



Tile Adhesive

- Description:** High strength, trowelable adhesive compound that cures at room temperature
- Intended Use:** Industrial Use: Bonding ceramic tile to vertical, curved, and overhead surfaces; repairing loose ceramic tiles
- Features:**
 - Easy to use 1:1 formula
 - Supports 4 lbs./sq. ft while curing
 - Excellent acid and alkali resistance
 - Non-sagging
 - Excellent adhesion to metal, ceramic, and concrete
- Limitations:** Suitability of product is determined by the end user for their application and process.

Technical data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties:

Cured 7 Days @ 75°F (24°C)

	Typical Values
Adhesive Tensile Shear	1,945 psi (13.4 MPa)
Coefficient of Thermal Expansion (x10-6)	14 in/in.°F (25.2 cm/cm.°C)
Compressive Strength	9,620 psi (66.3 MPa)
Cured Shrinkage	0.0010 in/in (cm/cm)
Dielectric Constant	46
Flexural Strength	5,480 psi (37.8 MPa)
Hardness	81 Shore D
Solids by Volume	100%
Temperature Resistance	200°F (93°C)
Tensile Strength	2,640 psi (18.2 MPa)

Standard Tests

- Adhesive Tensile Shear ASTM D 1002
- Cured Hardness Shore D ASTM D 2240
- Coef. of Thermal Expansion ASTM D 696
- Dielectric Constant ASTM D 150
- Cure Shrinkage ASTM D 2566
- Flexural Strength ASTM D 790
- Modulus of Elasticity ASTM D 638
- Thermal Conductivity ASTM C 177
- Compressive Strength ASTM D 695

Uncured Properties @ 72°F (23°C)

Color	White
Coverage (1/4" / 6.35mm)	76.8 in ² /lb (1092 cm ² /Kg)
Density	12.1 lb/Gal (1.45 g/cm ³)
Functional Cure	8 - 12 hrs
Mix Ratio by Volume	1:1
Mix Ratio by Weight	1.1:1
Mixed Viscosity	Putty Pot
Pot Life @ 75F	4 hrs.
Recoat Time	11 - 16 hrs
Specific Volume	19.2 in ³ /lb (0.69 cm ³ /g)

Surface Preparation:

1. Thoroughly clean the surface with Devcon® Cleaner Blend 300 to remove all oil, grease and dirt.
2. Grit blast surface area with 8-40 mesh grit, or grind with a coarse wheel or abrasive disc pad, to create increased surface area for better adhesion (Caution: An abrasive disc pad can only be used provided white metal is revealed). Desired profile is 3-5mil, including defined edges (do not "feather-edge" epoxy).

Note: For metals exposed to sea water or other salt solution, grit-blast and high-pressure-water-blast the area, then leave overnight to allow any salts in the metal to "sweat" to the surface. Repeat blasting to "sweat out" all soluble salts. Perform chloride contamination test to determine soluble salt content (should be no more than 40ppm).

3. Clean surface again with Devcon® Cleaner Blend 300 to remove all traces of oil, grease, dust or other foreign substances from the grit blasting.
4. Repair surface as soon as possible to eliminate any changes or surface contaminants.

WORKING CONDITIONS: Ideal application temperature is 55°F to 90°F (13-32°C). In cold working conditions, directly heat repair area to 100-110°F (38-43°C) prior to applying epoxy and maintain at this temperature during product cure to dry off any moisture, contamination or solvents, as well as to achieve maximum performance properties.

Mixing Instructions:

---- It is strongly recommended that full units be mixed, as ratios are pre-measured. ----

1. Add hardener to resin.
2. Mix thoroughly with screwdriver or similar tool (continuously scrape material away from sides and bottom of container) until a uniform, streak-free consistency is obtained.

INTERMEDIATE SIZES (1,2,3 lb. units): Place resin and hardener on a flat, disposable surface such as cardboard, plywood or plastic sheet. Use a trowel or wide-blade tool to mix the material as in Step 2 above.

LARGE SIZES: (25 lb., 30 lb., 50 lb. buckets): Use a T-shaped mixing paddle or a propeller-type Jiffy Mixer Model ES on an electric drill. Thoroughly fold putty by vigorously moving paddle/propeller up and down until a homogenous mix of resin and hardener is attained.

Application Instructions:

Apply Tile Adhesive with either a smooth or notched trowel.

TO APPLY:

1. Apply Tile Adhesive to base.
2. Press tile from its center outward to force out excess resin and eliminate air entrapment.
3. Pound tile with a rubber hammer to ensure a close fit.
4. Scrape excess adhesive from tile seams.

ADDITIONAL INFORMATION:

- Tile Adhesive has a very high green strength, which means that tiles will not slip during the cure process unless shortens functional cure and pot life.
- Tile Adhesive fully cures in 16 hours, at which time it can be machined, drilled or painted.

Storage:

Shelf life 3 yrs from manufacture. See package label. Store at room temperature, 70 °F (21°C)

Compliances:

None

Chemical Resistance:

Rating chemical resistance is not necessary for this product.

Precautions:

FOR INDUSTRIAL USE ONLY: Please refer to the appropriate Safety Data Sheet prior to using this product.

Warranty:

ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Order Information:

<u>Item No.</u>	<u>Package Size</u>
11495	20 lb (9.07 Kg)

Contacts:

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Disclaimer:

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