

## SECTION 1: Identification of the substance/mixture and of the company/ undertaking

### 1.1 Product identifier: MARMO MASTIC GEL / MARMO MASTIC CLEAR

Manufacturer / Importer / Supplier:

**ANAV INDUSTRIES**

Address: Khewat No. 1358/1151, Khatoni No.  
1461, Main NH-9, Near Toll Plaza, Village  
Rohad, Distt. Jhajjar, Haryana-124501

Marketed By:

**Marmo Solutions Pvt. Ltd.**

WHS 1/18, 2nd Floor, Kirti Nagar, New Delhi-110015

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### Marmomastic Clear

1.1.Marmo Solutions “Marmo Mastic Clear” is highly liquid 2-component products based on unsaturated polyester resins dissolved in styrene. The products are distinguished by the following qualities;

### 1.2.Characteristics:

- (a) Easy dosing and mixing by using the cartridge system
- (b) Wide field of application due to different consistencies.
- (c) Resistant to water, petrol and mineral oils.
- (d) Fast hardening (20- 60 minutes)
- (e) Very good adhesion on natural stones also at higher temperatures (60- 70°C; in case of low exposure to stain : 100 - 110°C)
- (f) Excellently polishing

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**1.3. Application field:** Marmo Solutions “Marmo Mastic Clear” are mainly used in stone processing industry for bonding natural stones, reinforcement with glass fibre products (laminating) and forming of rock substitutes with crushed rocks and sand.

#### 1.4. Special Properties:

(a) Transparent Marmo Mastic Clear Moderately viscous consistency

#### 1.5. Usage Instruction:

##### If Product in tins

- (a) The surface to be treated must be clean, completely dry and slightly roughened
- (b) Colouring is possible by adding Marmo Solutions “Marmotint” up to max 5% Marmo Mastic Clear.
- (c) Add 1 to 4 g of white hardener paste to 100 g of filler (4 to 5 cm of paste pressed out of the screw tube correspond to 1 g)
- (d) Mix both components thoroughly. The mixture can be worked for about 3 to 16 minutes (20 °C), depending on the product.
- (e) After 20 – 60 minutes (depending on the product) the treated parts can be further processed.
- (f) The hardening process is accelerated by heat and delayed by cold.
- (g) Tools can be cleaned by solvent.

##### If Product in cartridge system

- Without mixing nozzle Dosing apparatus only
- With mixing nozzle Dosing and mixing apparatus at the same time
- (a) Thoroughly clean, dry and slightly roughen surfaces to be bonded
- (b) Remove the clasp from the cartridge and put the cartridge in the gun; work the grip until material emerges from both openings; then eventually screw up the mixing nozzle.
- (c) For tinting the Marmo Mastic Marmo Solutions “Marmotint” for polyester products may be added (up to 5%)
- (d) Both components must be thoroughly mixed when working without mixing nozzle.
- (e) The mixture remains workable for approx 5- 7 mins (20°C/68° F). After 30-90 min (20°C/68°F) work can continue on the cured Marmo mastic (grinding, milling, drilling).
- (f) The hardening process is accelerated by heat and delayed by cold
- (g) Tools can be cleaned with solvent

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**1.6. Notes:**

- (a) Hardener portions higher than 4% reduce adhesion and deteriorate surface drying
- (b) Hardener portions less than 1% and low temperatures (under 5°C) considerably delay hardening.
- (c) An adhesive which is already thickened or just gelling should not be used anymore
- (d) The bonding layers should be as thin as possible (< 1mm) due to shrinkage (Approx 5-8%) caused by the high reactivity of the filler and development of heat during the hardening process.
- (e) Limited durability of bonding which are frequently exposed to humidity and frost.
- (f) Moderate adhesion on fresh, alkaline building materials (e.g. concrete, concrete bricks)
- (g) The hardened filler has a slight tendency to yellowing.
- (h) Once hardened, the filler can be longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C)
- (i) Being worked properly, the hardened filler is generally recognized as not injurious to health.
- (j) It is recommended to remove the mixing nozzle after use and close with the original clasp. Before screw up new mixing nozzle make sure if material emerges from both openings.

**1.7. For safety measure see EC safety data sheet:**

**1.1. Technical Data:**

**1.8.1 Colour:** Clear and white transparent

**1.8.2 Density:** 1.05 – 1.15 g/cm<sup>3</sup>

**1.8.3 Working time / min.:**

(a) At 20°C	Marmo Mastic Clear	Marmo Mastic Gel
<b>1% of hardener</b>	<b>12 – 14</b>	<b>8 – 10</b>
<b>2% of hardener</b>	<b>6 – 8</b>	<b>5 – 6</b>
<b>3% of hardener</b>	<b>5 – 6</b>	<b>4 – 5</b>
<b>4% of hardener</b>	<b>4 – 5</b>	<b>3 – 4</b>

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**1.8.4. Cartridge:**

(b)With 2% of hardener:

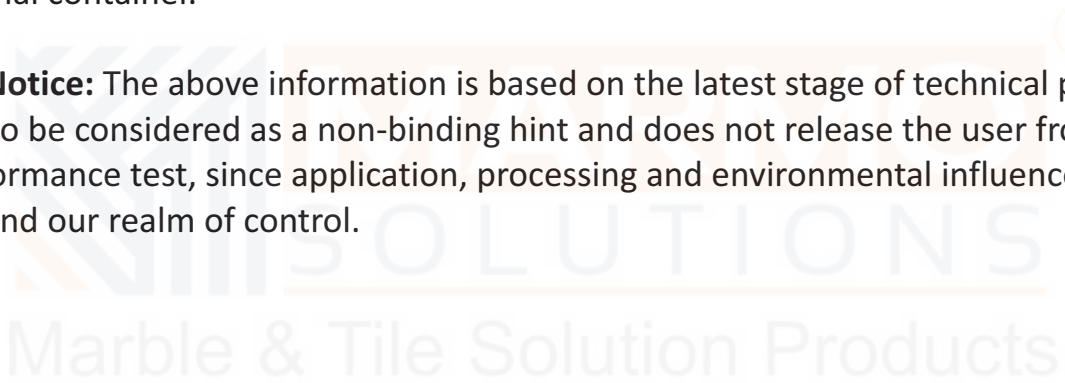
At 10°C	13 – 16	12 – 14
At 20°C	6 – 8	5 – 6
At 30°C	4 – 5	3 – 4

**1.2.Mechanical properties:**

Tensile strength DIN 53455	40 – 50 N/mm <sup>2</sup>
Bending Strength DIN 53452	100 – 110 N/mm <sup>2</sup>

**1.3.Shelf Life:** 1 year approx if stored in cool place free from froat in its tightly closed original container.

**1.4.Notice:** The above information is based on the latest stage of technical progress. It is to be considered as a non-binding hint and does not release the user from a performance test, since application, processing and environmental influence are beyond our realm of control.



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