

4-MINUTE EPOXY PART NO. 49409A

PHYSICAL PROPERTIES

Cured 7 days @ 75°F

T-peel.....	2-3 pli
Impact Resistance	5.5 ft. lb. /in. (2)
Tensile Elongation	1%
Shore Hardness	85 Shore D
Gap-Fill	Good
Dielectric Strength	490 volts/mils
% Solids by Volume.....	100
Adhesive Tensile Lap Shear (GBS)	1900 psi @ 0.005" bond line
Specific Volume	25.1 in. (3)/lb.

Uncured

Color.....	Light Amber
Mixed Viscosity	10,000 cps
Mix Ratio by Volume	1:1
Mix Ratio by Weight.....	1:1
Mixed Density.....	9.17 lbs. /gal.: 1.10 gm/cc
Working Time.....	3-6 min. (28 gm @ 72°F
Fixture Time.....	10-15 min. @ 72°F
Functional Cure	¾ -1 hr. @ 72°F
Full Cure	12
Service Temperature.....	Dry, -40°F to 200°F

Tests Conducted

Adhesive Tensile Shear ASTM D 1002
Dielectric Strength, volts/mil ASTM D 149
Cured Hardness Shore D ASTM D 2240
Cured Density ASTM D 792

DESCRIPTION

Dynatex® 4-Minute Epoxy is a rapid-curing, general purpose adhesive/encapsulant. It bonds rigid, durable substrates such as metals, ceramics, glass, concrete, and wood in all combinations. It forms a clear, hard, rigid bond coating in minutes. Pre-measured syringe assures proper mix for consistent results.

FEATURES

- Bonds rigid durable substrates such as metals, glass, ceramics, concrete and wood in all combinations
- Forms a clear hard rigid bond self leveling liquid in minutes
- Easy to use pre-measured syringe
- Functional cure in 1 hour
- 100% reactive, no solvents
- Good solvent resistance
- Low viscosity (10,000 cps)

TYPICAL APPLICATIONS

- Bond parts and accessories for do-it-yourself projects and hobbies
- Bond porcelain or metal designs to wood, marble, concrete and many other materials
- Mend china wares and pottery

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

1. Snap off nozzle tip.
2. Depress plunger to dispense.
3. Mix thoroughly for 2 minutes.
4. Apply to surfaces to be repaired with a putty knife or other appropriate tool.
5. Epoxy sets in approximately 4 minutes – full strength approximately 60 minutes. Do not disturb repair for at least 20 minutes.
6. Immediately remove excess epoxy.
7. Attach cap after each use.

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.

CHEMICAL RESISTANCE

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion @ 75°F)

Acetic (Dilute) 10%	Poor
Acetone	Poor
Ammonia	Poor
Corn Oil	Excellent
Cutting Oil.....	Excellent
Ethanol	Poor
Gasoline (Unleaded)	Excellent
Glycols/Antifreeze.....	Fair
Hydrochloric 10%.....	Poor
Isopropanol.....	Poor
Kerosene	Excellent
Methyl Ethyl Ketone.....	Poor
Mineral Spirits	Excellent
Motor Oil.....	Excellent
Sodium Hydroxide 10%	Poor
Sulfuric 10%	Poor

STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), **Dynatex® 4-Minute Epoxy** has a shelf life of 12 months from date of shipment.

In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity. Cartons should always be stacked upright. **DO NOT** stack cartons on their side. **NEVER** stack cartons more than 8 high. **DO NOT** store within 1 meter (4 feet) of roofline of the warehouse or storage building.

USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

Likewise, if the application, product specifications or manner in which our products are used require government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

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Suggestions of uses should not be taken as inducements to infringe any patents.

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