



TECHNICAL DATA SHEET



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Item #	Package	Size
1365736	Carded Bottles	2 x 4 fl. Oz.

DESCRIPTION:

Loctite® Epoxy Heavy Duty is a two-part adhesive consisting of an epoxy resin and a hardener. When mixed in equal volumes, resin and hardener react to produce a tough, rigid, high strength bond in 5 minutes for most projects. It can be used as an adhesive for a wide range of materials or as a versatile filler for gap bonding, surface repairs and laminating. Loctite® Epoxy Heavy Duty 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:

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

NOT RECOMMENDED FOR:

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

FEATURES & BENEFITS:

Feature	Benefits
High impact resistant.....	Won't crack when drilled
Can be tinted.....	Match surrounding materials
Water resistant.....	Can be used outdoors
Does not shrink.....	One-time application
Sets in 5-10 minutes.....	Quick completion of project

DIRECTIONS:

Tools Typically Required:

Utility knife, mixing tool/applicator (e.g. wooden stick), disposable surface, (e.g. foil or paper cup).

Safety Precautions:

Well-ventilated area, gloves.

Preparation:

Surfaces must be clean, dry and free from oil, wax and paint. Roughen smooth surfaces for better adhesion. Pre-fit parts to be joined. Dispense equal amounts of resin and hardener on a disposable surface. Recap bottles at once ensuring that the correct cap goes back on the correct bottle. Interchanging caps will make future cap removal impossible. Mix resin and hardener for one minute thoroughly.

Application:

For best results apply a small amount to both surfaces within one to two minutes of mixing adhesive and press together. Placing parts together close to the 5 minute set time will reduce adhesion. Remove any excess glue immediately with acetone. Support bond for 10 minutes at room temperature. Usable strength achieved in 8 hours. Fully cured in 24 hours.

Clean-up:

Clean excess glue immediately with acetone. 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.

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

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>	5 minutes depending on temperature and amount of adhesive used.
Hardener:	Opaque		
Resin:	Clear	<u>Usable Strength:</u>	8 hours
<u>Base:</u>	Epoxy resin / Polymercaptan hardener	<u>Full Cure Time:</u>	24 hours
<u>VOC Content:</u>	0.026% (resin and hardener combined)	<u>Odor:</u>	Mercaptan
<u>Specific Gravity:</u>			
Hardener:	1.04		
Resin:	1.17		
<u>Viscosity:</u>			
Hardener:	20,000 – 30,000 cps		
Resin:	18,000 – 30,000 cps		
<u>Flash Point:</u>			
Hardener:	250°F (121°C)		
Resin:	400°F (204°C)		
<u>Shelf Life:</u>	24 months from date of manufacture (Unopened)		
<u>Lot Code Explanation:</u>	YYDDD YY = Last two digits of year of manufacture DDD = Day of manufacture based on 365 days in a year For example: 09061 = 61 st day of 2009 = March 2, 2009		

Typical Cured Performance Properties

<u>Colour:</u>	Clear to amber
<u>Sandable:</u>	Yes
<u>Service Temperature:</u>	-23°C (-10°F) to 49°C (120°F)
<u>Shore D Hardness, 24 hours:</u>	76 ± 1
<u>Typical Tensile Shear Strength:</u> (Cold Rolled Steel, Sandblasted)	
30 minutes:	483 ± 129 psi
1 hour:	1073 ± 150 psi
4 hours:	3320 ± 149 psi
24 hours:	3597 ± 71 psi
<u>Compression Shear Strength, 24 hour:</u>	
Maple:	1771 ± 94 psi
Acrylic (Hard):	637 ± 191 psi
PVC (Hard):	748 ± 106 psi