



**MASONRY ADHESIVE**

## **INSTALLATION INSTRUCTIONS**

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## **SECTION 1 – GENERAL INFORMATION**

### **1.1 Description**

Mason Bond, product code F6200F, is a polyurethane adhesive formulated to bond concrete masonry unit structures that meet the requirements of ICC AC308. The International Code Council (ICC) has verified its code compliance with ESR-1968. (International Building Code Section 2103.8 and International Residential Code, Section R607.1)

### **1.2 Uses**

Mason Bond is used to permanently bond masonry block structures. It is a masonry adhesive for use in plain (unreinforced), grouted or ungrouted, non-fire-resistance-rated masonry construction consisting of open and closed, hollow concrete masonry units complying with ASTM C 90 in bearing walls, nonload-bearing walls, retaining walls, foundation stem walls and piers.

## **SECTION 2 – INSTALLATION INSTRUCTIONS**

### **2.1 Mixing Instructions**

1. Open Mason Bond tube: Cut end of applicator tip to allow for a minimum 3/16" bead of adhesive.
2. Puncture Seal: Use a thin, sharp object like a nail, put thru the cut applicator tip and puncture the seal between the caulk tube and the applicator tip.



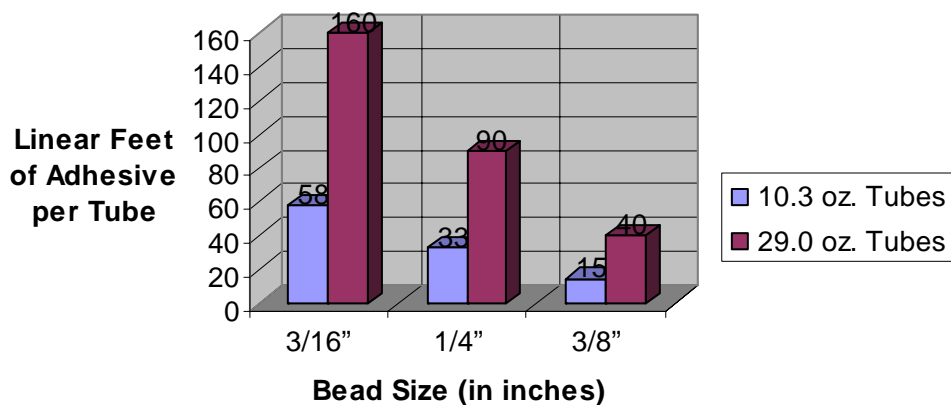
## 2.2 Application Instructions

- A. Application Rate and Bead Size:** The cartridges are currently available in either the 10.3 or 29.0 oz tubes. The following chart and graph represent yield per tube in linear feet. The recommended minimum bead size is 3/16”.

**Bead Size / Yield Correlation Chart**

| <b>Bead Size</b> | <b>10.3 oz. Tubes<br/>(in Linear Feet)</b> | <b>29.0 oz. Tubes<br/>(in Linear Feet)</b> |
|------------------|--|--|
| 3/16”            | 58   | 160  |
| 1/4”             | 33   | 90   |
| 3/8”             | 15   | 40   |

