



Toll Free: 87 PERMATEX
(877-376-2839)

6875 Parkland Boulevard, Solon
Ohio 44139

Technical Data Sheet

Permatex® Gel 5 Minute Epoxy

Revised 04/20

PRODUCT DESCRIPTION

Permatex® Gel 5 Minute Epoxy is a unique two-part, rapid 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 5 Minute Epoxy is ideal for complex, multi-piece assemblies.

PRODUCT BENEFITS

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

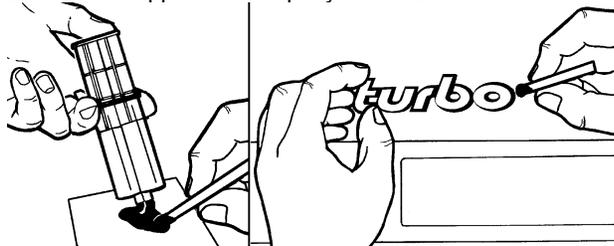
TYPICAL APPLICATIONS

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 5 minutes and may be handled in 15 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	
Resin	Blue Gel
Hardener	Clear to Yellow Gel
Odor	Mild
Specific Gravity	1.10 - 1.17
Flash Point, TCC	>200°F
Viscosity	Gel

CURING PROPERTIES

	Working Time	Fixture Time
84101	4 – 5 minutes	8 – 10 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
84101	5 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

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. **Permatex, Inc. specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Permatex, Inc. products and disclaims any liability for consequential or incidental damages of any kind, including lost profits.** This product may be covered by one or more United States or foreign patents or patent applications.