

Riverstone® 33

Low-viscous, impact resistant synthetic resin
To be used as stone adhesive

Application: Due to its low viscosity, **Riverstone® 33** is suitable for producing a ductile and hard 2k stone adhesive.

Properties: **Riverstone® 33** adhesive is appropriate for natural stone artificial stone tiles in combination with glass and polyester fibres. They are wear-resistant and non-ageing. Ensure an exact compliance of the mix in order to achieve ideal wear rates.

Features:	Chemical basis	Methyl methacrylate resin with TPU
	Delivery form	bluish, viscous, slightly cloudy liquid
	Odour	ester-like
	Viscosity	40 ± 3 s (23°C, DIN Becher, 4mm)
	Density	1 g/cm ³ (20°C)
	Flashpoint	+ 10°C (MMA, DIN 51755)
	Boiling point	+100 °C
	VbF	AI
	Processing time	20 - 25 min. with 1 % Riverstone H
	Curing	e.g. with 2 % curing takes place at 23 °C in 17 - 23 min.
	Cleaning of tools	Riverstone® cleaner 12
	Application	elastic adhesive for natural and artificial stone
	Storage	6 months max – dry and cool (20°C max)

Suggested formulation:

Adhesive is being produced with Riverstone® 33 resin and Riverstone® filler S 17 immediately before application.

ca.- indications

80.0 PBW	Rivestone® 33
20.0 PBW	Riverstone® filler S 17

Attention! Depending on application, the resin fraction may vary. Thus we recommend testing the resin fraction self-dependently!

Premix Riverstone® 33 and filler S 17 for about 2 min. in a suitable container and then add 1-3% Riverstone H. The mixing time of the adhesive with double-agitator takes about 3 minutes. Process the adhesive with a truing device. According to this formulation, you can also fill slight wrappings in the substrate. For bonding natural or artificial stone tiles, embed glass or polyester fibre into the wet adhesive. Riverstone® 33 is available clear or in standard RAL colours.

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Pot-and curing-times depending on the temperature:

Temperature(°C)	Hardener(W.-%)*	Pot life (min.)	Curing time (min.)
+ 5	4.0	~ 20	~ 60
+ 10	3.0	~ 25	~ 55
+ 20	2.0	~ 17	~ 35
+ 30	1.5	~ 14	~ 30

*(Quantity of hardener is calculated on the net quantity of the **resin component!**)

Hints:

Continue working only after complete curing of the previous layer!
Remove sticky areas, prime with Riverstone 12 if required.

At temperatures below + 5°C use accelerator 101 additionally (~ 0.5 % at 0°C to 1% at -5°C) while maintaining ~ 4 PBW % Riverstone® H.

Storage:

Methacrylate resins are subject to the handling regulations of highly flammable materials. MMA resins are to be stored cool, protected against direct sunlight, preferably at temperatures of 15-20 °C. During storage paraffin particles may deposit. Thoroughly stir up the material before processing! Mind the advice on our safety data sheets.

Processing:

Please mind regional hints of your local job safety authority and the hazardous substances regulations!

data concerning our products and devices as well as concerning our data and procedures are based on an extensive research work and an application technology experience. We obtain these results, with which we do not take over adhesion going beyond the respective single contract, in word and writing after best knowledge, reserve ourselves we however technical changes in the course of the product development. Beyond that our application technology service stands when desired for large consultation as well as for co-operation with the solution manufacturing and application technology problems for order. That does not relieve the user however to examine our data and recommendations before their use responsible for the own use. That applies - particularly for deliveries to foreign markets - also regarding the keeping of patent rights third as well as for applications and procedures, which are not expressly in writing indicated by us. The case of loss our adhesion is limited to indemnifications of same extent, as they plan our general terms of delivery and sales with lack of quality.