



# TECHNICAL DATA SHEET

Revision: 08/01/2022  
Supersedes: 12/08/2020  
Ref. #: 176823 / 352971



## Speed Set™ Epoxy

### DESCRIPTION

LePage® Speed Set™ Epoxy is a two-part adhesive consisting of an epoxy resin and a hardener which react to produce a tough, rigid, high strength bond in 5 minutes, for most projects. It's available in a convenient dual syringe which delivers equal parts of both components every time. LePage® Speed Set™ Epoxy can be used as an adhesive for a wide range of materials or as a versatile filler for gap filling, surface repairs and laminating. LePage® Speed Set™ 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. It can be sanded and drilled.

#### Available As:

Item #	Package	Size
2758384	Carded Syringe	25 mL

### FEATURES & BENEFITS

- Sets in 5 minutes at room temperature
- Dries translucent yellow
- Machinable
- Water Resistant
- Will Not Shrink or Expand

### RECOMMENDED FOR

LePage® Speed Set™ Epoxy bonds metal, glass, ceramic, wood, china, tile, fiberglass, masonry, stone, and many rigid plastics quickly and permanently. 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 applications requiring short-term heat exposure of greater than 150°C (302°F)
- 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> Translucent, clear	<u>Application Temperature:</u> Use between 4°C (39°F) & 35°C (95°F)
<u>Hardener Color:</u> Translucent, amber	<u>Odor:</u> Amine (Hardener)
<u>Appearance:</u> Liquid	<u>Gel Time (5g : 5g):</u> 4 – 10 minutes*
<u>Base:</u> Polymercaptan Hardener / Epoxy Resin	<u>Useable Strength:</u> 1 hour*
<u>Flash Point:</u> >93°C (>199.4°F); >249°C (>480.2°F)	<u>Cure Time*:</u> 24 hours*
<u>Specific Gravity:</u> 1.17 (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> 0.1% by weight CARB	



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## TECHNICAL DATA

### Typical Uncured Physical Properties:

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

A – January	G – July
B – February	H – August
C – March	J – September
D – April	K – October
E – May	L – November
F – June	M – December

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

### Typical Cured Performance Properties:

<u>Color:</u>	Clear to amber	<u>Water Resistant:</u>	Yes, when fully cured
<u>Cured Form:</u>	Non-flammable solid	<u>Paintable:</u>	No but can be tinted using earth pigments, cement, or sand
<u>Hardness:</u>	80 ± 1, Shore D		
<u>Service Temperature:</u>	-23°C (-9°F) to 49°C (120°F)	Long-Term (Continuous) Exposure	
	-23°C (-9°F) to 150°C (302°F)	Short-Term (Intermittent) Exposure	

#### Tensile Shear Strength:

Cold Rolled Steel, Sandblasted:

1 hour cure:	9.11 ± 0.88 N/mm <sup>2</sup> (1322 ± 128 psi)
4 hour cure:	17.20 ± 0.54 N/mm <sup>2</sup> (2494 ± 78 psi)
24 hour cure:	23.70 ± 0.40 N/mm <sup>2</sup> (3437 ± 58 psi)
7 day cure:	23.62 ± 1.07 N/mm <sup>2</sup> (3426 ± 155 psi)

Aluminum, Sandblasted:

24 hour cure:	14.17 ± 2.0 N/mm <sup>2</sup> (2055 ± 290 psi)
24 hour cure:	14.12 ± 1.10 N/mm <sup>2</sup> (2048 ± 160 psi)
7 day cure, 7 day water immersion:	9.11 ± 0.88 N/mm <sup>2</sup> (1322 ± 128 psi)

#### Compressive Shear Strength:

24 hour cure

Sanded Hard PVC (White):	7.45 ± 1.37 N/mm <sup>2</sup> (1081 ± 199 psi)
Sanded Acrylite FF:	6.61 ± 1.85 N/mm <sup>2</sup> (958 ± 268 psi)
Maple:	14.40 ± 1.68 N/mm <sup>2</sup> (2088 ± 243 psi)

#### Solvent Resistance:

Tensile Shear Strength - Aluminum, 7 day cure

24 hour gasoline immersion:	22.17 ± 1.90 N/mm <sup>2</sup> (3216 ± 275 psi)
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#### Side Impact Resistance:

6.8 Joules Sandblasted Cold Rolled Steel 1" x 1", 7 day cure

## 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 piston. Cut off the end tips of the syringe. 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.



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## DIRECTIONS

### **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 5 minute set time will reduce adhesion. Remove any excess glue immediately. Support bond until it sets, approximately 10 minutes at room temperature. Usable strength achieved in 1 hours. Fully cured in 24 hours.

### **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

## 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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