ARDEX 100% Solids Epoxy Adhesive

Use for installing all types of tile, including glass tile, moisture-sensitive marble and agglomerate tiles, resin-backed tile, mosaics and stone

Non-staining on white and light-colored marble

Use where maximum chemical resistance is required

Use for applications in food processing, industrial, institutional and commercial facilities

Ideal for swimming pools, hot tubs and other wet areas; can be submerged after only 7 days

Very easy to clean with only water

High bond strength

Solvent-free, low VOCs

Available in white only

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ARDEX 100% Solids Epoxy Adhesive

Suitable Substrates

Structurally sound, solid substrates that are dry and free of any contaminant that could act as a bond breaker, including:

- Concrete
- Ceramic and Porcelain Tile & Stones
- Exterior Glue Plywood*
- Concrete Masonry
- Brick Masonry
- Non-Water-Soluble Cut-Back Adhesive*
- Cement Mortar Beds
- Gypsum Wallboard*
- Cement Plaster
- Cementitious Terrazzo
- Cement Backer Board**
- Steel
- ARDEX TLT™ Building Panels
- Most glass tiles***

*Interior application only.

**Consult cement backer board manufacturer for specific installation recommendations and to verify acceptability for exterior use.

***Contact the ARDEX Technical Service Department for a full recommendation.

Suitable Applications

- Installing all types of tile, including glass tile, moisture-sensitive marble and agglomerate tiles, resin-backed tile, mosaics and stone
- White and light-colored marble (non-staining)
- Applications requiring maximum chemical resistance
- Food processing, industrial, institutional and commercial facilities
- Swimming pools, hot tubs, showers, bathrooms, dairies, meat packing facilities and breweries
- Hospitals and other installations requiring high standards of hygiene
- Interior and exterior installations; consult the ARDEX Technical Service Department on limitations for exterior installations

Jobsite Conditions

During installation, material and surface temperatures must be between 50°F and 85°F (10°C to 29°C). Do not install below 50°F (10°C) surface and air temperatures.

Store ARDEX 100% Solids Epoxy Adhesive at 70°F (21°C) for 24 hours prior to use.

Temperature will affect working properties. Warm temperatures will speed curing and shorten working time. Cool temperatures will slow curing and require a longer time before traffic.

If installing over in-floor heating systems, turn the heating system off 48 hours before, during and at least 48 hours after installation.

For warm weather installation instructions, contact the ARDEX Technical Service Department.

Step 1: Substrate Preparation (Proper Prep™)

ARDEX 100% Solids Epoxy Adhesive adheres to all dry, common, interior or exterior building substrates that are structurally sound, solid and free from any contaminant that can act as a bond breaker. Refer to ANSI A108.01 AN-2 "General Requirements for Subsurfaces" and the Tile Council of North America's "Handbook for Ceramic Tile Installation" for detailed substrate preparation guidelines.

Wallboards must be dry, sound and solidly anchored to structural components, with wall surfaces plumb and true; floor surfaces must have minimal variation in plane or slope, per TCNA guidelines.

Handle and dispose of asbestos and other hazardous materials in accordance with prevailing regulations, which supersede the recommendations in this document.

If pre-leveling or subfloor repair is required:

- Interior or exterior: ARDEX AM 100™, ARDEX A 38 MIX™ Rapid Set, Premixed Screed or ARDEX A 38™ Rapid Set Screed
- Interior only: ARDEX Self-Leveling Underlayments or Patching Compounds

Observe the instructions and dry times in the respective ARDEX technical data sheets.

Step 2: Mixing

Recommended Tools

- Appropriate notched trowel
- ARDEX T-2 Ring Mixing Paddle
- Low-speed drill
- ARDEX sponge (or similar)
- White Scotch-Brite® pad (or similar)

Each unit contains properly proportioned amounts of resin ("Part A") and hardener ("Part B"). Extra room is provided in the larger "Part A" container to accommodate "Part B."

As with all epoxies, full mixing of all material is critical to product performance. Add all of "Part B" to "Part A," using a spatula or similar scraping tool to ensure all hardener is removed from the hardener container, and mix thoroughly with a low-speed drill and ARDEX T-2 Ring Mixing Paddle.

Spread ARDEX 100% Solids Epoxy Adhesive out immediately after mixing — self-heating in the container will reduce working time. Working time is approximately 1 hour at 70°F (21°C); pot life is approximately 40 minutes. As with all reactive materials, elevated temperatures will drastically reduce pot life and working time.

Step 3: Application

Install in accordance with ANSI A108.6. Apply the epoxy to the substrate with the flat side of a trowel to obtain a solid mechanical bond, then comb with the notched side of a trowel of sufficient depth to ensure that the tile or stone is covered uniformly over the entire surface.

The type and size of the tile or stone will dictate the notch trowel size needed to achieve proper transfer and coverage. Follow TCNA recommendations for proper transfer of ARDEX 100% Solids Epoxy Adhesive from the substrate to the tile or stone.

Apply to an area no greater than what can be covered with tile while the epoxy remains plastic (approx. 1 hour, depending on jobsite conditions). Do not set tile into epoxy that has started to set. Tile position may be adjusted for up to approximately 1 hour after installation.

Tile can be grouted after 12 hours using ARDEX DG 1™, ARDEX FL™, ARDEX FG-C™, ARDEX FH™ or ARDEX WA™.

Cure Times

All times calculated at 70°F (21°C). Jobsite conditions and temperature may affect curing.

12 hours:	Light foot traffic
2 days:	Full traffic loads
7 days:	Limited chemical resistance and submerged applications

Step 4: Cleaning

Clean tools and excess epoxy with water before the epoxy begins to set — it cannot be removed once fully cured.

