

Physical Properties	5 Minute <sup>®</sup> Epoxy	5 Minute <sup>®</sup> Epoxy Gel	One Minute <sup>™</sup> Epoxy Gel	10 Minute <sup>™</sup> Epoxy		2 Ton <sup>®</sup> Clear Epoxy	Epoxy Plus <sup>™</sup> 25	HP 250	Food Grade Pot & Seal	SC2002 / SC2002NS	Speaker Bonder <sup>™</sup>	5 Minute <sup>®</sup> FR <sup>5</sup>	10 Minute <sup>®</sup> FR <sup>5</sup>
<b>Color</b>	Light Amber	Opaque	Amber	Black	Clear	Clear, White	Grey	Straw	White	Grey	Grey	Off-White	Off-White
<b>Mix ratio</b> (resin:hardener)	1:1	1:1	1:1	1:1	1:1	1:1	1:1	2:1	4:1	1 Part	1:1	1:1	1:1
<b>Mixed viscosity</b> cps	10,000	Gel	70,000	90,000	80,000	8,000	70,000	105,000	100,000	65,000	60,000	115,000	70,000
<b>Working time</b> <sup>1</sup> minutes	3 ~ 6	4 ~ 7	45 sec	10	10	8 ~ 12	25	65	42	N/A	10	4 - 8	10
<b>Fixture time</b> <sup>2</sup> minutes	10 ~ 15	10 ~ 15	1	20	20	30 ~ 35	3.5 hours	5 hours	Heat Cure	Unlimited 2 @ 280°F	25	10 ~ 15	20 ~ 25
<b>Functional cure</b> hours	0.75 ~ 1	0.75 ~ 1	0.5 ~ 0.75	1.5	1.5	2	24	24	12 @ 75°F	.5 @ 212°F	24 @ 75°F	1	3
<b>Adhesive tensile lap shear</b> (ASTM D1002) psi	1,900 <sup>4</sup>	2,500 <sup>3</sup>	1,600 <sup>4</sup>	2,400 <sup>3</sup>	2,400 <sup>3</sup>	2,250 <sup>3</sup>	2,750 <sup>3</sup>	3,200 <sup>3</sup>	1,980 (Heat Cure)	2,200	2,227	1,365 <sup>4</sup>	3,140 <sup>3</sup>
<b>Tensile elongation</b> %	1	1	1	5	5	1	20	25	1	1	1	1	5
<b>Peel strength</b> pli	2 ~ 3	2 ~ 3	2 ~ 3	20 ~ 25	20 ~ 25	2 ~ 3	20 ~ 25	35 ~ 40	2 ~ 3	3	2 ~ 3	2 ~ 3	17
<b>Impact resistance</b> ft-lb / in <sup>2</sup>	5.5	6.5	4.5	10	10	6.5	10	12	5.2	5.9	5.9	5.5	10
<b>Maximum service temperature</b> F dry	-40 ~ 200	-40 ~ 200	-40 ~ 200	-67~200	-67~200	-40 ~ 200	-40 ~ 200	-67 ~ 250	-40 - 280	-60 - 300	-40 - 120	-40 - 200	-40 - 200

Notes: <sup>1</sup> The maximum allowable time to mate and position parts after mixing and application of the adhesive. After this interval, parts must not be disturbed. <sup>4</sup> Bond line thickness of 0.005"  
<sup>2</sup> The time required for the adhesive to generate sufficient bond strength to allow parts to be handled without deformation of the bond line. <sup>5</sup> Meets FAR 25.853/25.885 [vertical burn test] and UL94V-0.  
<sup>3</sup> All tensile strength data per ASTM D1002 on grit-blasted steel, bond line thickness of 0.010".

Key: ● Excellent ○ Very Good ○ Fair ○ Poor

Chemical Resistance	5 Minute <sup>®</sup> Epoxy	5 Minute <sup>®</sup> Epoxy Gel	One Minute <sup>™</sup> Epoxy Gel	10 Minute <sup>™</sup> Epoxy	2 Ton <sup>®</sup> Clear Epoxy	Epoxy Plus <sup>™</sup> 25	HP 250	Food Grade Pot & Seal	SC2002 / SC2002NS	Speaker Bonder <sup>™</sup>	5 Minute <sup>®</sup> FR <sup>5</sup>	10 Minute <sup>®</sup> FR <sup>5</sup>
<b>ACIDS</b>												
Acetic 10%	○	○	○	○	○	○	○	○	○	○	○	○
Hydrochloric 10%	○	○	○	○	○	○	○	○	○	○	○	○
Sulfuric 10%	○	○	○	○	○	○	○	○	○	○	○	○
<b>ALCOHOLS</b>												
Glycol	○	○	○	○	○	○	○	○	○	○	○	○
Isopropanol	○	○	○	○	○	○	○	○	○	○	○	○
Methanol	○	○	○	○	○	○	○	○	○	○	○	○
<b>KETONES</b>												
Acetone	○	○	○	○	○	○	○	○	○	○	○	○
Methyl ethyl ketone	○	○	○	○	○	○	○	○	○	○	○	○
<b>ALKALIS</b>												
Ammonium hydroxide 20%	○	○	○	○	○	○	○	○	○	○	○	○
Sodium hydroxide 10%	○	○	○	○	○	○	○	○	○	○	○	○
<b>HYDROCARBONS</b>												
Gasoline (unleaded)	●	●	●	●	●	●	●	●	●	●	●	●
Mineral spirits	●	●	●	●	●	●	●	●	●	●	●	●
Motor oil	●	●	●	●	●	●	●	●	●	●	●	●
<b>CHLORINATED HYDROCARBONS</b>												
Perchloroethylene	○	○	○	○	○	○	○	○	○	○	○	○
<b>SALTS</b>												
Sodium chloride	○	○	○	○	○	○	○	○	○	○	○	○
Trisodium phosphate	○	○	○	○	○	○	○	○	○	○	○	○