



# Industrial Insulation Group, LLC

A Calsilite/Johns Manville Joint Venture

## Pipe & Equipment Insulations

### CalBond™ Gold

High Temperature Glue

#### Description

CalBond Gold is a modified, silicate-based glue for thermal insulations. It sets quickly to provide a high-temperature bond for porous insulating materials. CalBond Gold is completely asbestos free.

#### Applications

CalBond Gold is useful for bonding sections of calcium silicate or perlite high-temperature pipe or block insulation, to make mitered elbows, large insulating sections or other special shapes.

#### Advantages

- Easy to use, sets quickly
- Excellent adhesion strength to calcium silicate insulation, the glue line joint will outlast the insulation itself.

#### Available Forms

CalBond Gold is available in one-, two- and five-gallon (3.8, 7.6 and 18.9 liter) cans, as well as 12-ounce (355 ml) tubes and 55-gallon (208 liter) drums.

#### Specification Compliance

ASTM C 474-67

Certification of Compliance available upon request

#### Wet Properties

Density	14.5 lbs./gal. (1.74 kgs./liter)
Solids by Weight	62%
pH	12.8
Viscosity-Brookfield	7200 to 8500 cps.
Wet Coverage	$\frac{1}{16}$ " thick, 25 sq. ft./gallon (1.6 mm, 0.61 m <sup>2</sup> /liter)
	$\frac{1}{32}$ " thick, 50 sq. ft./gallon (0.8 mm, 1.23 m <sup>2</sup> /liter)

#### Drying Time on Calcium Silicate Insulation (ASTM C 474-67 at 77°F [25°C])

Set	15 Seconds
Handle	5 Minutes
Thorough Dry	1½ Hours
Minimum Application Temp. for Thorough Dry	35°F (2°C)

#### Physical Properties

Melt Point	Decomposes @ 1088°F (587°C)
Shore "C" Hardness – 24 Hour Cure	65 Minimum
Resistance to Cracking (ASTM C 474-67)	
0" - 1/8" (3 mm) Wedge	No Cracking
0" - 1/4" (6 mm) Wedge	No Cracking
Elongation – 10-Day Cure	2%
Shrinkage – 10-Day Cure	1%
Tensile Strength	3000 psi (20,685 kPa)
Adhesion to Calcium	
Silicate Insulation	Insulation Fails Before Glue Line Joint



#### Chemical Resistance

Non-Aqueous Solvents	Excellent with Aromatic, Aliphatic and Oxygenated Solvents
Mineral Acids	Salt Formation and Loss of Bond Strength
Water – Cold	Softens Upon Lengthy Submersion
Water – Hot	Softens Upon Continuous Contact

#### Storage and Application Limitations

Shelf Life	1 Year from Date of Manufacture
Do Not Store Below 35°F (2°C) (Wet Product)	Freezes
Do Not Store Above 95°F (35°C) (Wet Product)	Bodies Up
Freeze-Thaw Stability (Wet Product)	No Cycles Maximum Recommended Continuous
Service Temperature (Dry Product)	1000°F (538°C)
Fire Resistance (Dry Product)	Passes 1200°F (649°C) Oven Without Charring
Effect on Metal (Dry Product)	Non-Corrosive

#### Removal from Surfaces

Immediately Use Hot Water and Soap **Before** It Dries

#### Government Certification

When ordering material to comply with any government specification or any other listed specification, a statement of the fact must appear on the purchase order. Government regulations and other listed specifications require specific lot testing, and prohibit the certification of compliance after shipment has been made. There may be additional charges associated with specification compliance testing. Please refer to IIG-CSP-3 for certification procedures and charges.

#### ISO 9000 Certification

Industrial Insulation Group mechanical insulation products are designed, manufactured, and tested in our own facilities, which are certified and registered to stringent ISO 9000 (ANSI/ASQC 90) series quality standards. This certification, along with regular independent third-party auditing for compliance, is your assurance that Industrial Insulation Group products deliver consistent high quality.

# CalBond™ Gold

High Temperature Glue

For technical information and assistance regarding application information, code approvals, and performance specifications, call **1-800-872-0338**.

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**For Customer Service  
and Order Placement**  
(800) 334-7997  
Fax: (877) 758-6096

**For Sales  
Information**  
(800) 866-3234  
Fax: (877) 758-6096

**For Technical  
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(800) 872-0338  
Fax: (970) 858-9641



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The physical and chemical properties of the CalBond™ Gold presented herein represent typical, average values obtained in accordance with accepted test methods and are subject to normal manufacturing variations. They are supplied as a technical service and are subject to change without notice. Any references to numerical flame spread or smoke developed ratings are not intended to reflect hazards presented by these or any other materials under actual fire conditions. Check with the Customer Service Office to assure current information. **All Industrial Insulation Group products are sold subject to the IIG Limited Warranty and Limitation of Remedy. For a copy of the IIG Limited Warranty and Limitation of Remedy, email - [info@iig-llc.com](mailto:info@iig-llc.com).**

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