**Bead Size / Yield Correlation Chart**

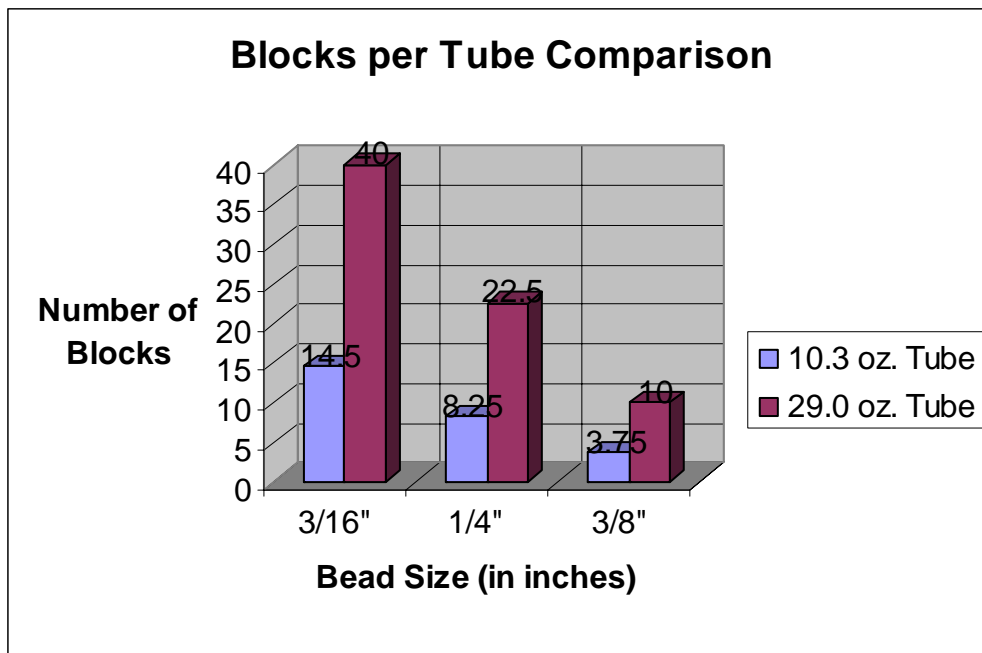




**B. Number of Blocks per Tube of Mason Bond:** The following chart and graph illustrates the number of 8"x8"x16" blocks that can be placed using Mason Bond at different bead sizes.

**Number of Blocks per Tube Comparison**

| Bead Size | No. Blocks per 10.3 oz. tube | No. Blocks per 29.0 oz. tube |
|-----------|------------------------------|------------------------------|
| 3/16"     | 14.5                         | 40                           |
| 1/4"      | 8.25                         | 22.5                         |
| 3/8"      | 3.75                         | 10                           |

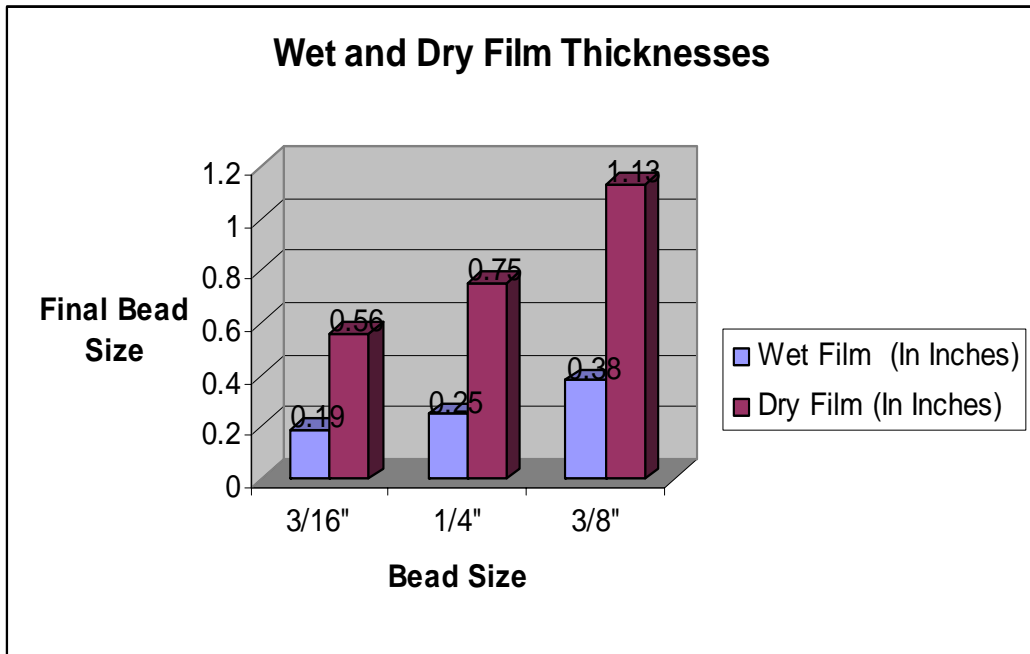




**C. Wet and Dry Film Thickness:** Mason Bond will grow to three times its size. The following chart illustrates size growth based on applied bead size.

