

CS 2725 Epoxy Bonding Compound

Chem Seal

Types I & II

Technical Bulletin
December 2010

PRODUCT DESCRIPTION

**Qualified DOD-C-24176 Type I and II
Approved by the American Bureau of Shipping**

CS 2725 fairing and bonding compound is designed for high adhesion to steel and Aluminium serving as the ideal hull and superstructure fairing and smoothing compound. Also CS2725 bonding compound may be used for repairs to concrete. CS2725 is easily mixed and applied. CS2725 is non-shrinking and ideally suited for repairing spalled and cracked areas in concrete, plaster, stucco, stone, slate, wood, and tile. CS2725 may be used as a mortar for ceramic tile, stone work, block, and brick; as an adhesive in fastening decorative masonry, metal clips, wall hangers, identification numbers or letters.

CS 2725 is a non-flow, modified epoxy compound formulated for easy application as an adhesive and bonding material. After cure, the product is hard and tough and exhibits abrasion and shock resistant qualities. CS 2725 is resistant to water, acids, alkali, and hydrocarbons. The tensile and other physical qualities are such that destruction of the bonded material will usually result prior to failure of the CS 2725.

SURFACE PREPERATION

Modified epoxy compounds have excellent adhesion to clean wood, concrete, steel, aluminum, and a variety of other materials. The areas to be adhered to must be clean and free of surface contamination such as cement dust, dirt, grease, wax, bond-breakers, rust, mill scale, and paint. Cement dust, alkali's, efflorescence, dirt and some paints may be removed by washing with a mixture of one part muriatic acid and eight parts water. Acid cleaned surfaces should be neutralized by a basic wash such as household ammonia, then rinsed with fresh water and allowed to dry prior to application of CS 2725. Steel surfaces should be prepared according to Steel Structures Painting Council SP10.

Removal of paint, bond-breakers, wax silicone sealers, curing agents, rust, and mill scale sandblasting or grinding is best. For removal of waxes, use an industrial wax remover that should be followed by a tri-sodium phosphate wash.

MIXING INSTRUCTIONS

Packaging of CS 2725 is in kit form with pre-measured quantities of Part A and Part B. Equal volumes of Parts A and B are thoroughly mixed. A mechanical mixer may

be used with speed below 180 rpm. Assure mixing uniformity by frequently scraping container sides and bottom. Surface wetting and mixing, with or without aggregate, may be facilitated by warming the components to a maximum of 140 deg. F. This substantially reduces the viscosity, work life, and tack free time and will speed up application, if desired. It is not recommended that solvent be used with CS 2725. If used maintain amount below 5%. Never use thinner except where application permits complete exposure to air of one surface of the applied epoxy.

Application and Physical Properties

Application Properties

Color	
Part A	White
Part B	Gray
Consistency	Non-Flow Mastic
Mix Ratio	Equal parts by volume
Application	1 hour @ 75 deg. F
Cure to Solid	6 hours @ 75 Deg. F
Full Cure	24 hours @ 75 Deg. F
Theoretical Coverage	1604 sq. ft. at 1 mil 39.3 Sq. m/l at 25 microns
Shelf Life	1 year

Physical Properties

Adhesive Strength	900 PSI Minimum
Chemical Resistance	Excellent
Salt Water Resistance	Excellent
Cured Finish	Smooth, but non-slip

Reported properties are typical and variations can be expected. For a full description of physical properties and test methods reference DOD-C-24176 Type I and II

APPLICATION

CS 2725 may be easily applied to surface areas with trowel, spatula, or putty blade. Smoothing may be readily accomplished with the application of small amounts of water to the surface of the epoxy to remove the tack.. CS 2725 may be applied to small enclosures such as cracks or cavities by means of a caulking gun, then smooth with a blade, if required. Warming the compound is preferred, instead of thinning, if lower viscosity is required. If CS 2725 should be mixed with aggregate, the above statements will still apply. When aggregate additives are made to increase the non-slip texture of CS 2725, mesh sizes 40-80 are recommended. If aggregate additives are only to increase viscosity and add body, mesh sizes finer than 100 are recommended.

Chem Seal Products

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Work life will be extended if the material is removed from the container after mixing and spread in a thin film on the surface to which it is to be applied.

CLEANING OF EQUIPMENT

CS 9900 solvent is recommended for cleaning tools and equipment. Removal of CS 2725 should be prior to cure. Removal of cured CS 2725 requires mechanical abrading or the use of a commercial epoxy stripper.

STORAGE LIFE

CS 2725 has a storage life of nine months when stored at temperatures below 80°F in the original unopened container.

SAFETY

Before using CS2725, read and understand the Material Safety Data Sheet (MSDS) associated with this material.

**Emergency Contact Chemtrec 800-424-9300
Outside North America 703-527-3887**

**Keep out of the reach of children
For industrial use only**

PACKAGING AVAILABILITY

Pre measured can kits ½ Pint – 1 Gallon

Bulk 5 Gallon pails and 50 Gallon drums

Sectional plastic kits

Contact Flamemaster for specialized packaging

Flamemaster does not warranty the performance of fuel tank sealants or coatings when subjected to fluids or fuels other than those specified by the applicable specification. " It is the responsibility of the user to determine the suitability for use utilizing the information contained in the applicable specification." All recommendations, statements, and technical data contained herein are based on tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and user assumes all risk and liability resulting from his use of the product. Sellers and manufacturers sole responsibility shall be to replace that portion of the product of this manufacturer, which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller. However since much of this information has been received from sources outside of the company, it is provided without any warranty expressed or implied regarding its correctness or suitability for specific situations. The

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conditions of handling, storage, use and disposal are beyond our control and may be beyond our knowledge.