



# TECHNICAL DATA SHEET



**Henkel Corporation**  
Professional and Consumer Adhesives  
Rocky Hill, CT 06067  
Phone 1-800-624-7767  
Fax (440) 250-9661  
[www.henkel.com](http://www.henkel.com) [www.loctiteproducts.com](http://www.loctiteproducts.com)



Item #	Package	Size
1405603	Carded Syringe	0.85 fl. oz.

## 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 making it 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, polytetrafluoroethylene (PTFE)/Teflon® or flexible materials
- Applications requiring short-term heat exposure of greater than 302°F (150°C)
- Continuously wet areas or water immersion
- Potable water systems

## FEATURES & BENEFITS:

Feature	Benefits
Machinable.....	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.

### Preparation:

Surfaces must be clean, dry and free from oil, wax and paint. Roughen smooth surfaces for better adhesion by sandblasting or sanding with emery cloth. Wash glass and ceramic surfaces with soap and water then rinse and let dry. Pre-fit parts to be joined. Remove the plug between the piston. Cut off the end tips of the syringe. Turn syringe end up and pull plunger back slightly allowing air bubbles to rise to top. Press plunger to expel air. Depress the double piston to dispense equal parts of the two materials on a disposable surface. 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. Mix resin and hardener for one minute thoroughly.

**Application:**

Apply a small amount of mixed adhesive to both surfaces, join and press together. Remove any excess glue immediately with acetone. Support until bond sets (approx. 60 minutes) at room temperature. Leave undisturbed for 3 hours. Usable strength in 24 hours.

**Clean-up:**

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:** Hardener contains polyamide resin, amorphous silica and amine curing agents. Resin contains epoxy resin. Do not get in eyes or on skin. Do not breathe vapors.  
**FIRST AID:** For eye contact, flush with water for 15 minutes, call a physician. For skin contact, wash thoroughly with soap and water, 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>Color:</u>		<u>Application Temperature:</u>	39°F (4°C) to 95°F (35°C)
Hardener:	Clear amber	<u>Odour:</u>	Amine
Resin:	Clear	<u>Gel Time:</u>	4 to 10 minutes
<u>Appearance:</u>	Liquid	(5 g : 5g)	(Gel time is dependent upon temperature and the amount of adhesive used)
<u>Base:</u>	Epoxy resin / Amine compound	<u>Full Cure Time:</u>	24 hours
<u>Specific Gravity:</u>			Note: Cure time is dependent upon temperature, humidity and amount of product used.
Hardener:	1.00		
Resin:	1.17		
<u>Flash Point:</u>			
Hardener:	212°F (100°C)		
Resin:	> 480°F (249°C)		
<u>VOC Content:</u>	0.1% by weight		
(Resin & Hardener)			
<u>Shelf Life:</u>	24 months from date of manufacture (unopened)		
<u>Lot Code Explanation:</u>	For Example:  LB <u>3</u> FAC569		
(Lot Code is stamped on back of syringe label)	3 = Last Digit in the Year of Manufacture 3 = 2013 (i.e. 1 = 2011, 2 = 2012, 3 = 2013, etc)  F = Month produced (see chart to the right) F = 6 <sup>th</sup> Letter of Alphabet F = June	A – January B – February C – March D – April E – May F – June	G – July H – August J – September (there is no I) K – October L – November M – December

## Typical Cured Performance Properties

<u>Color:</u>	Clear amber
<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>Water Resistant:</u>	Yes
<u>Sandable:</u>	Yes
<u>Paintable:</u>	No but can be tinted using earth pigments, cement or sand
<u>Hardness, Shore D:</u>	81 ± 1
<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 Shear Strength:</u>	
(Aluminum, Sandblasted, 7 day cure)	
Followed by 24 hour Water Immersion:	1704 ± 543 psi
Followed by 7 day Water Immersion:	1992 ± 36 psi
<u>Solvent Resistance - Tensile Shear Strength:</u>	
(Aluminum, Sandblasted, 7 day cure)	
Followed by 24 hour Gasoline Immersion:	2420 ± 263 psi
<u>Side Impact Resistance:</u>	3.5 Joules
(Cold Rolled Steel, Sandblasted, 1"x1", 7 day cure)	