



10 Minute™ Epoxy (Black/Clear)

Description:	Flexible epoxy with good impact resistance, peel strength, and excellent chemical resistance.				
Intended Use:	Sign/display, appliance, metalworking, and furniture industries.				
Product features:	Good impact resistance Self-leveling liquid High shear strength				
Limitations:	None				
Typical Physical Properties:	<i>Technical data should be considered representative or typical only and should not be used for specification purposes.</i>				
	Cured 7 days @ 75° F	TESTS CONDUCTED			
	Adhesive Tensile Lap Shear[GBS]	2,400 psi @ 0.010" bondline	Cured Hardness Shore D ASTM D 2240		
	Dielectric Strength	800 volts/mil	T-Peel Strength ASTM D 1876		
	Gap Fill	Good	Tensile Strength (Epoxies) ASTM D 638		
	Impact Resistance	10 ft.lb./in.(2)			
	Service Temperature	-67°F to 200°F			
	Shore Hardness	75 Shore D			
	Solids by Volume	100			
	Specific Volume	24.6 in.[3]/lb.			
	Tensile Elongation	5%			
	Tpeel	20-25 pli			
	Uncured				
	Color	Black and Clear			
	Fixture Time	20 min. @ 72°F			
	Full Cure	12 hrs.			
	Functional Cure	1.5 hrs. @ 72°F			
	Mix Ratio by Volume	1:1			
	Mix Ratio by Weight	100/99			
	Mixed Density	9.42 lbs./gal.: 1.13 gm/cc			
	Mixed Viscosity	Black: 90,000 cps; Clear: 80,000 cps			
	Working Time	10 min. [28 gm. @ 72°F]			
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.				
Mixing Instructions:	---- Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. ----				
	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

Acetic (Dilute) 10%	Poor
Ammonia	Poor
Corn Oil	Very good
Cutting Oil	Very good
Ethanol	Poor
Gasoline (Unleaded)	Fair
Glycols/Antifreeze	Very good
Hydrochloric 10%	Poor

Isopropanol	Poor
Mineral Spirits	Very good
Motor Oil	Very good
Sodium Hydroxide 10%	Poor
Sodium Hypochlorite	Very good
Sulfuric 10%	Poor

Precautions:

Please refer to the appropriate safety data sheet (SDS) prior to using this product.

For technical assistance, please call 1-855-489-7262

FOR INDUSTRIAL USE ONLY

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.

Disclaimer:

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Performance Polymers makes no representations or warranties of any kind concerning this data.

Order Information:

14255 50 ml cartridge (Black)
14251 50 ml cartridge