



TECHNICAL DATA SHEET



Speed Set™ Epoxy

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.

Available As:

Item #	Size	Package
1418137	25 ml	Carded Syringe
1747985	25 ml	Carded Syringe

Features & Benefits:

- 5 Minute Set Time
- Dries Translucent Yellow
- Machinable
- Water Resistant
- Will Not Shrink or Expand

Recommended For:

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

For Best Results:

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



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Typical Uncured Physical Properties:

Color:			
Hardener:	Light Yellow		
Resin:	Colorless		
Base:	Polymercaptan Hardener / Epoxy Resin		
Odor:	Amine		
Specific Gravity:			
Hardener:	1.04		
Resin:	1.17		
Flash Point:			
Hardener:	>93°C (200°F)		
Resin:	>249°C (480°F)		
VOC Content:	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	LB4FAC569		
	4 = Last Digit in the Year of Manufacture	A – January	G – July
	4 = 2014 (i.e. 3 = 2013, 4 = 2014, etc.)	B – February	H – August
	F = Month produced (see chart at right)	C – March	J – September
	F = June	D – April	K – October
		E – May	L – November
	June 2014 is the date of manufacture	F – June	M – December

Typical Application Properties:

Application Temperature:	Apply between 4°C (39°F) and 35°C (95°F)		
Gel Time (5g : 5g):	4 to 10 minutes*		
Usable Strength:	1 hour*		
Cure Time:	24 hours*		
	*Times are dependent on temperature, humidity and amount of adhesive used		

Typical Cured Performance Properties:

Color:	Clear to amber		
Cured Form:	Non-flammable solid		
Service Temperature:	-23°C (-9°F) to 49°C (120°F) -23°C (-9°F) to 150°C (302°F)	Long Term Exposure Short Term Exposure	
Water Resistant:	Yes		
Sandable:	Yes		
Paintable:	No but can be tinted using earth pigments, cement or sand		
Hardness:	80 ± 1	Shore D	
Tensile Shear Strength:			
Cold Rolled Steel, Sandblasted:			
1 hour cure:	9.11 ± 0.88 N/mm² (1322 ± 128 psi)		
4 hour cure:	17.20 ± 0.54 N/mm² (2494 ± 78 psi)		
24 hour cure:	23.70 ± 0.40 N/mm² (3437 ± 58 psi)		
7 day cure:	23.62 ± 1.07 N/mm² (3426 ± 155 psi)		
Aluminum, Sandblasted:			
24 hour cure:	14.17 ± 2.0 N/mm² (2055 ± 290 psi)		
7 day cure, 7 day water immersion:	14.12 ± 1.10 N/mm² (2048± 160 psi)		
Compressive Shear Strength:	24 hour cure		
Sanded Hard PVC (White):	7.45 ± 1.37 N/mm² (1081 ± 199 psi)		
Sanded Acrylite FF:	6.61 ± 1.85 N/mm² (958 ± 268 psi)		
Maple:	14.40 ± 1.68 N/mm² (2088 ± 243 psi)		
Solvent Resistance:	Tensile Shear Strength		
24 hour gasoline immersion:	22.17 ± 1.90 N/mm² (3216 ± 275 psi)		Aluminum, 7 day cure
Side Impact Resistance:	6.8 Joules	Sandblasted Cold Rolled Steel 1" x 1", 7 day cure	



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Directions:

Tools Typically Required:

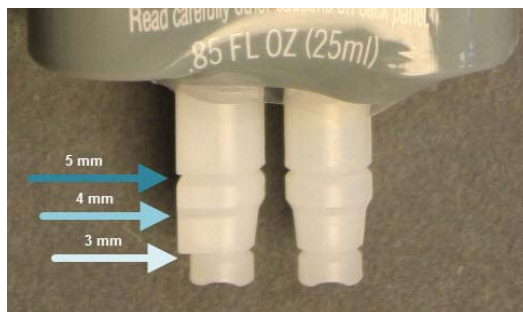
Utility knife, mixing tool/applicator (e.g. small flat plastic or wooden stick), disposable surface (e.g. foil, paper).

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:

For best results apply a small amount of mixed adhesive to both surfaces within one to two minutes of mixing and press together. Placing parts together close to the 5 minute set time will reduce adhesion. Remove any excess glue immediately. Support bond for 10 minutes at room temperature. Usable strength achieved in 1 hour. 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. Do not get in eyes or on skin. May cause allergic skin reaction. **KEEP OUT OF REACH OF CHILDREN. FIRST AID TREATMENT:** Contains epoxy resins, polymercaptan and amine curing agents. If swallowed, call Poison Control Centre or doctor immediately. Do not induce vomiting. If in eyes rinse well with water for at least 15 minutes. If on skin, rinse well with water.

Refer to 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.



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