



TECHNICAL DATA SHEET



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DESCRIPTION:

Loctite® Epoxy 5 Minute Instant Mix™ is a two-part adhesive consisting of an epoxy resin and a hardener. When mixed in equal volumes, the resin and hardener react to produce a tough, rigid, high strength bond which starts to set in 5 minutes and reaches handling strength in 1 hour. The static mix nozzle delivers a uniform mixture of resin and hardener every time. It can be used as an adhesive for a wide range of materials or as a versatile filler for gap bonding, surface repairs and laminating. Loctite® Epoxy 5 Minute Instant Mix™ does not shrink and is resistant to water and most common solvents. It can be tinted with earth pigments, cement or sand for color matching and can be sanded and drilled.

RECOMMENDED FOR:

Bonding metal, glass, ceramic, wood, many rigid plastics, china, tile, fiberglass, concrete and stone. Can be combined with fiberglass cloth for a durable patch.

NOT RECOMMENDED FOR:

- Polyethylene, polypropylene, nylon, polytetrafluoroethylene (PTFE)/Teflon® or flexible materials
- Continuously wet areas or water immersion

FEATURES & BENEFITS:

Feature	Benefits
Machinable.....	Will not crack when drilled
Can be tinted.....	Matches surrounding materials
Water resistant.....	Can be used outdoors
Does not shrink.....	One-time application
Convenient instant mix syringe.....	Consistently dispenses equal, uniformly mixed amounts of each component
Sets in 5 minutes.....	Quick completion of project

Item #	Package	Size
1365868	Carded Syringe	0.47 fl oz (14 mL)

DIRECTIONS:

Tools Typically Required:

Utility knife (for syringe)

Safety Precautions:

Apply and cure in a well-ventilated area. Wear gloves and wash hands after use.

Preparation:

Protect work area. Surfaces must be clean, dry and free from oil, wax and paint. Roughen smooth surfaces for better adhesion by sandblasting or sanding with an emery cloth. Wash glass and ceramic surfaces with soap and water then rinse and let dry. Pre-fit parts to be joined. Hold syringe with nozzle end up and pull plunger back slightly allowing air bubbles to rise to top. Snap cap off by pushing to the side (do not twist) and discard. Attach nozzle over syringe opening, push past prongs and turn 90° to lock in place.

Application:

Depress plunger to dispense epoxy directly onto one side of the surfaces to be bonded. Wipe syringe tip immediately. Join surfaces within 4 minutes of adhesive application. Immediately remove excess glue using mineral spirits or rubbing alcohol (follow manufacturer's instructions). Bond sets in about 5-7 minutes at 68°F (20°C) to 77°F (25°C). For best results in butt joints, apply adhesive as a reinforcing fillet or splint for additional support. Usable strength is obtained within 20 minutes. Warmer temperatures will shorten the set time and cooler temperatures will lengthen it.

Clean-up:

Remove and discard nozzle. Retract plunger slightly and wipe syringe tip. Remove cap from side holder and place on end of syringe. Clean excess glue immediately by wiping with clean cloth. Acetone may be used to assist in removal. Cured adhesive may be cut away with caution using a sharp blade. Prolonged immersion in paint stripper will soften the cured adhesive to aid removal. Note: Acetone is highly flammable and not compatible with all surfaces. Follow manufacturer's instructions and test on small area before applying.

STORAGE AND DISPOSAL

Not damaged by freezing. If frozen, warm to room temperature until the resin and hardener become liquid enough to mix. Use an approved hazardous waste facility for disposal.

LABEL PRECAUTIONS

DANGER: Corrosive. Causes eye and skin burns. May cause allergic skin and respiratory reaction. May be harmful if absorbed through skin.

DANGER: Contains epoxy resin, polymericaptan and amine curing agents. Do not get in eyes or on skin. Do not breathe vapors. **FIRST AID:** For eye contact, flush with water for 15 minutes and call a physician. For skin contact, wash thoroughly with soap and water and call a physician if symptoms persist. If swallowed, do not induce vomiting. Call a physician. **KEEP OUT OF THE REACH OF CHILDREN.**

Refer to the Material Safety Data Sheet (MSDS) for further information

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Purchasers should test the products to determine acceptable quality and suitability for their own intended use. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

TECHNICAL DATA

Typical Uncured Physical Properties		Typical Application Properties	
<u>Colour:</u>		<u>Application Temperature:</u>	39°F (4°C) to 95°F (35°C)
<u>Hardener:</u>	Yellow liquid	<u>Odor:</u>	Mild
<u>Resin:</u>	Colourless to light yellow liquid	<u>Gel Time:</u>	5 to 7 minutes (Cooler temperatures may require a longer set time)
<u>Base:</u>	Epoxy resin / Polymericaptan and amine hardener	<u>Usable Strength:</u>	20 minutes
<u>Specific Gravity:</u>		<u>Full Cure Time:</u>	24 hours
<u>Hardener:</u>	1.04		
<u>Resin:</u>	1.10		
<u>Flash Point:</u>			
<u>Hardener:</u>	302°F (> 150°C)		Note: Cure time is dependent upon temperature, humidity and amount of product used
<u>Resin:</u>	494.6°F (257°C)		
<u>VOC Content:</u> (Resin + Hardener)	0.1% by weight		
<u>Shelf Life:</u>	18 months from date of manufacture (unopened)		
<u>Lot Code Explanation:</u>	YYYY MMXX		
(Stamped on top of syringe above the label)	YYYY = Year of manufacture MM = Month of manufacture XX = Disregard		
	For example: 2013 1171 Manufactured in November 2013		

Typical Cured Performance Properties

<u>Color:</u>	Translucent yellow
<u>Service Temperature:</u>	
Long Term Exposure:	-9°F(-23°C) to 120°F(49°C)
Short Term Exposure:	-9°F(-23°C) to 302°F(150°C)
<u>Sandable:</u>	Yes
<u>Water Resistant:</u>	Yes
<u>Paintable:</u>	No but can be tinted with earth pigments, cement or sand for color matching
<u>Typical Tensile Shear Strength:</u> (on sand blasted, cold rolled steel)	
30 minutes:	714 psi (4.92 N/mm ²)
2 hours:	2384 psi (16.44 N/mm ²)
4 hours:	2756 psi (19.00 N/mm ²)
24 hours:	3211 psi (22.14 N/mm ²)