



TECHNICAL DATA SHEET

LEPAGE® SPEED SET™ EPOXY

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Item #	Package	Size
1418137	Carded Syringe	25 mL

DESCRIPTION

LePage® Speed Set™ Epoxy is a two-part adhesive consisting of an epoxy resin and a hardener. When mixed in equal volumes, the resin and hardener react to produce a tough, rigid, high strength bond in 5 minutes for most projects. Available in a convenient dual syringe which delivers equal parts of both components every time. LePage® Speed Set™ Epoxy can be used as an adhesive for a wide range of materials or as a versatile filler for gap filling, surface repairs and laminating. LePage® Speed Set™ Epoxy 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
- Applying at temperatures below 4°C (39°F) and above 35°C (95°F)
- Continuously wet areas or water immersion

FEATURES & BENEFITS

Feature	Benefits
High impact resistance.....	Won't crack when drilled
Can be tinted.....	Matches surrounding materials
Water-resistant.....	Can be used outdoors
Does not shrink.....	One-time application
Convenient syringe.....	Dispenses equal amounts of each component every time
Sets in 5-10 minutes.....	Quick completion of project

DIRECTIONS

Tools Typically Required:

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

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. Pre-fit parts to be joined. Remove the plug from 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. 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:

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.

PRECAUTIONS

DANGER: Resin contains epoxy resin. Hardener contains polymercaptan, amorphous silica and amine curing agents. 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.**

WARNING: This product contains a chemical known to the State of California to cause cancer.

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>Colour:</u>		<u>Gel Time:</u>	4 to 10 minutes
Resin:	Colourless	(5 g : 5g)	(Gel time is dependent upon temperature and the amount of adhesive used.)
Hardener:	Light Yellow		
<u>Base:</u>	Epoxy resin / Polymercaptan hardener	<u>Application Temperature:</u>	4°C (39°F) to 35°C (95°F)
<u>Specific Gravity:</u>		<u>Usable Strength:</u>	1 hour
Hardener:	1.04		
Resin:	1.17	<u>Full Cure Time:</u>	24 hours
<u>Viscosity:</u>			Note: Cure time is dependent upon temperature, humidity and amount of product used.
Hardener:	20,000 – 35,000 cps		
Resin:	15,000 – 40,000 cps		
<u>Flash Point:</u>			
Hardener:	93°C (200°F)		
Resin:	> 249°C (480°F)		
<u>VOC Content:</u>	0.098% by weight		
(Resin & Hardener)			

Typical Cured Performance Properties

<u>Colour:</u>	Clear to amber
<u>Sandable:</u>	Yes
<u>Service Temperature:</u>	-23°C (-10°F) to 150°C (302°F)
<u>Shore D Hardness (7 days):</u>	80 ± 1
<u>Tensile Shear Strength:</u>	
Cold Rolled Steel, Sandblasted	
1 hour:	1322 ± 128 psi
4 hours:	2494 ± 78 psi
24 hours:	3437 ± 58 psi
7 days:	3426 ± 155 psi
Aluminum, Sandblasted, 24 hours:	2055 ± 290 psi
<u>Compression Shear Strength – 24 hours:</u>	
Hard PVC (White), Sanded:	1081 ± 199 psi
Acrylite FF, Sanded:	958 ± 268 psi
Maple:	2088 ± 243 psi
<u>Water Resistance – Tensile Shear Strength:</u>	
(Aluminum, Sandblasted, 7 day cure)	
7 day Water Immersion:	2048 ± 160 psi
<u>Solvent Resistance - Tensile Shear Strength:</u>	
(Aluminum, Sandblasted, 7 day cure)	
Gasoline, 24 hour Immersion:	3216 ± 275 psi
<u>Side Impact Resistance:</u>	6.8 Joules
(Cold Rolled Steel, Sandblasted, 1"x1", 7 day cure)	