**Wet and Dry Film Thicknesses of Mason Bond**

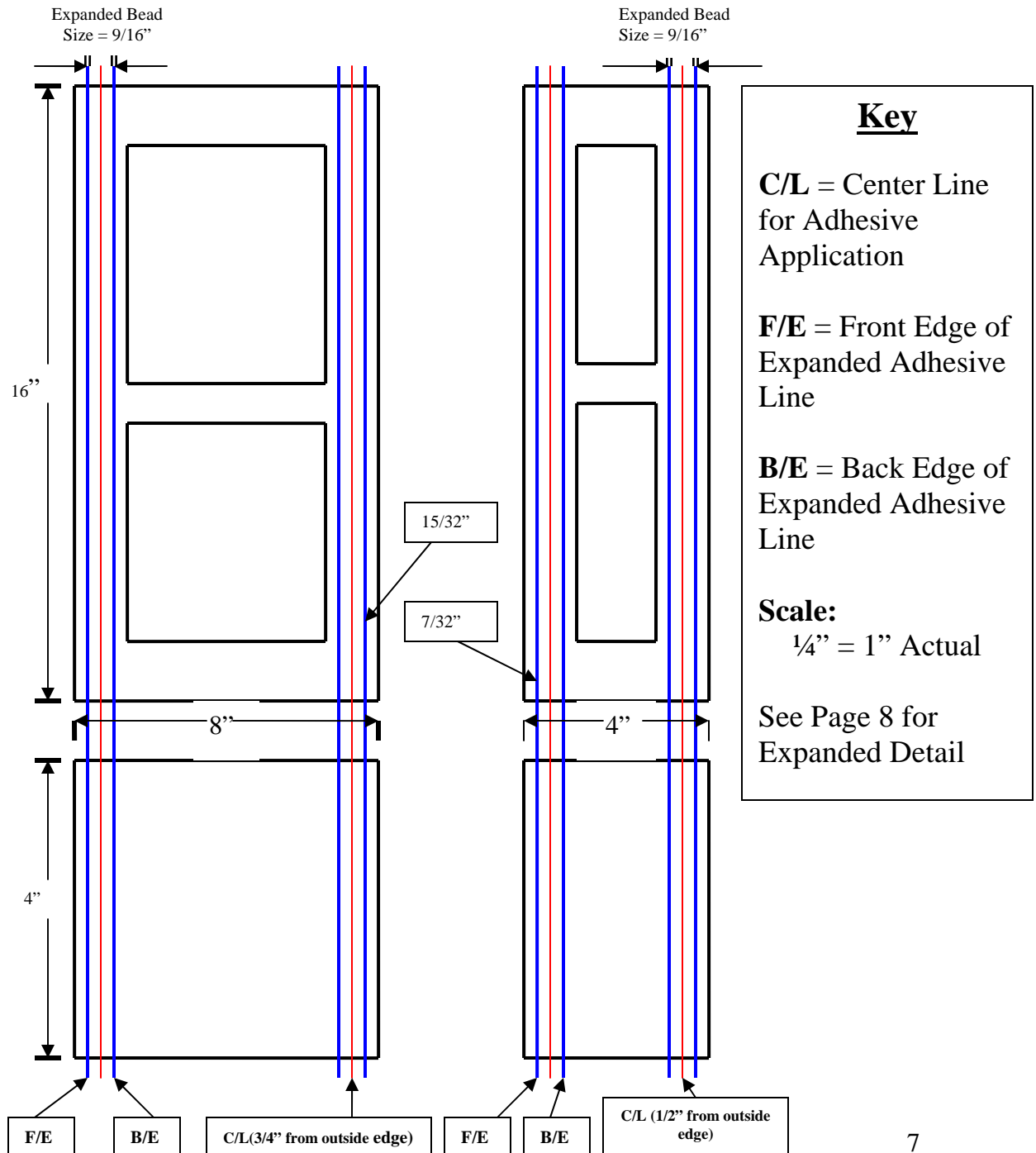
| Bead Size | Wet Film (In Inches) | Dry Film (In Inches) |
|-----------|----------------------|----------------------|
| 3/16"     | 3/16"                | 9/16"                |
| 1/4"      | 1/4"                 | 3/4"                 |
| 3/8"      | 3/8"                 | 1-1/8"               |





**D. Adhesive Application Location:** Mason Bond adhesive is designed to be applied to only one contact surface of the block. The following application illustration shows the placement location of the adhesive bead based on the recommended minimum bead size ( $3/16''$ ), including wet and dry (expanded adhesive) film thicknesses.

