.
  8. Warmth accelerates and cold retards the hardening process.
  9. Empty the container fully before disposing of it.
- Special Notes:**
- The optimal mechanical and chemical properties can only be attained by adhering to the exact mixing proportions; excess adhesive or hardener has the effect of a plasticizer.
  - The colour of the treated surfaces may deepen to a greater or lesser extent depending upon the type of stone involved; a deepening of colour may be more noticeable in the fissured area. Therefore we recommend to test on a sample piece.
  - The product is not suited as a surface layer or sealer.
  - Use separate vessels when component A and B are being extracted from their containers.
  - The resin is no longer to be used if it has already thickened or is jellying.
  - The best surfaces can only be achieved by using high-quality grinding and polishing segments.
  - The product is not to be used at temperatures below 15°C because it will not sufficiently harden.
  - The hardened resin can no longer be removed by means of solvents.

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This can only be achieved mechanically or by applying higher temperatures (> 200°C).

- If the resin has been correctly worked it presents no hazard to health when the hardening process is completed.

**Technical Data:**

Colour: transparent milky  
Density: comp. A: 1.17 g/cm<sup>3</sup>  
comp. B: 0.94 g/cm<sup>3</sup>

**Working time:**

a) at varying temperatures and  
a quantity of 125 g:

15°C:	7 – 12 hours
20°C:	5 – 8 hours
30°C:	2.5 – 4 hours
40°C:	1 – 2 hours

b) hardening times for stone slabs  
which have been pre-warmed to the  
given temperatures:

20°C:	approx. 48 hours
30°C:	approx. 24 hours
40°C:	12 - 14 hours
50°C:	6 - 8 hours
60°C:	3 - 4 hours

**Storage:**

2 years approx. under cool conditions in the firmly 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 trials of the product, in an inconspicuous area or fabrication of a sample piece.

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