



Technical Data Sheet



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Loctite Power Epoxy Metal 5 minute

CHARACTERISTICS

- Fast metallic epoxy (5 minute)
- Two component, 1:1 mix ratio
- Solvent-free
- Cured material can be machined (sanded, drilled) and painted

APPLICATION FIELD

Bonding and repairing metal parts.

It also adheres to most other materials such as woods, ceramic, stone, most plastics*

INSTRUCTIONS FOR USE

Surface Preparation

Surfaces to be bonded must be dry and dust and oil free. For best results surfaces should be roughened prior to bonding.

Application

The product is applied in a 1:1 mixture of the two components. Apply the adhesive mix on one of the surfaces and complete the bond without delay. Within 5 minutes of mixing, the product begins to harden.

TECHNICAL DATA

Composition	Epoxy Resin & Hardener system
Density (Part A, B)	1.3g/ml, 1.5g/ml
Heat resistance	-30°C to 150°C (Max 70°C for load bearing bonds)
Open time	3 minutes
Cured Colour	Metallic
Cure time	30 minutes to handling strength. Full strength after 24 hours
Final strength (EN 1465, RTC)	Up to 14 N/mm ² (substrate dependent)
Shelf Life (@20°C)	18 months, unopened, from date of production





LIMITATIONS

*Not suitable for use on waxy or soft plastics, e.g. PP, PE, Teflon® (PFTE), vinyl.

Cleaning tools

Once hardened the resin can be removed mechanically (sanding, scraping etc..). Uncured material can be removed with ethanol or other alcohol solvent cleaner.

Storage

Product should be stored at room temperature (10°C – 30°C). For maximum shelf-life, please store at lower end of temperature range.

HEALTH AND SAFETY

Before using the product please see related Material Safety Data Sheet that is available on request.

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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