



TECHNICAL DATA SHEET



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DESCRIPTION:

Loctite® Epoxy Extra Time is a two-part system consisting of an epoxy resin and a hardener available in a convenient dual syringe. When mixed in equal volumes, resin and hardener react to produce a tough, rigid, high strength bond. Loctite® Epoxy Extra Time sets in 60 minutes, excellent for complex multi-piece assemblies. It is used as an adhesive for a wide range of materials or as a versatile filler for gap bonding, surface repairs and laminating. Loctite® Epoxy Extra Time does not shrink and is resistant to water and most common solvents. It can be tinted with earth pigments, cement or sand for colour matching. It can be sanded and drilled.

RECOMMENDED FOR:

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

NOT RECOMMENDED FOR:

- Polyethylene, polypropylene, nylon, Teflon or flexible materials.
- Continuously wet areas or water immersion.
- Applications above 120°F (49°C).

FEATURES & BENEFITS:



Item #	Package	Size
1405603	Carded Syringe	0.85 Fl. Oz.

Feature	Benefits
High impact resistant.....	Won't crack when drilled
Can be tinted.....	Blends with surroundings
Water resistant.....	Can be used outdoors
Does not shrink.....	One-time application
Sets in 60 minutes.....	Ideal for complex multi-piece assemblies
Convenient syringe.....	Dispenses equal amounts of each component every time

DIRECTIONS:

Tools Typically Required:

Utility knife (for syringe), mixing tool/applicator (e.g. small flat plastic or wooden stick), discardable surface (e.g. foil, paper).

Safety Precautions:

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

Surfaces must be clean, dry and free from oil, wax and paint. Roughen smooth surfaces for better adhesion. Pre-fit parts to be joined. Remove the plug from between the piston. Cut off the end tips of the syringe. Depress the double piston to dispense equal parts of the two materials on a discardable surface. Mix resin and hardener thoroughly. Wipe syringe tips clean, retract piston slightly and close with the plug. Ensure that the plug is always placed in the same orientation on the tips.

Application:

Apply a small amount to both surfaces, join and press together. Remove any excess glue immediately with acetone. Support until bond sets in 60 minutes at room temperature. Usable strength in 24 hours.

Clean-up:

Clean excess glue immediately with acetone. Cured adhesive may be cut away using a sharp blade with caution. Prolonged immersion in paint stripper may soften the cured adhesive to aid removal.

PRECAUTIONS

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.

STORAGE AND DISPOSAL

MAY IRRITATE EYES AND SKIN. Do not get in eyes or on skin. May cause allergic skin reaction. **KEEP OUT OF REACH OF CHILDREN.**
FIRST AID TREATMENT: Contains diethylenetriamine. If swallowed, call Poison Control Centre or doctor immediately. Do not induce vomiting. If in eyes rinse well with water for at least 15 minutes. If on skin, rinse well with water.

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>Color:</u>		<u>Set Time:</u>	45 to 60 minutes
<u>Hardener:</u>	Clear amber	<u>Curing Time:</u>	24 hours
<u>Resin:</u>	Clear	<u>Odor:</u>	Amine
<u>Appearance:</u>	Liquid		
<u>Base:</u>	Epoxy resin / Amine compound		
<u>Specific Gravity:</u>			
<u>Hardener:</u>	1.00		
<u>Resin:</u>	1.17		
<u>Flash Point:</u>			
<u>Hardener:</u>	212°F (100°C)		
<u>Resin:</u>	> 480°F (249°C)		
<u>VOC Content:</u>	0.1% by weight (Resin & hardener mixed)		
<u>Shelf Life:</u>	24 months from date of manufacture (unopened)		

Lot Code Explanation: For Example:

L36FAC569

6 = Last Digit in the Year of Manufacture
6 = 2006
(i.e. 7 = 2007, 8 = 2008, 9 = 2009, etc)

F = Month within Year of Manufacture
F = 7th Letter of Alphabet
F = July
(i.e. A = Jan, B = Feb, C = March, etc)

Typical Cured Performance Properties

<u>Color:</u>	Clear amber
<u>Sandable:</u>	Yes
<u>Hardness, Shore D:</u>	81 ± 1
<u>Service Temperature:</u>	-10°F to 302°F (-23°C to 150°C)
<u>Tensile Shear Strength:</u>	
Cold Rolled Steel, Sandblasted:	
4 hours:	1595 ± 189 psi
6 hours:	2845 ± 34 psi
24 hours:	2910 ± 818 psi
Aluminum, Sandblasted:	
24 hours:	1830 ± 34 psi
<u>Compressive Shear Strength, 24 hours:</u>	
Hard PVC (White), Sanded:	1406 ± 372 psi
ABS:	1680 ± 379 psi
Acrylite FF, Sanded:	1458 ± 236 psi
Maple:	1345 ± 283 psi
<u>Water Resistance – Tensile:</u>	
(Aluminum, 7 day cure)	
24 hour Immersion:	1704 ± 543 psi
7 day Immersion:	1992 ± 36 psi
<u>Solvent Resistance – Tensile:</u>	
(Aluminum, 7 day cure)	
Gasoline, 24 hour Immersion:	2420 ± 263 psi