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# 5 Minute<sup>®</sup> Epoxy

## Technical Data Sheet

Rev 07/07

**PRODUCT DESCRIPTION:** 5 Minute<sup>®</sup> Epoxy is a two-part, rapid-curing, clear, general purpose epoxy. Available in syringe, tubes, bottles and flow-mix<sup>®</sup> applicator.

**WORKS BEST ON:** Metal, wood, chrome, concrete, glass, ceramics, china, fiberglass, tiles and fixtures. Does not bond to polyethylene or polypropylene plastics. **DO NOT USE ON AREAS THAT WILL COME IN CONTACT WITH FOOD RELATED ITEMS.**

### PRODUCT FEATURES:

Tensile Strength: 1,500 psi

Color: Clear

Water Resistant

Working Time: 4 – 5 Minutes

Set Time: 8 – 10 Minutes

Can be Handled In: 15 Minutes

Full Bond: 1 Hour

Temperature Range: -40°F to 200°F (Temperatures below 40°F (5°C) slows the curing time)

Chemical Solvent Resistance: gasoline, diesel and kerosene.

**Epoxies are generally not recommended for long term exposure to chemicals and solvents,**

Storage: Store in a cool, dry environment.

**SURFACE PREPARATION:** Protect work area from accidental spills. Slightly roughen repair area. Clean surface by solvent-wiping to remove grease, oil, dirt or other contaminants.

**REMOVAL METHODS:** (test inconspicuous area of item to be sure chemicals do not harm surface)

**Before epoxy is allowed to dry,** remove excess immediately with damp cloth. Can also use mineral spirits or isopropyl alcohol.

#### After cure:

**Metal/Ceramic/Glass:** Soak in hot water, if possible. Heat in excess of 350°F, this will weaken the bond. Solvents that can be used: isopropyl alcohol, acetone, methylene chloride or other solvent.

**Fabric: Before epoxy cures,** immediately flush fabric with warm water or wipe with a damp cloth. Once epoxy is cured, it is not possible to remove it from the fabric.

**Wood:** Sand the cured material from the wood.

**HELPFUL HINTS:** Heat is generated while the epoxy mixture cures; the more epoxy and hardener that is mixed together, the more heat that is generated causing the epoxy mixture to cure faster. Only mix the amount of epoxy and hardener together that can be used within the working time.

Equal portions of the hardener and resin must be thoroughly mixed together in order for this product to cure properly. The most common problem with a two-part epoxy product is not mixing it thoroughly; it will not cure and will remain tacky. It is recommended that these epoxies be mixed on a clean surface (such as a paper cup, in the inside of the blister it is packaged on or etc.); do not mix it directly on the surface to be repaired. Once the product is thoroughly mixed, it can be applied to the repair area(s). *Please note, during the mixing process, be sure to scrape the sides and bottom into the mixture so that you are mixing all of the epoxy resin and hardener together.*

Thinning is possible with denatured alcohol. Add this to the mixed product. This is good for getting rid of air bubbles. It also makes the product clearer and slightly changes the product making it more flexible. Note, that when you add denatured alcohol, you may change the tensile strength of the bond.

Can add color pigment concentrate to add color to the epoxy. This should be done after the product is thoroughly mixed.

Removable tape is good for putting on an area that you don't want any adhesive/epoxy to get on. Before the epoxy cures, remove the tape.

**See MSDS for more complete information, safe handling instructions and first aid.**

Non-Regulated

Part Number(s): 20445, 20545, 20645, 20845, 20945, 43109, 46409, 90150



The technical data contained herein are intended as a reference only

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