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Technical Data Sheet

Permatex® Gel 1 Minute Epoxy

Revised 04/20

PRODUCT DESCRIPTION

Permatex® Gel 1 Minute Epoxy is a unique two-part, instant curing, clear, general purpose epoxy. The formula contains a Blue Dye Indicator, in which the blue color disappears when epoxy is thoroughly mixed. Permatex® Gel 1 Minute Epoxy is ideal for rapidly fixing single piece assemblies.

PRODUCT BENEFITS

- Will not shrink
- Instant adhesion
- No clamping needed
- Fills gaps
- Nearly colorless
- Impact resistant
- Water resistant

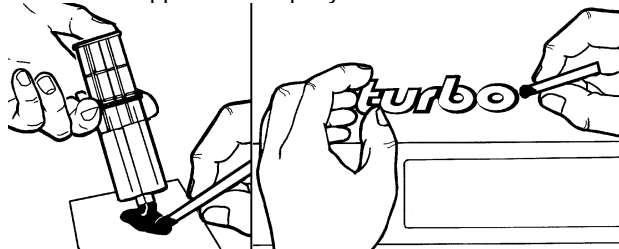
TYPICAL APPLICATIONS

To bond rigid materials including:

- Chrome
- Fiberglass
- Glass
- Plastics (**Excluding polyethylene and polypropylene**)
- Metal

DIRECTIONS FOR USE

1. Protect work area from accidental spills.
2. Surface must be clean, dry and free of grease & oil.
3. For better adhesion, roughen surfaces with sandpaper or other abrasive.
4. Snap cover off the end of the syringe and keep for storage.
5. Depress plunger evenly to dispense equal amounts of resin and hardener from tubes. Thoroughly mix resin and hardener on a clean discardable surface until blue dye indicator disappears and epoxy is a uniform color.



6. Apply to surfaces being repaired. Assemble parts immediately. Allow bond to set for the fixture time before moving. Remove excess epoxy immediately.

NOTE: Epoxy sets in 1 minute and may be handled in 5 minutes. Cooler temperatures may require longer set time.

7. Wipe any excess epoxy from tip and replace storage cap.

For Cleanup

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

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy and Mercaptan/Amine Resins
Mix ratio (volume)	1 : 1
Appearance	Blue Gel
Resin	Clear to Yellow Gel
Hardener	Mild
Odor	1.10 - 1.17
Specific Gravity	>200°F
Flash Point, TCC	Gel
Viscosity	

CURING PROPERTIES

	Working Time	Fixture Time
84160	1 minute	2 – 5 minutes

Final color	Clear to slightly yellow
Temperature range	-60°F to +180°F (-51°C to 82°C)

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
84160	1 min. general purpose epoxy, 0.84 fl. Oz. dual syringe, carded

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.

NOTE

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