

Technical Data Sheet Issue Date: 01-11-02		Product Code: VC-140 Rapid Steel 4 Minutes Epoxy
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Product Description:

Rapid Steel 4 Minutes Epoxy is a fast setting, non-shrinking, grey color epoxy adhesive that exhibit a remarkable combination of properties, high mechanical strength, excellent resistant to most chemical and reliable heat resistant. It is steel-filled hence offers good gap-filling capabilities and non-slumping characteristic. It is easy to machine, non-conductive and can be handled after 2 hours.

Applications:

Applications: Bonding of metal and metal alloys, casting impregnating and potting system, gap filling, trimming bonding, crack casting or holes repair, tools, ornaments, knobs, ceramic, glassware, fiberglass repair etc.

Physical Data:

Appearance	Rapid Steel 4 mins Resin (Black Liquid) Rapid Steel 4 mins Hardener (White Liquid)
Viscosity at 25°C	Rapid Steel 4 mins Resin – above 400,000 cps Rapid Steel 4 mins Hardener – above 1,000,000 cps
Main Ingredient	Epoxy Resin
Mixing Ratio	1:1 (by volume)
Tensile Strength (kg/cm ²)	Minimum 130
Hardness (Shore-D)	Minimum 80
Working Time	Below 3 minutes at room temperature
Curing Time	4 - 6 minutes at room temperature
100% Curing Time	24 hours at room temperature

Directions:

1. Surfaces must be clean, dry and free of dirt, grease, oil or water. Puncture the tube with the cap
2. Squeeze out equal amount of Resin and Hardener onto any discardable surface.
3. Mix thoroughly and apply mixture to both surfaces before joining. Low heat will accelerate hardening.
4. Replace cap after use and store in cool, dry place.

CAUTION:

Contains Epoxy Resin and Polymercaptan Hardener. May caused severe eye and skin irritation. Avoid prolonged contact with eyes or skin. In case of eye contact, flush with water for 15 minutes and seek medical attention immediately. In case of skin contact, wipe off and wash with soap and water.

Storage:

Provided the adhesive are stored dry and cool in air tight containers, the storage stability will be at least 12 months (before mixing) from day of delivery ex-works.

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