



Epoxy Extra Time

Description: Loctite Epoxy Extra Time is a two-part system consisting of an epoxy resin and a hardener available in a convenient dual syringe. When mixed in equal volumes, resin and hardener react to produce a tough, rigid, high strength bond. Loctite Epoxy Extra Time sets in 60 minutes making it excellent for complex multi-piece assemblies. It is used as an adhesive for a wide range of materials or as a versatile filler for gap bonding, surface repairs and laminating. Loctite Epoxy Extra Time does not shrink and is resistant to water and most common solvents. It can be tinted with earth pigments, cement or sand for color matching. It can be sanded and drilled.

Available As:

Item #	Size	Package
1405603	0.85 fl oz (25 ml)	Carded Syringe

Features & Benefits:

- 60 Minute Set Time
- More Time to Align
- Machinable
- Water Resistant
- Translucent Yellow
- Will Not Shrink or Expand

Recommended For:

Loctite Epoxy Extra Time bonds metal, glass, ceramic, wood, many rigid plastics, china, tile, fiberglass, concrete and stone. Can be used with fiberglass cloth for durable patch.

Limitations:

- Not recommended for polyethylene, polypropylene, non-stick coatings, nylon products or flexible materials
- Not suitable for applications requiring short-term heat exposure greater than 302°F (150°C)
- Not suitable for continuously wet areas or water immersion
- Not suitable for potable water systems



TECHNICAL DATA SHEET

Typical Uncured Physical Properties:

Color:	Hardener:	Clear amber	
	Resin:	Clear	
Base:		Epoxy resin / Polymercaptopan hardener	
Odor:		Mild amine	
Specific Gravity:	Hardener:	1.00	
	Resin:	1.17	
Flash Point:	Hardener:	212°F (100°C)	
	Resin:	> 480°F (249°C)	
VOC Content (Resin & Hardener):		0.1% by weight	CARB
Shelf Life:		24 months from date of manufacture (unopened)	
Lot Code Explanation:		For Example:	
Stamped on back of syringe label		LB6FAC569	
		6 = Last Digit in the Year of Manufacture	A – January
		6 = 2016 (i.e. 5 = 2015, 6 = 2016, etc.)	B – February
		F = Month produced (see chart at right)	C – March
		F = June	D – April
		June 2016 is the date of manufacture	E – May
			F – June
			G – July
			H – August
			J – September
			K – October
			L – November
			M – December

Typical Application Properties:

Application Temperature:	Apply between 39°F (4°C) and 95°F (35°C)
Gel Time (2g : 2g):	45 to 60 minutes*
Handling Time:	3 hours*
Full Cure Time:	24 hours*
	*Time is dependent on temperature, humidity and thickness of epoxy applied

Typical Cured Performance Properties:

Color:	Clear amber	
Cured Form:	Non-flammable solid	
Service Temperature:	-10°F (-23°C) to 120°F (49°C) -10°F (-23°C) to 302°F (150°C)	Long Term (Continuous) Exposure Short Term (Intermittent) Exposure
Water Resistant:	Yes	
Sandable:	Yes	
Paintable:	No but can be tinted using earth pigments, cement or sand	
Hardness:	81 ± 1	Shore D
Tensile Shear Strength:		
Cold Rolled Steel, Sandblasted:		
4 hour cure:	1595 ± 189 psi (11 ± 1.30 N/mm ²)	
6 hour cure:	2845 ± 34 psi (19.6 ± 0.2 N/mm ²)	
24 hour cure:	2910 ± 818 psi (20.1 ± 5.6 N/mm ²)	
Aluminum, Sandblasted:		
24 hour cure:	1830 ± 34 psi (12.6 ± 0.2 N/mm ²)	
7 day cure, 24 hr water immersion:	1704 ± 543 psi (11.7 ± 3.7 N/mm ²)	
7 day cure, 8 day water immersion:	1992 ± 36 psi (13.7 ± 0.2 N/mm ²)	
Compressive Shear Strength:		24 hour cure
Sanded Hard PVC (White):	1406 ± 372 psi (9.7 ± 2.6 N/mm ²)	
Sanded Acrylite FF:	1458 ± 236 psi (10.1 ± 1.6 N/mm ²)	
Maple:	1345 ± 283 psi (9.3 ± 2.0 N/mm ²)	
ABS:	1680 ± 379 psi (11.6 ± 2.6 N/mm ²)	



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Solvent Resistance: Gasoline:	2420 ± 263 psi (16.7 ± 1.8 N/mm ²)	Tensile Shear Strength Aluminum, 7 day cure 24 hour solvent immersion
Side Impact Resistance:	3.5 Joules	Sandblasted Cold Rolled Steel 1" x 1", 7 day cure

Directions:

Tools Typically Required:

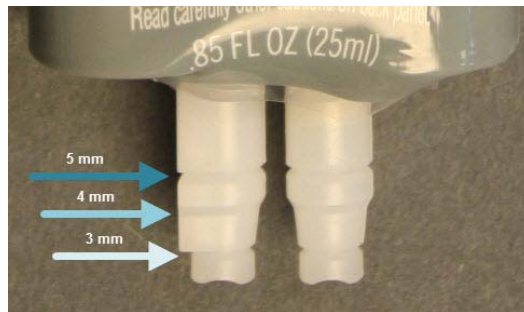
Utility knife, mixing tool/applicator (e.g. small flat plastic or wooden stick), disposable surface (e.g. foil).

Safety Precautions:

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

Preparation:

Surfaces must be clean, dry and free from oil, wax, paint, rust, etc. Roughen smooth surfaces for better adhesion by sandblasting or sanding with an emery cloth. Wash glass and ceramic surfaces with soap and water then rinse and let dry. Pre-fit parts to be joined. Remove the plug from between the piston. Cut off the end tips of the syringe at one of the three cut-off points as illustrated below. For easier extrusion, cut at the 4 mm or 5mm opening. For more precise application, cut at 3 mm opening.



Turn syringe end up and pull plunger back slightly allowing air bubbles to rise to top. Press the plunger to expel air. Depress the double piston to dispense equal parts of the two materials on a disposable surface. Mix resin and hardener thoroughly (about 1 minute). 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.

Application:

Apply a small amount of mixed adhesive to both surfaces, join and press together. Remove any excess glue immediately by wiping with acetone. Support until bond sets (approx. 60 minutes) at room temperature. Leave undisturbed for 3 hours. Usable strength in 24 hours. Moderate heat will speed hardening while cooler temperatures will require a longer set time.

Clean-up:

Clean excess glue immediately with acetone before adhesive sets. 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:

DANGER: Causes eye, skin and respiratory tract burns. May cause allergic skin reaction. May be harmful if swallowed or absorbed through skin.

DANGER Hardener contains polyamide resin, amorphous silica and amine curing agents. Resin contains epoxy resin. 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 REACH OF CHILDREN.**

WARNING: This product contains chemicals known to the State of California to cause cancer and/or birth defects and other reproductive harm.

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



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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.



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