



## 5 Minute™ Epoxy

<b>Description:</b>	A rapid-curing, general purpose adhesive/encapsulant.
<b>Intended Use:</b>	Industrial Use: Bonds metals, fabrics, ceramics, glass, wood, and concrete (in combinations)
<b>Features:</b>	<b>100% reactive, no solvents, Good Solvent Resistance, Bonds metals, fabrics, wood, and concrete</b>
<b>Limitations:</b>	Suitability of product is determined by the end user for their application and process.

**Typical Physical Properties:** Technical data should be considered representative or typical only and should not be used for specification purposes.

**Cured 7 Days @ 75°F (24°C)**

	<b>Typical Values</b>
Adhesive Lap Shear (GBS)	1,900 psi (13.1 MPa)
Dielectric Strength	490 volts/mil (19.3 kV/mm)
Hardness	85 Shore D
Impact Resistance	5.5 ft-lb/in <sup>2</sup> (11.56 kJ/m <sup>2</sup> )
Service Temperature	Dry -40°F - 200°F (-40°C - 93°C)
Solids by Volume	100%
Specific Volume	25.1 in <sup>3</sup> /lb. (0.99 cm <sup>3</sup> /g)
Tensile Elongation	1%
T-Peel	2-3 pli (0.35-0.53 N/mm)

**Standard Tests**

Tensile Lap Shear	ASTM D1002
Dielectric Strength, volts/mil	ASTM D 149
Cured Hardness Shore D	ASTM D 2240

**Uncured Properties @ 72°F (23°C)**

Color	Light Amber
Working Time	3-6 minutes
Fixture Time	10-15 minutes
Functional Cure	0.75-1 hours
Full Cure	12 hours
Mix Ratio by Volume	1:1
Mix Ratio by Weight	1:1
Mixed Density	9.17 lb/gal (1.10 g/cm <sup>3</sup> )
Mixed Viscosity	9,000-11,000 cP

**Surface Preparation:** Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength.

**Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths.**

**Mixing Instructions:** **25 ML Dev-Tube**  
1. Squeeze material into a small container the size of an ashtray.  
2. Using mixing stick included on Dev-tube handle, vigorously mix components for one (1) minute.  
3. Immediately apply to substrate.

**50 ML/400ML/490 ML CARTRIDGES**

1. Attach cartridge to Mark V™ [50ml] 400ml manual or pneumatic dispensing systems.
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to substrate.

**Application Instructions:**  
1. Apply mixed epoxy directly to one surface in an even film or as a bead.  
2. Assemble with mating part within recommended working time.  
3. Apply firm pressure between mating parts to minimize any gap and ensure good contact (a small fillet of epoxy should flow out the edges to display adequate gap fill.)

**For very large gaps:**

1. Apply epoxy to both surfaces.
2. Spread to cover entire area OR make a bead pattern to allow flow throughout the joint.

Let bonded assemblies stand for recommended functional cure time prior to handling.

**CAPABILITIES:**

Can withstand processing forces  
Do not drop, shock load, or heavily load

**Storage:** Store in a cool, dry place.

**Compliances:** None

**Chemical Resistance:** Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F (24°C)

Acetic 10% (Dilute)	Poor	Hydrochloric 10%	Poor
Acetone	Poor	Isopropanol	Poor
Ammonia	Poor	Kerosene	Excellent
Corn Oil	Excellent	Methyl Ethyl Ketone	Poor
Cutting Oil	Excellent	Mineral Spirits	Excellent
Ethanol	Poor	Motor Oil	Excellent
Gasoline (Unleaded)	Poor	Sodium Hydroxide 10%	Poor
Glycol/Antifreeze	Fair	Sulfuric 10%	Poor

**Precautions:** **FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate Safety Data Sheet prior to using this product.

**Warranty:** ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

**Order Information:**

14210	2.5 oz.
14630	9 lb.
DA051	400 ml cartridge
14250	25 ml Dev-Tube™
14270	50 ml cartridge
14200	15 oz.

**Contacts:**

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