

TECHNICAL DATA SHEET (TDS)

GOLDEN GEL

Transparent Stone Adhesive & Filler

1. CHARACTERISTICS

GOLDEN GEL is a two-component transparent polyester adhesive and filler based on unsaturated polyester resin in styrene with selected mineral fillers. It is designed for bonding, filling and repair of natural and artificial stone. It offers easy application, strong adhesion and fast curing, making it suitable for professional stone fabrication.

2. FIELD OF APPLICATION

GOLDEN GEL is mainly intended for use in the stone processing and fabrication industry for bonding, filling and repairing natural and artificial stones.

3. INSTRUCTIONS FOR USE

SURFACE PREPARATION

- Surface must be clean, dry and slightly roughened
- Remove dust, grease and loose particles
- Ensure no moisture is present
- Colour pastes may be added up to 5% if required

MIXING

- Add 1–4 g hardener per 100 g of GOLDEN GEL
- Mix thoroughly until uniform
- Use within working time
- Prepare only the amount needed

APPLICATION

- Apply with spatula or suitable tool
- Keep bonding layers thin
- Apply in layers for deep repairs
- Allow full curing before machining or polishing
- Clean tools immediately after use

4. SPECIAL HINTS

- Wear suitable protective gloves during handling and application.
- Do not exceed 4% hardener, as excess hardener may reduce adhesion and affect surface drying.
- Use at least 1% hardener; lower dosage may significantly delay curing, especially below 5°C.
- Keep bonding layers as thin as possible, preferably below 2 mm, to minimize shrinkage.
- Curing may cause approximately 2–8% shrinkage due to the resin reaction and heat development.
- For large holes, cavities, corners and edges, use the minimum practical amount of hardener.

- Avoid applications where the bonded area will be continuously exposed to moisture, humidity or frost.
- Slight yellowing may occur during prolonged outdoor exposure.
- Adhesion may be limited on fresh, highly alkaline substrates such as concrete and concrete bricks.
- Once fully cured, the product cannot normally be removed with solvents; removal is possible mechanically or at temperatures above 200°C.
- When properly handled and fully cured, the product is generally safe under normal intended use.

5. TECHNICAL INFORMATION

DENSITY

GOLDEN GEL : 1.50–1.70 g/cc

WORKING TIME AT 20°C

1% Hardener	: 16–20 min
2% Hardener	: 10–12 min
3% Hardener	: 6–8 min
4% Hardener	: 3–5 min

Working time values are typical and may vary according to temperature, mixing quantity, hardener dosage and application conditions.

6. MECHANICAL PROPERTIES

Tensile Strength	: 55–65 Mpa
Bending Strength	: 75–85 Mpa

7. SHELF LIFE

Up to 1 year in original sealed packaging under cool, dry conditions.

8. NOTE

Values are typical and may vary depending on conditions and application. A preliminary test is recommended before use.

Manufactured For & Marketed By:

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