



Technical Data Sheet

Permatex® Fast Cure 5 Minute® Epoxy

PRODUCT DESCRIPTION

Permatex® Fast Cure 5 Minute® Epoxy mixer cups contain both resin and hardener in one convenient package that eliminates measuring and weighing. The two components are color coded to assure complete mixing. No mess, no guess, no waste. Fast Cure 5 Minute® Epoxy is ideal for bonding glass, hard plastics, and metal. It also can be used to repair loose trim and broken grills and fills casting cracks and holes.

PRODUCT BENEFITS

- Pre-measured resin and hardener for easy application
- Consistent strength and time savings
- Holds in 5 - 15 minutes
- Useable in 30 minutes
- Good moisture resistance
- May be drilled, tapped, sanded or machined and painted after cure
- Available in re-sealable foil pouch

TYPICAL APPLICATIONS

- Fills gaps and bonds trim
- Casting cracks and holes
- Auto trim and ornaments

DIRECTIONS FOR USE

1. Before starting, make sure your work area is protected from accidental spills. Surfaces must be clean, dry and free of grease and oil.
2. Roughen smooth surfaces to be repaired with sandpaper.
3. Remove protective film from cup.
4. Using one of the mixer sticks provided, push down the center of the kit to form mixer cup.
5. Scrape all of the epoxy hardener and resin into the bottom of the cup and mix thoroughly until a uniform grey color is achieved (approximately one minute). Use mixing stick to apply epoxy to bonding area.
6. Press surfaces together until set - product will set up in 5 to 15 minutes.
7. While epoxy is still tacky, the excess can be removed with paint remover or mineral spirits.
8. Parts will fixture in 5 to 15 minutes; full cure is achieved in 24 hours.

For Cleanup

1. Cleanup must be completed before curing is complete. Use acetone or mineral spirits for cleanup.
2. Clean hands with Permatex® brand hand cleaners.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy, amine resins
Appearance	Resin – white paste Hardener - black paste
Odor	Mild
Flash Point, TCC, °F	>200

TYPICAL CURING PERFORMANCE

Permatex® Fast Cure 5 Minute® Epoxy has a gel time of 4 to 6 minutes, fixture time of 10 to 15 minutes with a full cure in 24 hours.

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance	Typical Values
Continuous, °C (°F) Maximum	-54(-65) to 82(180)
Intermittent, °C (°F) Maximum	-54(-65) to 93(200)

Appearance	grey
Shear Strength, ASTM D 1002, psi	2000

Chemical / Solvent Resistance

The product retains effective properties when in contact with water, oil, fuels and solvents.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as an adhesive for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size
21425	10 - 4 gm mixer cups

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° and 28°C (46° and 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.