Technical Data Sheet

Properties:

AKEPOX® 1016 Black Magic is a very fluid, black two-component epoxy resin system with a modified amine hardener which is used for intensifying the colour of black stones. The product is characterized by the following properties:

- black colour, therefore suitable for black or dark stones
- highly penetrative properties on account of its very fluid consistency
- solvent-free

Application Area:

AKEPOX® 1016 Black Magic is mainly used in the stone-working industry for dyeing of natural stones, concrete and concrete ashlar. Due to the black colour the natural colour of the stone is intensified.

Instructions for Use:

1. The stone slabs which are to be treated must be pre-calibrated according to their nominal thickness and must be clean and dry.
2. If the surface of the stone is pre-warmed (60°C to 70°C), the penetrative capacity and colour intensification will be increased considerably.
3. Three parts of Component A are to be thoroughly mixed with one part of Component B (e.g. 75 g and 25 g by volume or weight).
4. The mixture remains workable for approx. 1 – 2 hours at 20°C and is applied to the whole surface with a brush or roller; apply more than once on more absorbent surfaces..
5. The surfaces can be ground and polished after approx. 1 day at room temperature.
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 stone may change by strong UV radiation.
- Use separate vessels when component A and B are being extracted from their containers.
- Upon exceeding of the working time the penetrative capacity will be reduced.
- 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. 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:	comp. A: colourless transparent comp. B: black
Density:	comp. A: 1.07 g/cm³ comp. B: 1.04 g/cm³
Consumption:	approx. 100 – 200 g/m²

AKEMI GmbH · Lechstraße 28 · 90451 Nürnberg · Germany
Tel. +49(0)911-64296-0 · Fax +49(0)911-644456 · www.akemi.com

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Working time:		
a) at varying temperatures and a quantity of 100 g:	15°C:	2 – 4 hours
	20°C:	1 – 2 hours
	40°C:	0.5 – 1 hour
Hardening times for stone slabs which have been pre-warmed to the given temperatures:	20°C:	18 - 24 hours
	40°C:	4 - 8 hours
Surface is tack-free in thin layer:	20°C:	approx. 3 hours
	40°C:	approx. 1.5 hours
	60°C:	approx. 1.5 hours

Treated stones can be used in a temperature range of -20°C to +80°C.

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 trails of the product, in an inconspicuous area or fabrication of a sample piece.

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