Notes

Intended for use by professional contractors who are trained in the application of this product and/or similar products.

Not for use as a grout.

Not for use as a wear surface.

Adhesives for tile and stone are not replacements for waterproofing membranes. For cases requiring waterproofing, refer to the ARDEX 8+9™ Rapid Waterproofing and Crack Isolation Compound TDS and the ARDEX 8+9 "5 Step Application Guide."

ARDEX recommends the installation of test areas to confirm the suitability of the product for the intended use.

Never mix with cement or additives. Observe the basic rules of tile work.

For setting natural stone, contact the ARDEX Technical Service Department.

Do not reuse packaging. Dispose of packaging and residue in accordance with applicable regulations. Do not flush material down drains.

Technical Data According to ARDEX Quality Standards

Data based on a partial, in-lab mix at 70°F/21°C. Typical values, not specifications.

Mixing Ratio:	Mix all of "Part B" into "Part A."
Coverage (setting adhesive):	1/4" x 1/4" x 1/4" sq.-notch trowel (for tiles larger than 4 sq. in./25 cm^2): 19.5 sq. ft. (1.8 m^2) per unit 3/16" (D) x 5/32" (W) V-notch trowel (for tiles 4 sq. in./25 cm^2 or smaller): 32 sq. ft. (3 m^2) per unit Unit = combined "Part A" and "Part B" (8.8 lbs./4 kg total)
Pot Life:	Approx. 40 minutes
Working Time:	Approx. 1 hour
Open Time:	Approx. 1 hour
Time to Grout:	12 hours
VOC:	2.67 g/L per ASTM D2369
Packaging:	"Part A" Resin (6.6 lbs./3 kg); "Part B" Hardener (2.2 lbs./1 kg)
Storage:	Store in a cool, dry area, out of the sun.
Shelf Life:	1 year, if unopened
Warranty:	ARDEX Standard Limited Warranty; also eligible for the ARDEX Tile and Stone Installation Systems SystemOne™ Warranty.

ISO 13007 Classification

ISO 13007 Classification	Test Characteristic (28-Day Cure)	Classification Requirement
R2 (reaction resin adhesive, improved)	Shear adhesion strength after water immersion	≥ 290 psi (2 MPa/20 kg/cm^2)
	Open time: tensile adhesion strength	≥ 725 psi (5 MPa/51 kg/cm^2)
	Shear adhesion strength after thermal shock	≥ 290 psi (2 MPa/20 kg/cm^2)
R2T (reaction resin adhesive, improved characteristics, thixotropic, high sag resistance)	Additionally, with low sag	< 0.5 mm

Evaluation per ANSI A118.3

Property (Test Number)	Value	
	Evaluation	**Requirement**
Water Cleanability (E 5.1)	Pass	80 minutes
Initial Setting Time (E 5.2)	Pass	> 2 hours
Service Strength Setting Time (E 5.2)	Pass	< 7 days
Shrinkage 7-day (E 5.3)	0.1	< 0.25%
Sag (E 5.4)	Pass	No evident change
Bond Strength to Quarry Tile (E 5.5)	Pass*	> 1000 psi
Compressive Strength 7-day (E 5.6)	9050 psi	> 3500 psi
Tensile Strength 7-day (E 5.7)	2610 psi	> 1000 psi
Thermal Shock (E 5.8)	1569 psi	> 500 psi

*Tile failed during test TCNA-557-13.

Precautions

Carefully read and follow all precautions and warnings on the product label. For complete safety information, refer to the Safety Data Sheet (SDS) available at www.ardexamericas.com.

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Chemical Resistance

Long-term resistance (no effects after 7-day immersion): Aluminum sulfate (26.5%, saturated), ammonia (concentrated), animal fats, brine, calcium chloride (saturated), calcium hydroxide (saturated), carbon disulfide, caustic soda (saturated), chromic acid (5%), citric acid (saturated), diesel, effluent (wastewater, non-industrial), ethylene glycol, formalin solution (3%), formic acid (2.5%), glycerin, household detergent, hydrochloric acid (<36%), hydrofluoric acid (1%), hydrogen peroxide (25%), hypochlorite solution (act. Cl 165 g/L), lactic acid (10%), methyl alcohol (<5NR%), moor water, nitric acid (<1NR%; not concentrated), oleic acid, olive oil, oxalic acid (10% in water), peanut oil, petrol, phosphoric acid (75%), photographic developing fluid, sea water, sodium bisulfite (23%, saturated), sodium chromate (34%, saturated), sodium hydroxide (saturated), sodium hyposulfite (17%, saturated), tannic acid (10%), tartaric acid (saturated), toluene, treacle, turpentine, vegetable fats, xylene.

Discoloration only, after 7-day immersion: Potassium permanganate (≤ 10%), sulfuric acid (80%), ferric chloride (47.9%, saturated).

Short-term resistance (no effects after 1 day; effects after 3 days): Acetic acid (5%), ethyl alcohol (concentrated), formic acid (10%), lactic acid (20%), nitric acid (40%; not concentrated).

Not resistant (effects after 1-day immersion): Acetic acid (>10%), acetone, butanone (MEK), chloroform, ethyl acetate, hydrofluoric acid (>5%), lactic acid (>20%), methylene chloride, nitric acid (concentrated), sulfuric acid (96%).

Made in the USA.

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Visit www.youtube.com/ARDEX101 to watch ARDEX product demonstration videos. For recommended installation tools, visit DTA USA at www.dtausagroup.com. For easy-to-use ARDEX Product Calculators and Product Information On the Go, download the ARDEX App.

Available on the iPhone App Store | ANDROID APP ON Google play | YouTube

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