

## OVERVIEW & BENEFITS:

Tenax Stonefill Xtra Clear Epoxy Resin is a high-performance, ultra-transparent two-component epoxy system designed for bonding, filling, and repairing natural and engineered stones. Its crystal-clear finish makes it ideal for aesthetic applications where clarity and seamless blending are essential. StoneFill Xtra-Clear is suitable for all types of natural stones including precious Italian marbles. Product can be applied by brush, roller, or trowels on stone.



## KEY FEATURES:



### Ultra-Clear Transparency

Provides a glass-like finish, perfect for invisible repairs and aesthetic enhancements.



### Low Yellowing Formula

Engineered for long-term clarity and UV resistance.



### Color Tintable

Compatible with Tenax coloring pastes for custom color matching.



### High Adhesion Strength

Bonds securely to a wide range of stone surfaces.



### Polishable Surface

Can be polished to a high gloss, matching the stone's natural finish.

## APPLICATION PROCESS:

### Surface Preparation

- Clean the stone surface thoroughly using a suitable degreaser.
- Remove all dust, oil, and moisture.
- Use compressed air for deep cracks or holes.
- Ensure the surface is completely dry before application.

### Mixing Components

- Mix Part A (resin) and Part B (hardener) in a 100:30 ratio by weight.
- Stir slowly and thoroughly for 2–3 minutes to avoid air entrapment.
- If color adjustment is needed, add a small amount of tinter to the resin before mixing in the hardener. For best result use Tenax colorant.
- Apply the mixed epoxy using a brush, roller, or trowels on stone.
- For deep voids, apply in layers to prevent sagging and ensure full curing.
- Press firmly into cracks to eliminate air pockets.
- For bonding, apply a thin, even layer to both surfaces before joining. For best result more than 1 coat is recommended.

### Curing & Finishing

- Allow to cure undisturbed for 24 hours at 20–25°C.
- After curing, grind and polish with diamond abrasives for a seamless finish.
- Clean the surface with a neutral cleaner to remove any residue.

## TECHNICAL DATA:

### INDIVIDUAL COMPONENTS

Property	Unit	Value
Resin; appearance	visual	Clear liquid
Hardener; appearance	visual	Clear liquid
Resin; colour	Gardner scale	Max. 1

Hardener; colour	Gardner scale	Max. 1
Resin; viscosity @ 25±1 °C	cPs	850 – 1250
Hardener; viscosity @ 25±1 °C	cPs	40 – 80
Resin; density @ 25 °C	gm/ml	1.10 – 1.15
Hardener; density @ 25 °C	gm/ml	0.95 – 0.98

## AFTER MIXING

Property	Unit	Value
Mixing ratio	byweight	100:30
Gel time @ 25±1 °C, 100 gm mix mass	minutes	60 – 70
Hardness, after 24 hr curing at 25 °C	shore-D	Min. 78
*Tack free time at 25±1 °C of approx. 200-micron film	minutes	Min. 240
*Tack free time at 40±1 °C of approx. 200-micron film	minutes	Min. 170
Time to polish at 25±1 °C	hours	After 24*

\*Note: Actual time may vary depending upon ambient temperature and humidity.

## RECOMMENDED USAGE:



### Onyx & Quartz

Ideal for invisible repairs and aesthetic enhancement.



### Marble & Light

Colored Stones – Perfect for seamless joint filling.



### Granite & Engineered Stone

Effective for bonding and surface restoration.



### Decorative Stone Applications

Enhances clarity and visual appeal.

## DO'S AND DON'TS:

Category	Do's	Don'ts
Surface Prep	Ensure the surface is clean and dry before application.	Do not apply on wet, dusty, or dirty surfaces.
Mixing	Mix resin and hardener in 100:30 by weight ratio in a clean container.	Do not alter the mixing ratio or add excess resin/hardener.
Application	Apply using a fine-toothed spreader, brush, roller, or trowel. Apply multiple coats for large fissures or porous surfaces.	Do not skip sealing deep cracks from the backside of the stone.
Timing	Consume the mixture within 40–50 minutes at 25°C.	Do not delay application beyond the workable time.
Polishing	Polish after 24–48 hours, depending on ambient temperature.	Do not polish immediately after application.
Storage	Store in original tightly closed containers in a cool, dry place away from heat and sunlight. Avoid freezing conditions.	Do not expose to heat sources or freezing environments.
Quality	Follow exact mixing proportions for optimal mechanical and chemical properties.	Do not assume warranty for improper application or unsuitable conditions.

## STORAGE AND SHELF LIFE:

Store in a cool, dry place away from direct sunlight and extreme temperatures. Keep containers tightly sealed. Shelf life is 24 months in original, unopened packaging under recommended storage conditions.



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