

Technical Data Sheet

Page 1 of 2

- Properties:** AKEPOX® 1099 Invisible is a very fluid, two-component, epoxy resin system with a modified amine hardener which is used for closing cracks and pores. The product is characterized by the following properties:
- fast hardening
 - has good penetrative properties on account of its low viscosity
 - clear transparent
 - generally no colour intensification, therefore excellently suited for light stones
 - free of solvents
 - weather-resistant
 - excellent grinding and polishing properties
 - increases the firmness and improves the quality of natural stone surfaces
 - increases the yield and the productivity
 - classification according to the Berufsgenossenschaft der Bauwirtschaft (Accident Prevention and Insurance Association of the German Building Industry): GISCODE: RE 01
- Application Area:** AKEPOX® 1099 Invisible is mainly used in the stone-working industry for strengthening porous and fissured natural stone slabs, concrete and concrete ashlar and improving their surface qualities. In combination with spun glass fabrics it is also used for strengthening brittle natural stone slabs. The hardened product shows a tendency to yellow if exposed to ultraviolet light or to warmth.
- Instructions for Use:**
1. The stone slabs which are to be treated must be pre-calibrated according to their nominal thickness and must be clean and dry.
 2. Four parts by weight of Component A are to be thoroughly mixed with one part by weight of Component B (e.g. 100 g and 25 g) until the mixture is free of streaks. Alternatively, 7.5 parts by volume of Component A are to be mixed with 2 parts by volume of Component B (e.g. 150 ml and 40 ml); Large amounts can be worked more easily with a dosing and mixing apparatus for AKEPOX® products.
 3. AKEPOX® colouring concentrates or Stone Ink can be used for colouring if required (max. 5%).
 4. The mixture remains workable for approx. 4 - 8 minutes at 20°C and is applied to the whole surface with a fine-toothed spreader; apply more than once in the event of larger fissures or areas of greater absorption. Cracks which are running completely through the stone are to be closed on the back before application of AKEPOX® 1004.
 5. The surfaces can be ground and polished after approx. 6 hours at room temperature.
 6. The contact pressure of the grinding and polishing segments should be 1 to 1.5 bar at the most.
 7. Tools can be cleaned with AKEMI® Universal Dilution.
 8. Warmth accelerates and cold retards the hardening process.
 9. Empty the container fully before disposing of it.
- Special Notes:**
- The optimal mechanical and chemical properties can only be attained by adhering to the exact mixing proportions; excess adhesive or hardener has the effect of a plasticizer.

TDS 12.15

Technical Data Sheet

Page 2 of 2

- The colour of the treated surfaces may deepen to a greater or lesser extent depending upon the type of stone involved; a deepening of colour may be more noticeable in the fissured area. Therefore we recommend to test on a sample piece.
- Use separate vessels when component A and B are being extracted from their containers.
- The resin is no longer to be used if it has already thickened or is jellying.
- The best surfaces can only be achieved by using high-quality grinding and polishing segments.
- The product is not to be used at temperatures below 15°C because it will not sufficiently harden.
- The hardened resin can no longer be removed by means of solvents. This can only be achieved mechanically or by applying higher temperatures (> 200°C).
- If the resin has been correctly worked it presents no hazard to health when the hardening process is completed.

Technical Data:

Colour: light transparent
Density: comp. A: 1.12 g/cm³
comp. B: 1.04 g/cm³
Consumption: approx. 100 – 200 g/m²

Working time:

a) at varying temperatures and
a quantity of 125 g: 15°C: 6 – 8 minutes
20°C: 4 – 6 minutes
30°C: 2 – 3 minutes

b) at 20°C and varying amounts: 25 g: 5 – 8 minutes
125 g: 4 - 6 minutes

Hardening times for stone slabs which
have been pre-warmed to the given
temperatures: 20°C: 6 hours
30°C: 3 hours

Storage:

2 years approx. under cool conditions in the firmly closed original container.

Health & Safety:

Read Material Safety Data Sheet before handling or using this product.

Important Notice:

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.

TDS 12.15