

## Touchstone<sup>™</sup> Invisibond



### Product Description

A structural bonding epoxy for laminating and bonding countertops. With Invisibond, you will never have to return to a job site to solve adhesive problems. It lays down a thin, tight bond line.

### Product Features

- Strongest adhesive bond available
- Holds up through rigorous machining
- Water clear, polishable
- Will not shrink
- Ideal for high humidity or freeze-thaw conditions
- More economical than Edge System with better UV resistance and slightly thinner
- Gallon size comes in easy to pour bottles
- Can be tinted using Touchstone<sup>™</sup> Liquid Tints
- Can be dispensed using Easy Mix Dispenser



### Applications

- Countertop fabrication
- Stone lamination
- Structural bonding

### Specifications

Product Type:	Epoxy
Viscosity:	Flowing
Mix Ratio:	2:1
Set Time:	2 Hours
Cure Time:	24 Hours
Pot Life:	15 Minutes
Application Conditions:	Interior, Exterior; Horizontal
Recommended Application Temp:	75°F (24°C)
Coverage:	Per Gallon: 50mils (1/16")30ft <sup>2</sup> or 231cu. inches
Available Colors:	Clear
Sizes:	Quart (946ml), Gallon (3,785ml), 5 Gallon Pail (18,927ml)
Other:	NA



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Can be used with  
Easy Mix Dispenser

## Surface Preparation & Use

Use gloves, wear eye protection, and avoid skin contact. When grinding cured joints, wear a dust mask. Substrate to be bonded must be completely dry and dust free. Mix only the amount of material which can be used in 10 minutes (or less, if Accelerator is used). Avoid stressing joint before complete cure of material. Mask areas which must be kept free of material. Clean tools of uncured material using toluene or xylene. Use caution, these solvents are flammable and ensure local ventilation. Remove cured material mechanically.

## Mixing Instructions

Minimum material and substrate temperature should be at or above 55°F (13°C). Combine the two ingredients at the following mix ratio: Two parts of A to one Part B.



## Temperature Dependency

The adhesive, substrate, aggregate, and environment's temperature will affect the working properties of the material. Lower temperatures will prolong cure, higher temperatures will shorten cure time. Every 15°F (-9°C) results in doubling the speed of cure. Therefore, at 90°F (32°C) set time is cut in half, at 60°F (16°C) the set time is doubled. Do not use on substrate at a temperature below 55°F (13°C).

## Shelf Life & Storage

If Invisibond A & B is exposed to below room temperature conditions for extended periods of time, it may crystallize, giving it a stiff, grainy, consistency. The product must be reconstituted before use by heating it up to 150°F degrees. Stir until it becomes a homogeneous liquid.

## Limitations

Use on dry stone. Use on oil, grease, and coating-free substrates. Minimal yellowing and chalking will occur when exposed to ultra-violet light.

## Safety

Before storing, mixing, or applying this product, read and understand all the product's Safety Data Sheets. For a copy of the SDS, contact Bonstone Materials at (800) 425-2214.

## Warranty

This product's warranty is limited to replacement of defective material and freight charges to destination only. Bonstone Materials is not responsible for consequential damages.

Testing Data

<u>Strengths</u>	<u>Results</u>	<u>Test Method</u>
Tensile	3,058 psi	ASTM D-638
Compressive	4,736 psi (Stone Failure)	ASTM D-905-89
Flexural	374,423 psi	ASTM D-790
<u>Modulus</u>		
Tensile	573,157 psi	ASTM D-638
Compressive	Not available	Not available
Flexural	374,423 psi	ASTM D-790
Elongation: Tensile: Elongation at break	0.0063	ASTM D-638
Shore D	80	ASTM D-1706
Heat Distortion Temp	135°F (57°C)	ASTM D-648
Shear Strength	Not available	Not available
24 Hour Water Absorption	Not available	Not available
Other	NA	



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