



TECHNICAL DATA SHEET

Revision: 11/15/2022
Supersedes: August 16, 2014
Ref. #: 372919 / 352971

LEPAGE® Gel Epoxy



DESCRIPTION

LePage® Gel Epoxy is a two-part adhesive consisting of an epoxy resin and a hardener, available in a convenient dual syringe. When mixed in equal volumes, the resin and hardener react to produce a tough, rigid, high strength bond in 6 minutes. The gel formulation is ideal for vertical surfaces and overhead repair where dripping may occur. It can be used as an adhesive for a wide range of materials or as a versatile filler for gap bonding, surface repairs, and laminating. LePage Gel Epoxy does not shrink and is resistant to water and most common solvents. It can be tinted with earth pigments, cement, or sand, for colour matching. Once cured, it can be sanded and drilled.

Available As:

Item #	Package	Size
2758343	Carded Syringe	25 mL

FEATURES & BENEFITS

- Sets in 6 minutes* at room temperature
- Dries translucent yellow
- Gel consistency for vertical applications
- Machinable
- Water Resistant
- Will not shrink or expand

RECOMMENDED FOR

LePage® Gel Epoxy bonds metal, glass, ceramic, wood, china, tile, fiberglass, concrete, stone, and many rigid plastics. Can be combined with fiberglass cloth for a durable patch.

LIMITATIONS

- Not for use on nylon, polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE) / Teflon®, or flexible materials
- Not suitable for potable water systems
- Not suitable for continuously wet areas or water immersion

TECHNICAL DATA

Typical Uncured Physical Properties:		Typical Application Properties:	
<u>Resin Color:</u>	Opaque, milky white	<u>Application Temperature:</u>	Use between 4°C (39°F) and 35°C (95°F)
<u>Hardener Color:</u>	Translucent, Amber	<u>Odor:</u>	Amine
<u>Appearance:</u>	Liquid	<u>Gel Time:</u> (2g: 2g)	5 – 6 minutes*
<u>Base:</u>	Amine, Polymercaptan Hardener / Epoxy Resin	<u>Useable Strength:</u>	8 hours
<u>Flash Point:</u>	Hardener: > 93°C (> 199.4°F) Resin: 204.44°C (399.99°F)	<u>Cure Time:</u>	24 hours*
<u>Specific Gravity:</u>	1.02 (Resin); 1.08 - 1.18 (Hardener)	<u>Clean Up:</u>	Clean excess glue immediately by wiping with clean cloth. Acetone may be used to assist in removal. Cured adhesive may be carefully cut away with a sharp-edged tool.
<u>VOC Content:</u>	3.77% by weight (CARB) 0.38 g/l (SCAQMD)		



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TECHNICAL DATA

Shelf Life: 24 months from date of manufacture
(unopened)

Lot Code Explanation: LB9FAC56 (Example)

9 = Last digit in the year of manufacture; 9 = 2019
F = Month produced (see chart on right); F = June
June 2019 is the date of manufacture

9: 2019
0: 2020
1: 2021
2: 2022
3: 2023

A – January
B – February
C – March
D – April
E – May
F – June

J – September
G – July
H – August
M – December
K – October
L – November

* Time is dependent upon temperature, humidity, porosity of substrate and amount of adhesive used

Typical Cured Performance Properties:

Color: Translucent yellow

Cured Form: Non-flammable solid

Hardness: 81 ± 2, Shore D

Service Temperature: -23°C (-9°F) to 49°C (120°F)
-23°C (-9°F) to 150°C (302°F)

Water Resistant: Yes, when fully cured

Paintable: No but can be tinted using earth pigments, cement, or sand

Long-Term (Continuous) Exposure
Short-Term (Intermittent) Exposure

Tensile Shear Strength:

Cold Rolled Steel, Sandblasted:

1 hour cure:	7.16 ± 1.41 N/mm ² (1039 ± 205 psi)
4 hour cure:	17.32 ± 0.46 N/mm ² (2512 ± 67 psi)
24 hour cure:	20.00 ± 3.69 N/mm ² (2901 ± 575 psi)
7 day cure:	21.79 ± 0.09 N/mm ² (3161 ± 130 psi)
28 day cure:	22.85 ± 2.21 N/mm ² (3315 ± 321 psi)

Aluminum, Sandblasted:

24 hour cure:	13.36 ± 0.61 N/mm ² (1937 ± 89 psi)
7 day cure, 24 hr. water immersion	13.53 ± 0.52 N/mm ² (1962 ± 76 psi)
7 day cure, 8 day water immersion:	14.64 ± 0.74 N/mm ² (2124 ± 108 psi)

Compressive Shear Strength:

