



CalBond® Gold HIGH TEMPERATURE GLUE

DESCRIPTION

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

ADVANTAGES

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

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.

PACKAGING

CalBond Gold is available in one, two and five gallon (3.8, 7.6 and 18.9 liter) pails as well as 55 gallon (208 liter) drums.



CalBond® Gold

SPECIFICATION COMPLIANCE	
ASTM C447 Max Service Temp.	Passes
ASTM C665 Corrosivity to Steel	Passes
ASTM C795/C871/C692	Passes
ASTM E136 Non Combustible	Passes
Mil-I-24244	Passes
Reg Guide 1.36	Passes
EPA Test for VOC	

WET PROPERTIES	
Density	12 lbs./gal. (1.44 kgs./liter), avg
Solids by Weight	62%, avg
pH	12.8
Wet Coverage	1/16" thick, 25 sq. ft./gallon (1.6 mm, 0.61 m ² /liter)
	1/32" thick, 50 sq. ft./gallon (0.8 mm, 1.23 m ² /liter)

DRYING TIME ON CALCIUM SILICATE INSULATION (ASTM C474-67 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	
Shore "C" Hardness – 24 Hour Cure	65 Minimum
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	3 Years from Date of Manufacture
Effect on Metal (Dry Product)	Non-Corrosive
Store between 35°F and 95°F	
Clean Up: Use hot water and soap before drying. Maximum Recommended Continuous Service Temperature (Dry Product) 1000°F (538°C)	

ADDITIONAL INFORMATION AND MSDS

Please visit our website at www.iig-llc.com.

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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.

Industrial Insulation Group, LLC is a Johns Manville company. IIG manufactures MinWool-1200® mineral fiber pipe, block and a variety of other insulations; Thermo-12® Gold Calcium Silicate pipe and block insulation; Super Firetemp® fireproofing board; SprouleWR-1200® Perlite pipe and block insulation; high temperature adhesives, and insulating finishing cement.

The physical and chemical properties 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. Numerical flame spread and 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.



Industrial Insulation Group, LLC

A Johns Manville Company

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**CUSTOMER SERVICE,
TECHNICAL & GENERAL INFORMATION**

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www.iig-llc.com