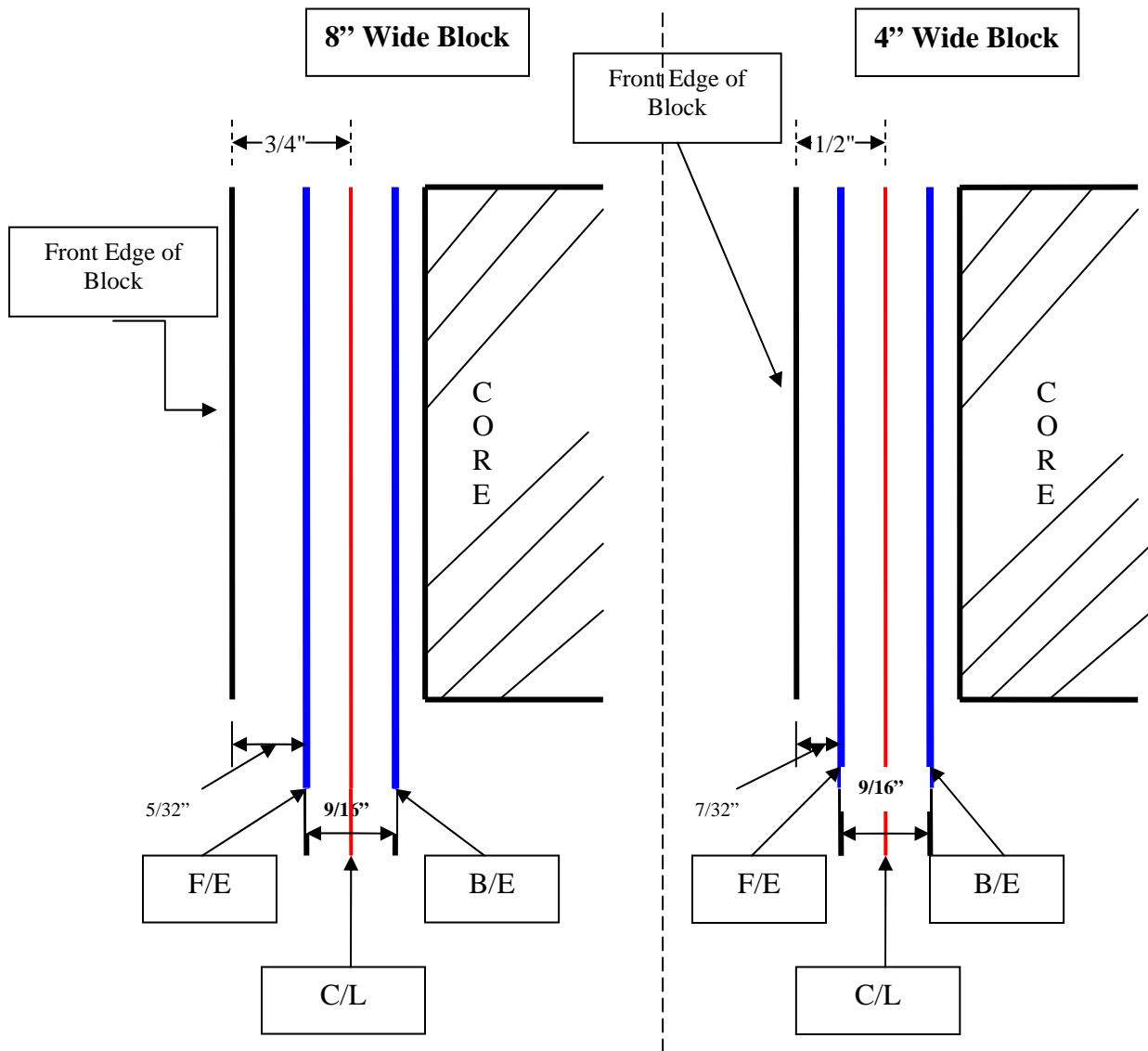
### MASON BOND ADHESIVE BEAD APPLICATION





## MASON BOND ADHESIVE BEAD APPLICATION

### EXPANDED DETAIL



SECTION DRAWING OF FRONT BED JOINTS OF 8" WIDE AND 4" WIDE CMU'S

FULL SCALE



### 2.3 Assembly Conditions

- A. Temperature Limitations** -The assembly temperature range for Mason Bond is between 40°F and 120°F
- B. Humidity Limitations** – The assembly humidity range for Mason Bond is between 20% relative humidity 90% relative humidity
- C. Time Limitations** – The assembly time or open time range for Mason Bond is limited to 15 +/- 5 minutes.

