

TECHNICAL DATA SHEET

FILE UNDER DIVISION 4

Compbond 638 A/B

DESCRIPTION: A two-component, exterior grade, clear epoxy adhesive.
Two hour set, flowing liquid.

APPLICATIONS:

- Honeycomb stone lamination adhesive
- Reinforcement of backlit stone panels
- Laminating stone to other construction materials
- Excellent for rodding countertops
- Stone patching, mending, repairing, and bonding
- Product Information

Use on dry stone. Use on oil, grease, and coating free stone. Minimal yellowing and chalking will occur when exposed to ultra-violet light. Color: Clear product - use Touchstone tint for tinting

INSTALLATION: **General Instructions:** If using cartridges, additional directions are available.
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 epoxy which can be used in 10 minutes. Avoid stressing joint before complete cure of epoxy. Mask areas which must be kept free of epoxy. Clean tools with uncured epoxy using toluene or xylene. Use caution, these solvents are flammable and ensure local ventilation. Remove cured epoxy mechanically.
Mixing instructions: All materials should be at or above 55°F. Combine the two ingredients at the following volume ratio: Two parts of A to one part B.
Temperature dependency: Temperature will affect the working properties of the material. Every 15°F results in doubling the speed of cure. Therefore, at 90°F set time is cut in half, at 60°F the set time is doubled. Do not use on substrate at a temperature below 55°F.
Coverage: Approximately 30 square feet per gallon when applied at 50 mils (1/16th of an inch). 231 cubic inches per gallon.

AVAILABILITY: **Packaging and storage:** Compbond 638 is available in quarts, gallons, 5 gallon and cartridges. Thickening powders are available for increasing viscosity.
*** If Compbond 638 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 to 150°F degrees. Stir until it becomes a homogeneous liquid.*

WARRANTY: This product's warranty is limited to replacement of defective material and freight charges to destination only. Chemical Concepts. is not responsible for consequential damages.

MAINTENANCE: Designed for application in areas inaccessible to maintenance procedures.

4. **TECHNICAL DATA**

Compbond 638

Mixed Properties

Values

Test Methods

Mix Ratio: 2 parts A to 1 part B by volume

Pot Life at 75°F: 30 minutes

Cured Properties

Initial set time at 75°F: 2 hours
Full cure time at 75°F: within 24 hours

STRENGTHS

Tensile:	3058 psi	ASTM D-638
Flexural:	8713 psi	ASTM D-790
Shear -academy black granite (Shear by compressive loading)	4736 psi (stone failure)	ASTM D-905-89

MODULUS

Tensile:	573,157 psi	ASTM D-638
Flexural:	psi 374,423	ASTM D-790

ELONGATION

Tensile: Elongation at break	0.63%	ASTM D-638
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Shore D Hardness:	80	ASTM D-1706
Heat Distortion Temperature:	135°F	ASTM D-648



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