



Aqua-Tool-Bond™ Data Sheet & Instructions

Aqua-Tool-Bond is a water-soluble adhesive for bonding Aqua Blocks or Aqua Mandrels. It will be delivered ready to use and it withstands temperature up to 195°C.

Tips and Procedure for Aqua-Tool-Bond

- Apply the glue evenly, either thin to both faces or thick on one (best only for very large pieces or those which are difficult to position). Use a brush for small surfaces or a squeegee to cover larger surfaces.
- Work before material absorbs all glue – while there is still a glossy appearance to the surface (if necessary, rewet surface carefully, as the material will have softened).
- The best bond achieved by clamping or other means of applying force.
- Wipe any excess glue or runs as quickly as possible
- Although not necessary, it helps to let bonded pieces to rest for 10-20 minutes prior to moving into a warm oven. This is to allow the glue to wick into the material.
- Do not allow any movement at the joint until the material has set. This will result in either a weak bond or no bond.
- Drying at 94°C / 200°F works well, but lower or higher temperature present no problem. Bonding at room temperature is possible too, but it requires much longer drying time.
- Drying time varies depending on size and shape of mating surfaces (i.e. a 130x130mm / 5"x 5" mating surface can be fully workable in about an hour at 94°C / 200F whereas a 50x320mm / 2"x12.5" will be ready in 20 minutes). If the time is available, best is to let the bonded block in the oven over night to ensure that the piece is thoroughly dry.

Step-by-Step

1. Prepare surfaces
2. Prepare fixturing/clamping method
3. Apply Aqua-tool-bond
4. Clamp sections together
5. Wipe runs
6. Wait 10-20 minutes
7. Move to oven/Turn oven on

For additional assistance, please contact Aero Consultants AG.

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Recommended equipment

Mixed Aqua-Tool-Bond, cup and mixing stick, paint brush or spatula



Viscosity of Aqua-Tool-Bond is thinner than honey

Apply very thin coat of Aqua-Tool-Bond to both bonding surfaces utilizing small brush. Repeat the process after 5min.



Bond both Aqua block surfaces together by applying reasonable clamping force.

