60 Sec. Epoxy System
Part No. 46309

PRODUCT DATA BULLETIN

PRODUCT DESCRIPTION:

A super fast, general purpose thixotropic epoxy adhesive for applications requiring fast fixturing. This quick curing formula is excellent for bonding metals, glass, fiberglass and ceramics.

FEATURES/BENEFITS

- Non-sagging on vertical and overhead surfaces
- Part fixturing in less than 1 minute
- Bonds to metals, glass, fiberglass, fabrics and ceramic
- 100% reactive, no solvents

RECOMMENDED APPLICATIONS

- Ideal for repairing or assembling furniture, jewelry, china, appliances and models
- Fast cure metal-to-metal bonding and repairs

PRODUCT DATA
Physical Properties – (uncured)

Color	Clear
Mix Ratio By Volume	1:1
Mixed Viscosity	Thixotropic
Working Time 28 Grams @ 75°F	30 seconds
Functional Cure @ 28 grams @ 75°F	4 minutes
Coverage (Based on 25 ml)	152 sq. in. @ .010"
Specific Volume	23.7 in^3/lb.
% Solids by Volume	100

Performance Characteristics – (7 days cured @ 75°F)

Adhesive tensile shear, (steel) ASTM D1002*	1,600 psi
Operating temperature, dry	-40°F to +200°F
Cured density ASTM D792	1.08 gm/cm^3
Cured hardness, ASTM D2240	82D
Dielectric strength	490 volts/mil

*Overlap shear run @ 0.005" bond line thickness

Chemical Resistance: 7 days room temperature cure (30 days immersion @ 75°F)

Kerosene	VG	Methanol	U
3% Hydrochloric Acid	VG	Toluene	VG
Chlorinated Solvent	U	Ammonia	VG
10% Sulfuric Acid	VG	10% Sodium Hydroxide	VG

Key: VG = Very Good F = Fair U = Unsatisfactory

PLEASE CONSULT FACTORY FOR OTHER CHEMICALS.
Epoxies are very good in water, saturated salt solution, leaded gasoline, mineral spirits, ASTM #3 oil and propylene glycol. Epoxies are generally not recommended for long term exposure to concentrated acids and organic solvents.

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APPLICATION INFORMATION:

Surface Preparation:

60 Sec. Epoxy System works best on clean surfaces. Surfaces should be solvent-wiped, free of heavy deposits of grease, oil, dirt or other contaminants, or cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. Abrading or roughing the surfaces of metals will increase the microscopic bond area significantly and optimize the bond strength.

Mixing:

Proper homogeneous mixing of the two epoxy components of resin and hardener are essential for the curing and development of stated strengths. Always mix the two components with clean tools, preferably of a disposable design.

Application:

Apply mixed epoxy directly to one surface in an even film or as a bead. Assemble with the mating part within the recommended working time. Obtain firm contact between the parts to minimize any gap and ensure good contact of the epoxy with the mating part. A small amount of epoxy should flow out the edges to show there is adequate gap filling. For very large gaps, apply epoxy to both surfaces and spread to cover the entire area, or make a bead pattern which will allow flow throughout the joint.

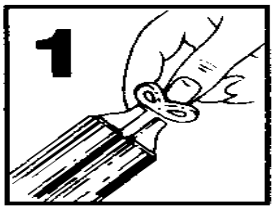
Let bonded assemblies stand for the recommended functional cure time before handling. They are capable of withstanding processing forces at this point, but should not be dropped, shock loaded or heavily loaded.

Cure:

Full bond strength is reached in 1 hour.

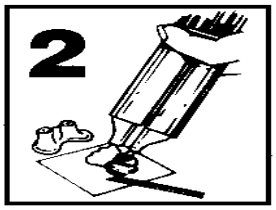
Packaging and Dispensing:

60 Sec. Epoxy System comes in a 25 ml syringe, carded, packed six units per case. The syringe is a high-tech, patented dispenser. The patented 1-2-3 dispenser makes it easy to dispense and mix the right amount for the job.



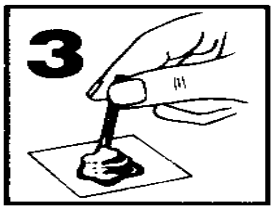
SNAP

Just snap off the cap. The snap off cap eliminates unsafe cutting of tube ends. The cap is reusable.



DISPENSE

When you dispense the product by pushing the easy glide plunger in, a mixing paddle will pop out.



MIX

Mix the right amount of product with the handy mixing paddle. Snap the cap back on. It's that simple.

STORAGE AND SHELF LIFE:

60 Sec. Epoxy System should be stored in a cool, dry place when not in use for a long period of time. A shelf life of 3 years from date of manufacture can be expected when stored at room temperature 70°F (22°C) in their original containers.

PRECAUTION:

For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets prior to using this product.