

TERRAZZCO® Clam-Tite Adhesive 680

DESCRIPTION

TERRAZZCO® Clam-Tite Adhesive 680 is 100% solid (VOC free), two-component epoxy resin system cured with an amine hardener. This eco-friendly adhesive may be used for bonding metal, wood, glass, plastic, ceramic and terrazzo tile, and terrazzo precast products. TERRAZZCO® Clam-Tite Adhesive 680 may be thickened using thickening powder to provide maximum resistance against slippage and movement during the curing process.

ADVANTAGES

- Utilizes renewable resource components
- 100% solid VOC free for a healthier environment
- Contributes to higher LEED® credits compared to other epoxy adhesive systems on the market
- Manufactured and supplied from the Southeast United States
- Quick curing and finishing time

CONSIDERATIONS

- Substrate temperature must be a minimum of 55°F before, during and 72 hours after installation. The surface temperature of the substrate must be 5° above the dew point to ensure proper curing.
- Substrate must be free of dirt, waxes, curing agents, and other foreign materials. Concrete surface must be prepared by shot blasting or by grinding. Metal should be abraded and cleaned to remove any corrosion or mill scale.
- Adhesive is not a substitute for waterproofing membranes. When a waterproofing membrane is required consult with the installer or a TERRAZZCO® technical representative.
- Do not cover joints with adhesive. All joints must be properly addressed prior to installing floor system.
- Materials should be allowed to acclimate to controlled application environmental conditions prior to being mixed
- Material is not designed to be used as a moisture vapor barrier

TYPICAL USES

TERRAZZCO® Clam-Tite Adhesive 680 is perfect for almost any surface where a highly durable, highly adaptable, adhesive is desired. TERRAZZCO® Clam-Tite Adhesive 680 may be used in heavy duty commercial applications such as kitchens, shower areas, and restrooms for bonding metal, wood, glass, ceramic and terrazzo tiles, and terrazzo precast products.

APPLICATION

Surface Preparation: All work should be performed by trained and experienced contractors or maintenance personnel. Substrate surface and air temperature must be a minimum of 55° F during installation and cure. Substrate surface temperature must be 5° above the dew point to ensure proper curing of the adhesive. Consult installer for job specific slab conditions. Concrete surface must be free of dirt, waxes, curing agents, or any other foreign material. The concrete surface should be prepared by grinding or shot blasting and repairs to the concrete must be made prior to applying this product. An active vapor barrier under the concrete slab is required.

Concrete surfaces must be tested for relative humidity according to ASTM-F-2170 (Relative Humidity in Concrete Floor Slabs using in situ probes) Measurements must be



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made using Wagner Electronics Rapid RH® 4.0 Smart Sensor and Rapid RH® Easy Reader. If measurement readings 80% or higher are obtained a waterproofing membrane system must be applied to the concrete prior to adhesive application. Consult with the installer or a TERRAZZCO® technical representative regarding waterproofing membrane systems. A record sheet should be filled out including the ambient temperature and humidity during testing along with the substrate temperature and relative humidity. The test must be conducted at end user environmental conditions. Any deviation from this procedure will result in the warranty being voided.

WORKING DATA

Temperature will affect the working properties of TERRAZZCO® Clam-Tite adhesive 680. Cooler temperatures will slow down the cure rate and warmer temperatures will speed up cure rate. Data shown below is for temperature and humidity controlled conditions at 75°F.

Working (Pot) Life	40 - 50 min. @ 75°F
Full Set Time	18 - 24 hours @ 75°F
Full Cure & Maximum Performance	5 -10 days

MATERIALS NEEDED

- Mineral spirits or isopropyl alcohol for cleaning equipment
- Mixing drill equipped with jiffy blade

MIXING & INSTALLATION

Mix five (5) parts of TERRAZZCO® Clam-Tite Adhesive 680 resin part A with one (1) part of TERRAZZCO® Clam-Tite Adhesive 680 hardener part B by volume with a slow speed drill equipped with jiffy blade for three to four minutes to ensure that the mixture is completely blended. If a thicker paste is desired fumed silica may be added to increase thickness of the product.

Apply TERRAZZCO® Clam-Tite adhesive 680 with the proper size notched trowel to achieve desired thickness.

CLEAN UP

Clean skin with soap and water. Tools and equipment should be cleaned with isopropyl alcohol or mineral spirits before the epoxy hardens. Failure to do so will cause the epoxy system to harden on the tools and equipment making it very difficult to remove. Consult the SDS for safety and health precautions.

SAFETY

Refer to SDS prior to use. Federal, state and local guidelines must be followed during the handling and installation of these materials. Any excess material shall be disposed of according to applicable federal, state, and local codes.

MATERIAL STORAGE

It is suggested that materials are stored in a temperature and humidity controlled environment. If this is not possible materials should be allowed to acclimate to controlled environmental conditions of application. Keep resins and hardeners separated from each other until ready for use. Materials should be kept away from sources of ignition. Materials should be stored in their original unopened container. Epoxy resin does not have a shelf life and hardener has 1 year shelf life when stored in the above described manner.

PACKAGING

TERRAZZCO® Clam-Tite adhesive 680 resin part A is packaged in 5 gallon plastic pails and hardener part B is packaged in 1 gallon cans.

TECHNICAL SERVICE

TERRAZZCO® authorized representatives provide services and consultations on material selection, specification, troubleshooting, and other information on the proper repair, care and protection of concrete surfaces. TERRAZZCO® authorized representatives are available to assist customers at any time. For more information on TERRAZZCO® products, contact the manufacturer and distributor, Concord Terrazzo Inc. at (704) 921-4928.

WARRANTY: TERRAZZCO® products are warranted for a period of one (1) year. Warranty provides that the product will be free of manufacturing defects and will be in conformity with published specifications when handled, stored, mixed and applied in accordance with recommendations of TERRAZZCO® literature. If any product fails to meet this warranty, the liability of manufacturer will be limited to replacement of any non-conforming material if notice of such non-conformity is given to manufacturer within (1) one year of delivery of materials. Manufacturer may in its discretion refund the price received by them in lieu of replacing the material. No customer or distributor of TERRAZZCO® products is authorized to change or modify the published specifications of this warranty in any way. No one is authorized to make oral warranties on behalf of manufacturer. In order to obtain replacement or refund the customer must provide written notice containing full details of the non-conformity. Manufacturer reserves the right to inspect the non-conforming material prior to replacement. EXCEPT FOR THE EXPRESSED WARRANTY STATED ABOVE, THERE ARE NO OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING WITHOUT LIMITATION, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE. MANUFACTURER OBLIGATION SHALL NOT EXTEND BEYOND THE OBLIGATIONS EXPRESSLY UNDERTAKEN ABOVE AND MANUFACTURER SHALL HAVE NO LIABILITY OR RESPONSIBILITY TO THE PURCHASER OR ANY THIRD PARTY FOR ANY LOSS, COST, EXPENSE, DAMAGE OR LIABILITY, WHETHER DIRECT OR INDIRECT, OR FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES. TERRAZZCO'S WARRANTY IS VOIDED IF PAYMENT FOR PRODUCT IS NOT RECEIVED IN FULL. LEED® is a registered trademark of the Green Building Council.

MANUFACTURER AND DISTRIBUTOR



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