



Technical Data Sheet

Permatex® PermaPoxy™ Multi-Metal Epoxy Products

PRODUCT DESCRIPTION

S.I.N.: 834-300

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

Appearance

Resin

Hardener

Odor

Specific Gravity

Flash Point, TCC

Viscosity

Black

Off white/White

Mild

1.75 - 1.85

>300°F

Paste

PRODUCT BENEFITS

- Will not shrink
- Various curing cycles
- No clamping needed
- Fills gaps
- Dark grey color
- Impact resistant
- Water resistant
- High temperature resistant

TYPICAL APPLICATIONS

- Aluminum
- Brass
- Chrome
- Copper
- Iron
- Stainless Steel
- Steel
- Cast

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. Thoroughly mix resin and hardener on a clean discardable surface for at least one (1) minute 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.

For Cleanup

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

PROPERTIES OF UNCURED MATERIAL

Chemical Type

Typical Value
Epoxy and Mercaptan or Amine
Resins

Mix Ratio

1:1

CURING PROPERTIES

	<u>Working Time</u>	<u>Fixture Time</u>
84109	4 – 5 minutes	8 – 10 minutes
84112	90 minutes	90-110 minutes
84209	4 – 5 minutes	8 – 10 minutes
84212	90 minutes	90-110 minutes
Final color	Grey	
Temperature range	-60°F to +300°F(Continuous) +350°F(Intermittent)	

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
84109	4 min. Multi-Metal Epoxy, 0.84 fl. oz. dual syringe, carded
84112	90 min. Multi-Metal Epoxy, 0.84 fl. oz. dual syringe, carded
84209	4 min. Multi-Metal Epoxy, 2 – 1oz. tubes, carded
84212	90 min. Multi-Metal Epoxy, 2 – 1oz. tubes, carded

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 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.