

5 Minute™ Epoxy Gel

- Description:** Thixotropic/non-migrating gel adhesive with excellent gap-filling properties.
- Intended Use:** Bonding metal, ceramic, wood and vertical surface where gap-filling is needed.
- Features:** Good solvent resistance, fills gaps to 0.25 inches (6.35 mm), non-sagging adhesive.

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)	Typical Values	Standard Tests
Adhesive Lap Shear (GBS)	2,500 psi (17.2 MPa)	Tensile Lap Shear ASTM D1002
Dielectric Strength	440 volts/mil (17.3 kV/mm)	Dielectric Strength, volts/mil ASTM D 149
Hardness	82 Shore D	Cured Hardness Shore D ASTM D 2240
Impact Resistance	6.5 ft-lb/in ² (13.6 kJ/m ²)	
Service Temperature	-40°F - 200°F (-40°C - 93°C)	
Solids by Volume	100%	
Specific Volume	23.7 in ³ /lb. (0.86 cm ³ /g)	
Tensile Elongation	5%	
T-Peel	2-3 pli (0.35 - 0.53 N/mm)	

Uncured Properties @ 72°F (23°C)	
Color	Opaque
Working Time	4-7 minutes
Fixture Time	10-15 minutes
Functional Cure	1.5 hours
Full Cure	48 hours
Mix Ratio by Volume	1:1
Mix Ratio by Weight	1:1
Mixed Density	9.75 lb/gal (1.17 g/cm ³)
Mixed Viscosity	Gel

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

- 50 ML/400ML/490 ML CARTRIDGES**
- Attach cartridge to Mark V™ [50ml] 400ml manual or pneumatic dispensing systems.
 - Open tip.
 - Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
 - Attach mix nozzle to end of cartridge.
 - Apply to substrate.

- Application Instructions:**
- Apply mixed epoxy directly to one surface in an even film or as a bead.
 - Assemble with mating part within recommended working time.
 - 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:

<u>Item No.</u>	<u>Package Size</u>
14240	25ml Dev-Tube™
14265	50ml cartridge
DA052	400ml cartridge

Contacts: www.itwpp.com

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