

## Technical Data & Instruction Sheet

### PRODUCT BENEFITS

Gloss enhancer

Solvent free epoxy system

Excellent product to fill pinholes & cracks on coloured marble

Resistant to chemicals

Easy polishing during stone processing

### RECOMMENDED SURFACES

Granite, Marble and other natural stones

### MIXING RATIO

100 pbw Resin and 25 pbw Hardener

### COVERAGE

100- 250 Sq. ft. per kg depending on the porosity of surface

### TECHNICAL INFORMATION

Form: Liquid

Pot Life: 60 minutes

Curing Time (Touch Dry):

25°C-50°C: 3-6 Hours

15°C-25°C: 6-10 Hours

5°C-15°C: 10-24 Hours

Curing Time (Full Cure): 7 Days

Adhesion Strength: > 2 MPa (Pull off)

Shelf Life: 2 years

### DESCRIPTION

RachTR 1025 IN is solvent free, two components, low viscosity epoxy system for filling cracks and pinholes of colored natural stones in stone processing industries.

### DIRECTIONS

Read entire label before using. Use only as directed. Always test on a small area with a 24 hours curing to check desired results. Make sure surface is clean and free of waxes, dirt and coatings.

1025 IN should not be applied to wet surfaces. Ensure proper and thorough mixing of resin

### METHOD OF APPLICATION

1. The substrate must be thoroughly cleaned and should free of moisture, dirt, oil and grease etc. Use Gloves during application. Follow manufacturer's instructions of for using gloves.
2. Mask any surface not intended to be treated.
3. A layer of 1025 should be applied on after applying initial grit (cutting) the substrate for Stones.
4. Mix part A and B homogeneously and apply it on the substrate. If pinholes reappear, apply another coat.
5. If excess epoxy is not wiped off, residue appears, mechanically remove the cured epoxy.
6. A full cure of a single coat is achieved after 24 hours.
7. Clean tools with appropriate solvent immediately after application and allow them dry in a well ventilated area.
8. After 12-20 hours, the treated part can be further processed and transported.
9. Hardener portion more than 20% will reduce adhesion and deteriorate surface drying.
10. Hardener portion less than 10% will delay the hardening and can affect the desired quality.
11. The low temperatures can significantly affect the curing process.

### STORAGE AND HANDLING INSTRUCTIONS

1. May be harmful if swallowed. May cause skin, eye and respiratory irritation.
2. Use in a well ventilated area.
3. Do not ingest.
4. Do not freeze or store above 40° C.
5. Do not mix with other chemicals.

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