24 hour cure

Sanded Hard PVC (White):	6.83 ± 1.75 N/mm ² (991 ± 254 psi)
Sanded Acrylite FF:	4.99 ± 0.14 N/mm ² (724 ± 20 psi)
Maple:	13.02 ± 1.98 N/mm ² (1889 ± 287 psi)

Solvent Resistance - Tensile Shear Strength: (Aluminum to Aluminum, 7 day cure)

24 hour gasoline immersion:	18.49 ± 2.40 N/mm ² (2682 ± 349 psi)
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DIRECTIONS

Tools Typically Required:

Utility knife, mixing tool/applicator (e.g., small, flat, plastic, or wooden stick), disposable surface (e.g., foil, paper)

Safety Precautions:

Wear gloves, safety glasses, and wash hands after use. Apply and cure in a well-ventilated area.

Preparation:

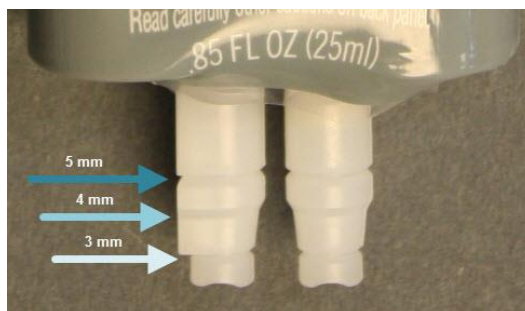
Surfaces must be clean, dry, free from dirt, grease, wax, paint, rust, etc. For better adhesion, roughen smooth surfaces with sandpaper. Wash glass and plastic surfaces with soap and water then rinse and let dry. Pre-fit parts to be joined. Remove the plug from between the pistons. Cut off the end tips of the syringe at one of the three cut-off points as illustrated on the next page. For easier extrusion, cut at the 4 mm or 5mm opening. For more precise application, cut at 3 mm opening.



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DIRECTIONS



Turn syringe tips end up and pull plunger back slightly allowing air bubbles to rise to the top. Press the plunger to expel air. Depress the double piston to dispense equal parts of the two materials on a clean, discardable surface. Mix resin and hardener thoroughly for 1 minute. Wipe syringe tips clean, retract piston slightly and close syringe tips with plug provided to prevent leakage. Ensure that the plug is always placed in the same orientation on the tip.

Application:

For best results apply a small amount of mixed adhesive to both surfaces and press together within one to two minutes of mixing. Placing parts together close to the 6-minute set time will reduce adhesion. Remove any excess glue immediately. Support bond until it sets, approximately 6 minutes at room temperature. Usable strength is achieved in 8 hours*. Full cure is achieved in 24 hours*. Moderate heat will speed hardening while cooler temperatures will require a longer set time.

Clean up:

Clean excess glue immediately by wiping with clean cloth. Acetone may be used to assist in removal. Cured adhesive may be cut away with caution using a sharp blade. Prolonged immersion in paint stripper will soften the cured adhesive to aid removal. Note: Acetone is highly flammable and not compatible with all surfaces. Follow manufacturer's instructions and test on a small area before applying.

STORAGE & DISPOSAL

NOT DAMAGED BY FREEZING. If frozen, warm to room temperature until the resin and hardener become liquid enough to mix. Use an approved hazardous waste facility for disposal.

LABEL PRECAUTIONS

CAUTION. IRRITANT. MAY IRRITATE EYES AND SKIN. Do not get in eyes or on skin. May cause allergic skin reaction.

KEEP OUT OF REACH OF CHILDREN.

FIRST AID TREATMENT: Contains epoxy resin, polymercaptan and amine curing agents. If swallowed, call Poison Control Centre or doctor immediately. Do not induce vomiting. If in eyes rinse well with water for at least 15 minutes. If on skin, rinse well with water.

Refer to the Safety Data Sheet (SDS) for further information

LIMITED WARRANTY

This product is warranted to be free from defects in materials when used as directed. Henkel's sole obligation shall be, at its option, to replace or refund the purchase price of product proven to be defective. Henkel makes no other warranty, express or implied, including warranties of MERCHANTABILITY and FITNESS FOR A PARTICULAR PURPOSE and will not be liable for consequential or incidental damages. This limited warranty gives you specific legal rights, Henkel may be contacted at 1.800.624.7767 M-F 9:00 am to 4:00 pm ET for warranty assistance.



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DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Henkel recommends purchasers/users should test the products to determine acceptable quality and suitability for the intended use. All adhesive/sealant applications should be tested under simulated or actual end use conditions to ensure the adhesive/sealant meets or exceeds all required project specifications. Since assembly conditions may be critical to adhesive/sealant performance, it is also recommended that testing be performed on specimens assembled under simulated or actual production conditions. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.



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For Technical Assistance call: 1-800-624-7767 – Mon-Fri - 9:00a – 4:00p ET
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