**Conclusion:** Temperature is not a factor for assembly. Assembly or open time is determined by relative humidity levels.

The higher the humidity is, the shorter the assembly or open time. In case of higher humidity, open time may be reduced by 5 minutes from the standard of 15 minutes.

The lower the humidity is, the longer the assembly or open time. In case of low humidity, open time may be increased by 5 minutes from the standard of 15 minutes.

- D. Moisture Content of Block** - Block moisture content is consistent with that of the temperature, humidity, and time limitations for assembly.

The higher the humidity or moisture content is of the block, the shorter the open time for assembly. Higher moisture content may lead to a reduction of 5 minutes of assembly or open time from the standard of 15 minutes.

The lower the humidity or moisture content is of the block, the longer the open time. Lower moisture content may lead to an increase of 5 minutes of assembly or open time from the standard of 15 minutes.

- E. Block Conditions** – The substrate must be free of dust, grease and other contaminants that would interfere with the adhesive placement. All blocks must be inspected prior to assembly. Mason Bond may be applied to the dry or wet block. There cannot, however, be any standing or pooled water on the block at the time of installation.



#### **F. Block-to-Block Joint Tolerances**

- a. **Head Joint** – Maximum block-to-block width tolerances on the head joint are to be no greater than 1/16”.
- b. **Bed Joint** – Maximum block-to-block width tolerances on the bed joint are to be no greater than 1/16”.

#### **2.4 Recommended Curing Conditions**

- A. Recommended Curing Temperature** – Mason Bond is not reliant on temperature for curing. The temperature range for assembly should be limited to 40°F up to 120°F.
- B. Recommended Curing Pressure** - Mason Bond does not require pressure for curing.
- C. Recommended Curing Time Under Pressure** – Mason Bond does not require time under pressure for curing. Mason Bond will be 100% cured within 72 hours of initial adhesive application.
- D. Recommended Curing Temperature of the Assembly Under Pressure** - Mason Bond does not require any additional curing temperature outside the assembly condition limitations as listed in Section 2.3 on Page 9.

#### **2.5 Pot Life, Storage Temperature, and Maximum Storage Life**

- A. Pot Life** – Pot life information for Mason Bond is not applicable due to the fact it is not a catalyzed formulation and requires no mixing.
- B. Storage Temperature** – The storage temperature for Mason Bond is 65°F to 95°F.
- C. Maximum Storage Life** – The maximum storage life of an unopened container of Mason Bond is 18 months.



## DIRECTIONS FOR USE

1. Read Material Safety Data Sheet: Read entire label before using.
2. Refer to WHMIS below for all personal protective equipment precautions and recommendations.
3. Clean block surface of loose dirt and debris.
4. Cut end of tip to apply approximately a 3/16" bead on surface: Cut tip of application nozzle.
5. Install caulk tube into caulking gun.
6. Puncture seal of caulk tube: Use a thin sharp object, like a nail, put thru the cut applicator tip and puncture the seal between the caulk tube and the applicator tip.
7. Apply a 3/16" bead of adhesive to the bed joints and head joints on both sides of the block (follow Application Guide for specific application instructions).
8. Set next block: Block can be set immediately or up to 15 minutes after the application of the bead. (15 minutes is normal open time @ 75°F, 40%RH. Open time decreases in humid conditions and increases in dry conditions.)
9. Adhesive will be fully cured within 72 hours.
10. Do not reuse empty container. Dispose of according to all federal, state, and local regulations.
11. Remove **uncured** adhesive with GC 33 or another ITW TACC approved cleaning agent.
12. Remove **cured** adhesive with trowel, putty knife or small electric angle grinder with course twisted wire cup brush. Test to make sure block is not damaged

**Temperature Limitations** – The assembly temperature range for Mason Bond is between 40°F and 100°F.


**Humidity Limitations** – If relative humidity is below 20%, mist blocks with water to aid in curing process.

**NOTE:** The shelf life for an unopened container of this adhesive is 18 months from date of manufacture.

**ATTENTION:** Do not reuse empty container. Dispose of according to all federal, state, and local regulations.

KEEP OUT OF REACH OF CHILDREN.  
IF YOU DO NOT UNDERSTAND, OR CANNOT READ ALL DIRECTIONS,  
CAUTIONS AND WARNINGS DO NOT USE THIS PRODUCT.  
SEE MSDS FOR MORE INFORMATION.

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