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Product Description Sheet

Fixmaster[®] High Performance Epoxy

Maintenance, Repair & Operations, December 2001

PRODUCT DESCRIPTION

LOCTITE[®] Fixmaster[®] High Performance Epoxy is a fiberglass reinforced two-part epoxy adhesive with outstanding tensile and lap shear strengths. It is ideal for most types of bonding under typical dry service temperatures of -29° to +82°C (-20° to +180°F).

Special Features:

- Convenient applicator and mixer package.
- Paintable - saves time.
- High tensile strength.
- Fiberglass reinforced for a strong resilient bond.
- Absorbs mechanical stresses.
- Adheres to most surfaces. Bonds to dissimilar materials, e.g., metal to wood or wood to glass.
- Spreads easily and resists sagging up to 1.5mm (1/16").

TYPICAL APPLICATIONS

- Electrical embedment
- Fills gaps
- Tooling material
- Sealing and caulking
- Bond and repair metal, ceramic, wood, concrete, glass, fiberglass and many plastics

DIRECTIONS FOR USE

1. Clean and abrade application surface.
2. Work the material onto the substrate to allow maximum surface contact and adhesion.

For use of cartridge applicators:

1. Remove cap from tips. Affix static mixer.
2. Insert cartridge into applicator gun Product No. 983531.
3. Pull trigger and epoxy will mix properly as it is dispensed.
4. It is not necessary to use all of the epoxy in the syringe at one time. NOTE: leave the static mixer on the syringe when application is complete. The mixer serves as a seal and should be discarded and replaced with a fresh Fixmaster Mixer Product No. 39634 for the next application.

For use of two gallon kits:

1. Measure equal parts of resin and hardener onto a clean mixing surface.
2. Mix thoroughly to a uniform color.
3. To store unused portions, wipe rim of each can and tightly close lids.

For use of syringe:

1. Cut ends of tips.
2. Dispense material onto a clean and dry mixing surface by pushing plunger with equal force on each side.
3. Mix thoroughly.
4. To store unused portions, break cap from plungers and insert in end of syringe.

TECHNICAL TIPS FOR WORKING WITH EPOXIES

Working time and cure time depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of the material mixed, the faster the cure.

To speed the cure of epoxies at low temperatures:

- Store epoxy at room temperature.
- Pre-heat repair surface until warm to the touch.

To slow the cure of epoxies at high temperatures:

- Mix epoxy in small masses to prevent rapid curing.
- Cool resin/hardener component(s).

PROPERTIES OF UNCURED MIXED MATERIAL

	Typical Value
Appearance	Thick Tan Liquid
Mix Ratio (R:H) by Volume	1:1
by Weight	1:1
Coverage	49 cm ³ (3 in ³) per 50 ml kit 7.1 dm ³ (432 in ³) per 2 gal. kit

TYPICAL CURING PERFORMANCE

(@ 25°C unless noted)

Curing Properties

	Typical Value
Working Life, minutes	30
Cure Time, hours	8

TYPICAL PROPERTIES OF CURED MATERIAL

(@ 25°C unless noted)

Physical Properties

	Typical Value
Shear Strength ASTM D1002, psi (N/mm ²)	3,800 (26.2)
.005" gap, acid etched aluminum	
Hardness ASTM D-2240, Shore D	85

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant 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
99393	1.4 fl oz. syringe
99392	2 gal. kit
99394	50 ml cartridge

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F 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. For further specific shelf life information, contact your local Technical Service Center.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

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