



The Glue People

Trade Grade Products Ltd
10 Victory Close
Woolbridge Industrial Park
Three Legged Cross
Wimborne, Dorset, BH21 6SX

Tel 01202 820177
Fax 01202 814011

Tradeweld Fast Set Epoxy

Rapid set epoxy twin syringe

General Description

Tradeweld Fast Set Epoxy is a highly reactive, two component adhesive in a twin syringe for easy, clean and accurate dispensing, for use in light assemblies, maintenance & repairs.

It is suitable for bonding metals, glass, GRP, ceramics, rubbers, plastics and woods.

- Rapid curing
- Easy to use
- Accurate dispensing
- Bonds a wide range of substrates

Application

All substrate surfaces should be abraded using abrasion paper or air-driven narrow belt sander. It is imperative that the surfaces are then cleaned of any dust, grit, loose material, wax, grease and oil using a suitable cleaner.

Using the Fast Set Epoxy twin syringe, dispense the desired amount in to a suitable mixing vessel. This will dispense both resin and hardener portions of the adhesive in the correct mix ratio (1:1).

Mix the two parts together quickly until a uniform consistency is achieved. Apply the adhesive to one of the material surfaces that is to be bonded. Clamp the two material together until the handling strength is achieved 15 minutes after the adhesive has been mixed.

It is important that Fast Set Epoxy is mixed and used, and the materials clamped together before the pot life is exceeded. Handling strength is achieved approximately 15 minutes after bonding. Full cure is achieved 24 hours after bonding.

Characteristics

Property	Data
Colour	Light yellow (when mixed)
Base	Epoxy resin with amine hardener
Consistency	Liquid
Specific gravity (20°C)	1.14
Total Solids Content	100%
Viscosity (20°C)	10,000 – 12,000 cP
Mix Ratio	1:1 Resin to Hardener
Pot Life (20°C)	5 – 7 minutes
Cure time (20°C)	Handling strength 10-15 minutes Full cure 24 hours
Gap filling	Up to 0.3mm
Coverage	200 grams per m ²
Operating temperature	0-60°C

The performance data presented here has been determined by our standard test methods and are average values that should not be used for specification purposes. Our recommendations on the use of this product are based on tests believed to be reliable. It is advised that users conduct their own tests to determine the suitability of the product for their specific application.

Test	Substrates	Results
Shear adhesion test	Mild steel	9-15 MPa
Shear adhesion test	Stainless steel	9-14 MPa
Shear adhesion test	Aluminium	9-14 MPa

General Information

Storage

Tradeweld Fast Set Epoxy should be stored in its original container, with the syringe cap tightly secured, in dry conditions and at temperatures between 5°C and 25°C. Fast Set Epoxy will keep satisfactorily for up to 24 months from date of manufacture if stored according to the recommended conditions.

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradeweld Fast Set Epoxy.