



TECHNICAL DATA SHEET

Revision: 01/15/2023
Supersedes: 05/07/2015
Ref. #: 248643 / 352971

LEPAGE® SPEED SET® Professional Epoxy



DESCRIPTION

LePage® SPEED SET® Professional Epoxy 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. LePage® SPEED SET® Professional Epoxy is chemically curing and does not shrink. It can be tinted with earth pigments, cement, or sand for colour matching. It can be sanded and drilled once cured.

Available As:

Item #	Package	Size
2758388	Carded Bottles	2 x 118 mL

FEATURES & BENEFITS

- 5 minute set time
- High impact resistance
- Machinable
- Resistant to water and most chemicals
- Will not shrink or expand

RECOMMENDED FOR

LePage® SPEED SET® Professional Epoxy bonds metal, glass, ceramic, wood, china, tile, fiberglass, concrete, stone, and many rigid plastics. Can be combined with fiberglass cloth for a durable patch.

LIMITATIONS

- Not for use on nylon, polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE) / Teflon®, or flexible materials
- Not suitable for applications requiring short-term heat exposure greater than 150°C (302°F)
- Not suitable for potable water systems
- Not suitable for continuously wet areas or water immersion

TECHNICAL DATA

Typical Uncured Physical Properties		Typical Application Properties	
<u>Resin Color:</u>	Translucent, Clear	<u>Application Temperature:</u>	Use between 4°C (39°F) and 35°C (95°F)
<u>Hardener Color:</u>	Translucent, Amber	<u>Odor:</u>	Amine
<u>Appearance:</u>	Liquid	<u>Gel Time: (5g : 5g)</u>	4 – 5 minutes*
<u>Base:</u>	Amine, Polymercaptan Hardener & Epoxy Resin	<u>Useable Strength:</u>	20 minutes*
<u>Flash Point:</u>	Resin >249°C (>480.2°F) Hardener >93°C (>199.4°F)	<u>Cure Time:</u>	24 hours*
<u>Specific Gravity:</u>	1.17 (Resin); 1.08 – 1.18 (Hardener)	<u>Clean Up:</u>	Clean excess adhesive immediately by wiping with clean cloth. Acetone may be used to assist in removal. Cured adhesive may be carefully cut away with a sharp-edged tool.
<u>VOC Content:</u> (Mixed A and B)	<3.77% by weight CARB <0.38 g/l SCAQMD		

* Time is dependent upon temperature, humidity, and amount of adhesive used



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Shelf Life: 24 months from date of manufacture (unopened)

Lot Code Explanation: LB2FAC56 (Example)

2 = Last digit in the year of manufacture; 2 = 2022
F = Month produced (see chart on right); F = June
June 2022 is the date of manufacture

9: 2019
0: 2020
1: 2021
2: 2022
3: 2023

A – January
B – February
C – March
D – April
E – May
F – June

G – July
H – August
J – September
K – October
L – November
M – December

Typical Cured Performance Properties

Color: Clear to amber

Cured Form: Non-flammable solid

Hardness: 76 ± 1, Shore D

Sandable: Yes

Service Temperature: -23°C (-9°F) to 49°C (120°F)
-23°C (-9°F) to 150°C (302°F)

Water Resistant: Yes, when fully cured

Paintable: No, but can be tinted using earth pigments, cement, or sand

Long-Term (Continuous) Exposure
Short-Term (Intermittent) Exposure

Tensile Shear Strength:

Cold Rolled Steel, Sandblasted:

1 hour cure: 3.33 ± 0.89 N/mm² (483 ± 129 psi)
4 hour cure: 7.40 ± 1.03 N/mm² (1073 ± 150 psi)
24 hour cure: 22.90 ± 1.03 N/mm² (3320 ± 149 psi)
7 day cure: 24.80 ± 0.49 N/mm² (3597 ± 71 psi)

Aluminum, Sandblasted:

24 hour cure: 18.00 ± 2.98 N/mm² (2608 ± 432 psi)
7 day cure, 7 day water immersion: 17.10 ± 0.79 N/mm² (2484 ± 114 psi)

Compressive Shear Strength: 24 hour cure

Sanded Hard PVC (White): 5.16 ± 0.73 N/mm² (748 ± 106 psi)
Sanded Hard Acrylic: 4.39 ± 1.32 N/mm² (637 ± 191 psi)
Maple: 12.2 ± 0.65 N/mm² (1771 ± 94 psi)

DIRECTIONS

Tools Typically Required:

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

Safety Precautions:

Wear gloves, safety glasses, and wash hands after use. Apply and cure in a well-ventilated area.

Preparation:

Surfaces must be clean, dry, free from dirt, grease, wax, paint, rust, etc. For better adhesion, roughen smooth surfaces with sandpaper. Wash glass and plastic surfaces with soap and water then rinse and let dry. Pre-fit parts to be joined. Unscrew nozzles and remove seal. Replace nozzles, remove caps, and cut tips. Dispense equal amounts of resin and hardener on a disposable surface. Prepare as much as can be used in 5 minutes. Recap bottles at once ensuring that the correct cap goes back on the correct bottle. Interchanging caps will make future cap removal impossible as curing may occur. Mix resin and hardener thoroughly for one minute.



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DIRECTIONS

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 mineral spirits, acetone, or rubbing alcohol (follow all solvent manufacturer's precautions). Support surfaces until bond sets (approx. 5 minutes). Usable strength achieved in 20 minutes. Fully cured in 24 hours.

Clean up:

Clean excess glue immediately by wiping with clean cloth. Acetone may be used to assist in removal. 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. Note: Acetone is highly flammable and not compatible with all surfaces. Follow manufacturer's instructions and test on small area before applying.

STORAGE & 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

CAUTION. IRRITANT. MAY IRRITATE EYES AND SKIN. May cause allergic skin reaction. Do not get in eyes or on skin or clothing.

KEEP OUT OF REACH OF CHILDREN.

FIRST AID TREATMENT: Resin contains epoxy resin. Hardener contains polymercaptan and amine curing agents. If swallowed, call Poison Control Centre or doctor immediately. Do not induce vomiting. If in eyes rinse, with water for at least 15 minutes. If on skin, rinse well with water.

Refer to the Safety Data Sheet (SDS) for further information

LIMITED WARRANTY

This product is warranted to be free from defects in materials when used as directed. Henkel's sole obligation shall be, at its option, to replace or refund the purchase price of product proven to be defective. Henkel makes no other warranty, express or implied, including warranties of MERCHANTABILITY and FITNESS FOR A PARTICULAR PURPOSE and will not be liable for consequential or incidental damages. This limited warranty gives you specific legal rights, which vary from state to state. Henkel may be contacted at 1.800.624.7767 M-F 9:00 am to 4:00 pm ET for warranty assistance.

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. Henkel recommends purchasers/users should test the products to determine acceptable quality and suitability for the intended use. All adhesive/sealant applications should be tested under simulated or actual end use conditions to ensure the adhesive/sealant meets or exceeds all required project specifications. Since assembly conditions may be critical to adhesive/sealant performance, it is also recommended that testing be performed on specimens assembled under simulated or actual production conditions. 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.



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