



# NON-SAG FAST SETTING EPOXY GENERAL PURPOSE • NON-SAG EPOXY

PART NO. **EP5**

## DESCRIPTION

EP5 is a non-sag, two-component, opaque white colored, fast-setting epoxy adhesive that is used for sealing, gap filling, fixturing, and tacking for industrial and electrical applications. It bonds to aluminum, epoxy, glass, wood, and stone. It is thixotropic and sag resistant in a DOUBLE/BUBBLE® 4.5 g Packet. EP5 is an excellent, general-purpose adhesive.

## RECOMMENDED SUBSTRATES

Metals, Carbon Steel, Stainless Steel, Aluminum, Plastics, Epoxy, Stone, Wood, Glass, Ceramic, and Leather.

## TYPICAL USES

This non-sag, fast-setting epoxy can be used to repair tools, auto parts, electrical and electronic components, furniture and other applications that require a fast-setting adhesive. Ideal for quick, permanent, vertical and overhead repairs. For fixturing, tacking, sealing, gap filling and staking in electrical and industrial applications.

## GENERAL PROPERTIES

Technology / Base	Epoxy
Type of Product	Structural Adhesive
Components	Two-Component
Curing	Room Temperature (secondary thermal cure)
Appearance / Color	Opaque White
Consistency	Non-Sag Liquid

## PACKAGING

The DOUBLE/BUBBLE® package is a handy, dual-pouch, one-shot, job-size package design. It reduces the waste typically associated with the use of larger quantities of two-component adhesives. This unique packaging ensures that DOUBLE/BUBBLE® adhesives are always factory fresh and accurately portioned for optimum adhesive performance.

## CURING PROCESS

The cure schedule is dependent upon the temperature. The recommended cure schedule will vary with the desired properties.

## HANDLING & CLEANUP

See SDS for handling and clean-up information.

## SAFETY & DISPOSAL

See SDS for safety and disposal information.

## FEATURES & BENEFITS

- Room temperature cure
- Extra fast setting
- Non-sag formulation
- Excellent cohesive strength

## STORAGE

These materials should be stored in a dry environment within a temperature range of 16 °C to 27 °C (60°F to 80 °F). Extremes of temperature beyond this range may result in crystallization or polymerization of the materials.



## INSTRUCTIONS

The surface must be clean and dry before application. Remove all chemicals, dirt, wax, and oil. These materials are intended for industrial use only.

Fold the DOUBLE/BUBBLE® package along the center seal, snip the end, squeeze out the contents, mix thoroughly and apply.



FOLD

SNIP

SQUEEZE

MIX/APPLY

Avoid contamination with oxidized metals (such as copper, brass, or mild steel), and rust or other metal oxides. The stability of the product is greatly reduced by materials such as strong acids or bases, sulfur compounds, amines, or reducing agents of any type. Surfaces to be bonded must be clean, dry and free from grease, oil, wax, weak oxide films, and other contaminants.



## PHYSICAL PROPERTIES (UNCURED)

Rheology	Value	Condition/Method
Viscosity - Part A	465,000 cPs	at 25°C
Viscosity - Part B	400,000 cPs	at 25°C
Viscosity - Mixed	Thixotropic Paste	N/A
<b>Uncured Material Characteristics</b>		
Specific Gravity - Part A	1.19	N/A
Specific Gravity - Part B	1.15	N/A
Specific Gravity - Mix	1.17	N/A
Volume Mix Ratio	100 to 100	N/A
Weight Mix Ratio	100 to 94	N/A
Gel Time	3 to 5 min	at 25°C
Preparation Mass	N/A	4 gram
Handling Time	15 to 30 min	N/A
Full Cure	24 hours	at 23°C
Alternate Cure	24 hours	at 25°C (77°F)
Cure Process Note	N/A	The cure schedule is dependent upon the temperature. The recommended cure schedule will vary with the desired properties.
Shelf Life	12 months	Unopened
<b>Mechanical Properties During Cure</b>		
Overlap Shear Strength		
15 min at 25°C	346 psi	Aluminum, Acid Etched at 25°C
30 min at 25°C	717 psi	Aluminum, Acid Etched at 25°C
60 min at 25°C	1700 psi	Aluminum, Acid Etched at 25°C

## PHYSICAL PROPERTIES (CURED)

Cured Mechanical Properties	Value	Condition/Method
Hardness	83 Shore D	ASTM D2240
Tensile Strength	7,250 psi	ASTM D638
Elongation at Break	8.5%	ASTM D638
Overlap Shear Strength		
Aluminum, Acid Etched at 25°C	3712 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at -40°C	830 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 38°C	N/A	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 66°C	N/A	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 82°C	425 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 93°C	N/A	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 149°C	174 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 25°C, 15 min	346 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 25°C, 30 min	717 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 25°C, 60 min	1700 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 25°C, 24 hours	3712 psi	ASTM D1002, 25°C 50% RH
T-Peel Strength		
T-Peel Strength at 25°C	2.7 pli	Acid etched Al-Al
T-Peel Strength at -40°C	1.0 pli	Acid etched Al-Al
T-Peel Strength at 82°C	2.0 pli	Acid etched Al-Al
Operating Temperature	82°C (180°F)	N/A

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