



Technical Data Sheet

Permatex® PermaPoxy™ Clear General Purpose Epoxy Products

PRODUCT DESCRIPTION

Permatex® PermaPoxy™ products are two part, clear epoxy adhesive systems. PermaPoxy™ Clear General Purpose epoxies are of a maximum strength formula that is available in several working times. PermaPoxy™ is ideal for complex, multi-piece assemblies. They are water and solvent resistant and available in dual syringes or tubes.

PRODUCT BENEFITS

- Will not shrink
- Various curing cycles
- No clamping needed
- Fills gaps
- Nearly colorless
- Impact resistant
- Water resistant

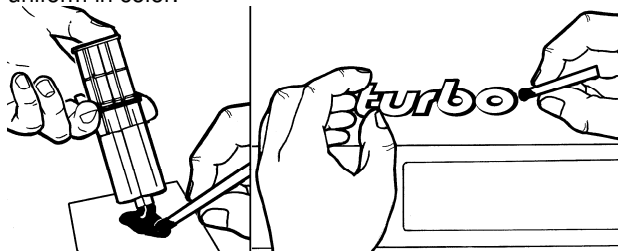
TYPICAL APPLICATIONS

To bond rigid materials including:

- Chrome
- Fiberglass
- Glass
- Plastic
- Metal

DIRECTIONS FOR USE

1. Protect work area from accidental spills.
2. Surface must be clean, dry and free of grease & oil.
3. Roughen surfaces with sandpaper or other abrasives.
4. Use a sharp blade to cut off the tips of both nozzles.
5. Depress plunger on syringe or squeeze out of tubes equal amounts of resin and hardener from tubes. Thoroughly mix resin and hardener on a clean discardable surface for at least one (1) minute (20 to 25 seconds in the case of the one minute epoxy) or until uniform in color.



6. Apply to surfaces being repaired. Assemble parts immediately. Remove excess epoxy immediately.
7. Allow bond to set for the fixture time before moving.

DIRECTIONS FOR SINGLE USE POUCH

1. Protect work area from accidental spills.
2. Surface must be clean, dry and free of grease & oil.

3. Roughen surfaces with sandpaper or other abrasives.
4. Hold the lower half of pouch between thumbs and forefingers and press firmly to break inner seal.
5. Quickly and thoroughly mix until the blue color turns clear (about 15 seconds).
6. Tear open pouch and apply small amount of mixture to both surfaces and assemble parts immediately (product sets up in about 60 seconds).
7. Remove excess epoxy immediately with mineral spirits or acetone.
8. Usable strength is reached in 4 hours at 72°F (22°C). Cooler temperatures may require a longer set time

DIRECTIONS FOR STATIC MIXER

1. Clean, dry and roughen surfaces to be bonded.
2. Remove black storage cap from the middle of black plunger. Turn syringe nozzle end up and pull back on black plunger about 1/8". Allow bubbles to rise to the top.
3. Snap off and discard end of syringe.
4. Insert static mixer into nozzle and twist 90 degrees. NOTE: Static mixer applicator must lock in place before pushing plunger.
5. Push plunger evenly to dispense epoxy. Dispense directly onto surface to be bonded. NOTE: Epoxy sets in 5 minutes and may be handled in 15 minutes. Cooler temperatures may require longer set time.
6. When finished, remove static mixing nozzle and discard. Wipe any excess epoxy from tip and replace black storage cap.

NOTE: Adhesive will not bond most polyethylene or polypropylene plastics.

For Cleanup

1. For any cleanup, use isopropyl alcohol before the material is allowed to dry/cure.
2. Clean hands with Permatex® Fast Orange® hand cleaner or soap and water.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy and Mercaptan or Amine Resins
Mix ratio (volume)	1 : 1
Appearance	
Resin	Clear
Hardener	Clear
Odor	Mild
Specific Gravity	1.10 - 1.17
Flash Point, TCC	>200°F
Viscosity	Heavy syrup

CURING PROPERTIES

	<u>Working Time</u>	<u>Fixture Time</u>
84160	50-60 seconds	2 – 4 minutes
82516	50-60 seconds	2 – 4 minutes
84101	4 – 5 minutes	8 – 10 minutes
82517	4 – 5 minutes	8 – 10 minutes
84107	30-35 minutes	45-50 minutes
84164	4 – 5 minutes	8 – 10 minutes
84201	4 – 5 minutes	8 – 10 minutes

Final color Clear to slightly yellow
Temperature range -60°F to +180°F (-51°C to 82°C)

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as an adhesive for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size
84160	1 min. general purpose epoxy, 0.84 fl. Oz. dual syringe, carded
82516	1 min. clear general purpose epoxy, 2 – 0.14 fl. Oz. single use pouches
84101	5 min. general purpose epoxy, 0.84 fl. Oz. dual syringe, carded
82517	5 min. clear general purpose epoxy, 2 – 0.14 fl. Oz. single use pouches
84107	30 min. crystal clear epoxy, 0.84 fl. Oz. dual syringe, carded
84164	5 minute clear general purpose epoxy, 0.47 fl. Oz. dual syringe/static mixer, carded
84201	5 min. general purpose epoxy, 2 – 1oz. tubes, carded

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° and 28°C (46° and 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.