



TECHNICAL DATA SHEET

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1. DESCRIPTION

Multibond Adhesives are a two-part methacrylate, super flexible, dripless/non-sag, low shrink, low exotherm, ultra violet light stable, non-yellowing hard surfacing adhesive designed for the nearly seamless bonding of Porcelain, sintered stone, glass, engineered stone, marble and quartz, and natural stone products. Combined at a ratio of 10:1 (10 parts resin, one part activator), Multibond adhesives have a working time of 10 to 15 minutes, with a 5 to 10 minute De-Roping Time, and achieve nearly 90 percent of its ultimate strength in 45 to 60 minutes at room temperature curing. Multibond adhesives offer a combination of high strength, stiffness, and toughness as well as the ability to bond very strongly to a wide variety of hard surface or inorganic materials. When combined with the proper use of GlueBoss's proprietary Bond=Bond surface cleaner/activator, Multibond adhesives provide high strength bonds to virtually any stone, engineered stone or quartz or granite products, including porcelain, sintered stone, and glass. With the use of Bond=Bond, stone fabricators can bond successfully to wet stone, although bonding underwater is not permitted or recommended. Multibond adhesives permit the seasoned fabricator the opportunity to apply the adhesive to vertical surfaces, as well as horizontal surfaces, without dripping, and upon gelation, give the fabricator an extended window (5 to 10 minutes) to de-rope, or trim with a single bladed straight edge razor blade, the excess from the stone slab without ripping the adhesive out of the joint, nor damaging the surface of the stone. Additionally, since the product is supplied in cartridges, unlike other cartridge adhesives in the market, wherein the resin (large side) is pigmented, with Multibond, the activator (small side) is pigmented. For the fabricator, this means that when he sees color, he knows that the product is catalyzed, and will get dry/react/get hard 100% of the time.

Company Identification: Tenax USA

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2. CHARACTERISTICS:

Room Temperature Cure

- Working Time
- De-Rope Time
- Fixture Time
- Routable
- Operating Temp.
- Gap Filling
- Mixed Density
- Flash Point

Properties

10 to 15 minutes
5 to 10 minutes
20 to 30 minutes
45 to 60 minutes
65°F to 85°F (18°C to 30°C)
.250 inches – 5 mils (thousands) for countertops
8.6 lbs/gal (.98 g/cc)
51°F (11°C) – See SDS for more safety information

3. CHEMICAL RESISTANCE:

Excellent Resistance to:

- Hydrocarbons
- Acids and Bases
- Vinegar
- Wine and Condiments
- Most Household Foods

Susceptible to:

Polar Solvents
Super Strong Acids and Bases



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4. PHYSICAL PROPERTIES:

Uncured:	Adhesive	Activator
Viscosity(cps)	45,000 – 75,000	15,000 – 25,000
Color	Purple Tint Clear	Various Colors
Density (lbs/gal)	8.4	9.0
Mix Ratio (wt. or vol.)	10.0	1.0
Mixer Recommendation	Cartridge (50ml): Cartridge (250ml): Cartridge (500ml):	MBHX 05-16T –Sulzer 16 element MFQX 08-24 –Sulzer 24 element MFQX 08-24 –Sulzer 24 element

5. MECHANICAL PROPERTIES:

Tensile Strength (ASTM D638)	Substrate	Results	Failure Type
Strength, psi	Quartz	3,000 - 3,500	Substrate
Strength, psi	Granite	2,500 - 3,000	Substrate

6. HANDLING AND APPLICATION:

Multibond adhesive (Part A) and activator (Part B) are flammable. Contents include Methacrylate ester and acids, and peroxide. Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of the reach of children. Keep away from heat, sparks, and open flames. Do not smoke cigarettes or anything else while handling or near the product. Refer to the Multibond Material Safety Data Sheet for more complete safety instruction. To assure maximum bond strength, surfaces must be mated together within the specified working time, and all clamps affixed within that time. Use sufficient material to ensure that the joint is completely filled when parts are mated and clamped. Avoid over clamping parts, which may cause a dry joint or a joint starved of adhesive. All adhesive application, part positioning, fixturing, and clamping should occur before the working time of the adhesive has expired. After the indicated working time, parts must remain undisturbed until the fixture time is completed. Sheet, adhesive, and shop temperature can have a significant effect on the work and fixture time of the adhesive. Application of Multibond adhesive at temperatures between 65°F and 85°F (18°C and 30°C) will ensure proper cure. Temperatures below 65°F (18°C) will slow cure and fixture speed. Multibond adhesives will still react, but will take longer. Temperatures above 85°F (18°C and 30°C) will increase cure and fixture speeds, and there's a risk that the adhesive will be hardened or too thick to pull a tight seam. The viscosities of Multibond adhesives are affected by temperature.

7. HANDLING AND STORAGE

The shelf life of Multibond is one (1) year from the date of manufacture based upon continuous storage at room temperature (77°F or 25°C). Storage of Multibond in refrigerated compartments will extend the shelf life even more. Do not store Multibond or any other adhesives in a refrigerator which has food or lunch products in them. Be sure to bring Multibond adhesives to room temperature for 24 hours before use, otherwise longer cure and fixture times may be expected. Long-term storage at temperatures above room temperature will shorten the shelf life of Multibond adhesives, especially the activity of the catalyst. Storage at temperatures above 100°F or 38°C could shorten the shelf life to less than one month. Multibond adhesives contain no water, so freezing of the adhesive for short periods is permissible, but is not encouraged.

8. ADDITIONAL INFORMATION

NOTE: All information on this data sheet is based upon laboratory testing and is not intended for design purposes. Tenax USA makes no representations or warranties of any kind concerning this data. Due to the variance of storage, handling, and application of these materials, Tenax USA cannot accept liability for results obtained. Contact Tenax USA for more information

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