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## Technical Data Sheet

### Permatex® PermaPoxy™ Clear General Purpose Epoxy Products

INDUSTRIAL

#### PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex® PermaPoxy™ products are two part, clear epoxy adhesive systems. PermaPoxy™ Clear General Purpose epoxies are of a maximum strength formula that is available in several working times. PermaPoxy™ is ideal for complex, multi-piece assemblies. They are water and solvent resistant and available in dual syringes or tubes.

#### PRODUCT BENEFITS

- Will not shrink
- Various curing cycles
- No clamping needed
- Fills gaps
- Nearly colorless
- Impact resistant
- Water resistant

#### TYPICAL APPLICATIONS

To bond rigid materials including:

- Chrome
- Fiberglass
- Glass
- Plastic
- Metal

#### DIRECTIONS FOR USE

1. Protect work area from accidental spills.
2. Surface must be clean, dry and free of grease & oil.
3. Roughen surfaces with sandpaper or other abrasives.
4. Use a sharp blade to cut off the tips of both nozzles.
5. Depress plunger on syringe or squeeze out of tubes equal amounts of resin and hardener from tubes. Thoroughly mix resin and hardener on a clean discardable surface for at least one (1) minute (20 to 25 seconds in the case of the one minute epoxy) or until uniform in color.
6. Apply to surfaces being repaired. Assemble parts immediately. Remove excess epoxy immediately.
7. Allow bond to set for the fixture time before moving.

#### For Cleanup

1. For any cleanup, use isopropyl alcohol before the material is allowed to dry.
2. Clean hands with Permatex® Fast Orange® hand cleaner or soap and water.

#### Chemical Type

Mix ratio (volume)  
Appearance  
Resin  
Hardener  
Odor  
Specific Gravity  
Flash Point, TCC  
Viscosity

**Typical Value**  
Epoxy and Mercaptan or Amine  
Resins  
1 : 1  
Clear  
Clear  
Mild  
1.10 - 1.17  
>200°F  
Heavy syrup

#### CURING PROPERTIES

	<u>Working Time</u>	<u>Fixture Time</u>
84160	50-60 seconds	2 – 4 minutes
84101	4 – 5 minutes	8 – 10 minutes
84104	40-45 minutes	60-70 minutes
84107	30-35 minutes	45-50 minutes
84201	4 – 5 minutes	8 – 10 minutes
84204	40-45 minutes	60-70 minutes

Final color                      Clear  
Temperature range           -60°F to +180°F

#### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant 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
84160	1 min. general purpose epoxy, 0.84 fl. oz. dual syringe, carded
84101	5 min. general purpose epoxy, 0.84 fl. oz. dual syringe, carded
84104	45 min. general purpose epoxy, 0.84 fl. oz. dual syringe, carded
84107	30 min. crystal clear epoxy, 0.84 fl. oz. dual syringe, carded
84201	5 min. general purpose epoxy, 2 – 1oz. tubes, carded
84204	45 min. general purpose epoxy, 2 – 1oz. tubes, carded

#### PROPERTIES OF UNCURED MATERIAL

NOT FOR PRODUCT SPECIFICATIONS.  
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.  
PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.  
PERMATEX, INC., HARTFORD SQUARE NORTH, 10 COLUMBUS BOULEVARD, HARTFORD, CT 06106 PHONE – (1-87PERMATEX) Revised 05/05

## STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 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.

## NOTE

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