

## Technical Data Sheet

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**Properties:**

AKEMI® CRACK BOND Waterclear is a liquid, low viscous 2-component product based on UV-stabilized, unsaturated polyester resins dissolved in styrene. The product is characterized by the following qualities:

- low viscosity, therefore very good penetration
- no colour of its own, therefore suited for light and white, mainly transparent-crystalline natural stones
- due to slow hardening and low tensions bigger defects can be filled
- easily polishable
- very good adhesion on natural stones
- resistant to water, petrol and mineral oils

**Application Area:**

AKEMI® CRACK BOND Waterclear is mainly used in stone processing industry for strengthening of larger areas of light or white, transparent-crystalline natural stones e.g. Thassos, Carrara, Onyx, Palisandro, Estremoz. Due to the low viscosity and colourless-transparent appearance, waterclear bondings can be made which maintain the stereoscopic structure of the stone. By adding little quantities of AKEMI® Polyester Colouring Pastes a similar look like natural stone can be achieved.

**Instructions for Use:**

1. The surface to be treated must be clean, completely dry and roughened.
2. Colouring is possible by adding AKEMI® Polyester Colouring Pastes up to max 5 %.
3. Add 1 to 2 g of hardener B liquid (35 - 70 drops) to 100 g of CRACK BOND Waterclear.
4. Mix both components thoroughly. The mixture can be worked for about 13 to 28 minutes (20°C/68°F).
5. After approx. 12 hours (20°C/68°F) the hardened CRACK BOND Waterclear can be further processed (grinding and polishing).
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.
- The product only hardens with hardener B liquid.
- Hardener portions higher than 2 % cause more or less intensive discolouring.
- Hardener portions less than 1 % and low temperatures (below 5°C/41°F) considerably delay hardening.
- Permanent influence of heat (> 50°C/122°F) causes discolouring.
- Moderate adhesion on fresh, alkaline building materials (e.g. concrete, concrete bricks).
- Once hardened, CRACK BOND Waterclear 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 filler is generally recognized as not injurious to health.

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**Technical Data Sheet**

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<b>Technical Data:</b>	Colour:	colourless transparent
	Density:	approx. 1.10 g/cm <sup>3</sup>
	Working time /min.	
	a) at 20°C	
	1% of hardener B:	23 – 28
	1.5% of hardener B:	18 – 22
	2% of hardener B:	13 – 17
	b) with 1.5% of hardener B	
	at 10°C:	35 – 45
	at 20°C:	18 – 22
	at 30°C:	9 – 11
<b>Storage:</b>	1 year approx. if stored in cool place free from frost in its tightly closed original container.	
<b>Health &amp; Safety:</b>	Read Material Safety Data Sheet before handling or using this product.	
<b>Important Notice:</b>	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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