

Technical Data Sheet

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- Properties:** AKEMI® Match Bond is a styrene-free, gel-like 2-component product based on acrylic resins. The product is distinguished by the following qualities:
- very good workable because of very smooth, slightly gel-like consistency
 - does not form filaments, therefore especially exact working possible
 - very fast hardening (20 – 30 minutes)
 - very fast surface drying
 - excellently polishable
 - easy dosing and mixing by using the cartridge system
 - cartridge system with a working time of 10 minutes
 - wide colour palette available with most common colours for a seamless bonding of many Engineered Stone, ceramics and natural stone
 - AKEMI® Colour Matching System for an optimal colour adjustment
 - very low tendency to yellow
 - 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
- Application Area:** AKEMI® Match Bond is mainly used indoors 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. The product is especially recommended for bonding of acrylic stones.
- 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 remains workable for approx. 9 – 11 min (20°C/68°F).
 5. At 20°C/68°F the product can already be mechanically worked after approx. 25 – 30 minutes (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.
 - Do not throw away the cartridge clasp.
 - 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.
 - 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 adhesive 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 Match Bond has a very slight tendency to yellowing.
- Once hardened, Match Bond can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C/392°F).
- Being worked properly the hardened adhesive is not injurious to health.

Technical Data:

Colour: various
Density: approx. 1.05 g/cm³

Working time / min. (mixture of 100 g):

at 10°C	17 - 19
at 20°C	9 - 11
at 30°C	5 - 7

Shore D hardness (20°C, layer of 2mm)

<u>18 min</u>	<u>20 min</u>	<u>22 min</u>	<u>24 min</u>	<u>30 min</u>	<u>24 h</u>
43	70	75	76	78	88

Mechanical properties of hardened adhesive:

Tensile strength EN ISO 527:	15 - 20 N/mm ²
E-module EN ISO 527:	750 - 830 N/mm ²
Elongation at break EN ISO 527:	3 - 5 %

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

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