

Taiwan Steel Ground Enterprise Co., Ltd.

No.51-3, Lane 280, Renlin Road, Renwu Township

Kaohsiung County, TAIWAN 815

TECHNICAL DATA

Product Name: 5 MINUTES CLEAR EPOXY LIQUID
Product Code: 903
Manufacturer: TAIWAN STEEL GROUND ENT. CO., LTD.
No.55, Lane 401, DaShe Road, DaShe Hsian
Kaohsiung County, Taiwan 815
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*** For information only - not for specification purposes. ***

TYPICAL PHYSICAL PROPERTISE	RESULTS	TEST METHOD
Cure 7 days@75°F		Adhesive Tensile Shear ASTM D 1002
T-peel	2-3 pli	Dielectric Strength, volts/mil ASTM D 149
Impact Resistance	5.5 ft.lb./in.(2)	Cure Hardness Shore D ASTM D 2240
Tensile Elongation	1%	
Shore Hardness	85 Share D	
Gap-Fill	Good	
Dielectric Strength	490 volts/mils	
% Solids by Volume	100	
Adhesive Tensile Lap Shear(GBS)	1900 psi @ 0.005" bondline	
Specific Volume	25.1 in(3)/lb	
Uncured		
Color	Light Amber	
Mixed Viscosity	10000 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	3/4- 1 hr. @ 72 °F	
Full Cure	12	
Service Temperature	Dry, - 40°F to 200°F	

Surface Preparation: Clean surface by solvent-wipping any deposit 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: Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths.

24ML TS-TUBE

1. Squeeze material into a small container size of an ashtray.
2. Using mixing stick included on TS-tube handle, vigorously mix components for one (1) minute.
3. Immediately apply to substrate.

Application Instructions:

1. Apply mixed epoxy directly to one surface in a an even film as a bead.
2. Assemble with mating part within recommended working time.
3. Apply firm pressure between mating parts minimize any gap and ensure good contact.

