



Moulding and Casting Materials

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British United Industries (Vic) Pty Ltd ATF Byrne Hughes Family Business Trust Trading as Solid Solutions Group ABN 46 977 073 014 ACN 006 303 591

5 MINUTE EPOXY ADHESIVE 142

PRODUCT DESCRIPTION:

5 Minute Epoxy 142 is a two component, 100% solids non-shrinking adhesive, suitable for use on timber, glass, stone, fibreglass, ferrous and non-ferrous metals, most hard plastics, ceramic, cement, plaster and brick.

Resultant bonds are strong and permanent, being resistant to abrasion, impact, water and a range of corrosive chemicals, including acids, alkalis and petroleum solvents.

PHYSICAL PROPERTIES:

Colour	Compound - clear straw liquid Hardener - clear amber liquid
Mixing Ratio	1 part Component "A" to 1 part Component "B"
Viscosity of Mix	Free flowing liquid
Pack Size	1 Litre
Bulk Density of Mix	1,200 kg. per cubic metre
Coverage	1.2 kg. of mixed product covers 1 sq. metre at 1mm thickness
Pot Life of 500g mix	5 minutes at 25 degrees Celsius
Tack Free time of 1mm Film	10 minutes at 25 degrees Celsius
Maximum Service Temperature	60 degrees Celsius
Normal Service Cure	30 minutes at 25 degrees Celsius

MECHANICAL PROPERTIES:

Compressive Strength	27 MPa
Tensile Strength	7.0 MPa after 10 minutes at 25 degrees Celsius 14.0 MPa after 30 minutes at 25 degrees Celsius



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SURFACE PREPARATION:

Adequate surface preparation is essential for the achievement of maximum bond strengths. The main requirements are that surfaces be clean, rough, reasonably dry and free from loose material. Concrete surfaces can be sandblasted, scabbled, detergent scrubbed or etched, depending upon condition.

MIXING DIRECTIONS:

Mix thoroughly equal parts by weight or volume of compound and hardener in a clean mixing vessel, using a spatula or similar blade. Only mix sufficient for immediate use. Do not mix full kits in view of extremely short pot life.

APPLICATION:

Ensure that the surfaces to be bonded have been correctly prepared prior to mixing. Using a putty knife, paint scraper or small trowel, apply mixed 5 Minute Epoxy Adhesive 142 to both bonding surfaces. A rubber bladed squeegee can be used to thoroughly 'wet out' the surfaces and spread the mix evenly. Clamping is not necessary, however the bond may require some support whilst curing.

5 Minute Epoxy Adhesive 142 may be sanded, sawn, drilled or painted after 15 minutes curing at 25 degrees Celsius. Curing is adversely affected by lower temperatures and external heating may be required to raise job temperature to 20-30 degrees Celsius.

CLEAN UP:

Remove excess adhesive immediately after application. Clean tools with toluene, xylene or methyl ethyl ketone (M.E.K.).

STORAGE DIRECTIONS:

Storage Life 12 months

Keep containers closed tightly when not in use.

Do not interchange lids or in other ways contaminate Compound with Hardener or vice versa.

Do not store in conditions of excessive heat or cold.

If separation occurs after long storage, stir each component thoroughly before use.

HANDLING INSTRUCTIONS:

Avoid direct skin contact. Gloves and overalls should be worn. Should direct contact occur, wash affected areas thoroughly with soap and water. Do not use solvents to remove product from skin. Respirators should be worn in confined areas or in the case of prolonged exposure to vapours. Contaminated clothing should be laundered as soon as possible.