



1001 Trout Brook Crossing
Rocky Hill, CT 06067-3910
Telephone: (860) 571-5100
FAX: (860) 571-5465

Product Description Sheet

Fixmaster® 4 Minute Epoxy

Maintenance, Repair & Operations, December 2001

PRODUCT DESCRIPTION

LOCTITE® Fixmaster® 4 Minute Epoxy Adhesive is a two-part super fast bonding adhesive. It is excellent for bonding metals, ceramics, wood, concrete, and glass under typical dry service temperatures of -29° to +71°C (-20° to +160°F). Gel consistency for non-sag on vertical surfaces.

Special Features:

- Convenient applicator and mixer package
- Fast curing – for fast repairs requiring high strength
- Adheres to most clean surfaces – versatile
- Excellent tensile and lap shear strength
- Eliminates mess

TYPICAL APPLICATIONS

- Bonds metals, ceramic, wood, concrete and glass
- Emergency adhesive needs
- Structural bonding

DIRECTIONS FOR USE

1. Clean and abrade application surface.
2. Work the material onto the substrate to allow maximum surface contact and adhesion.

For use of cartridge applicators:

1. Remove cap from tips. Affix static mixer.
2. Insert cartridge into applicator gun Product No. 983531.
3. Pull trigger and epoxy will mix properly as it is dispensed. It is not necessary to use all of the epoxy in the syringe at one time. NOTE: leave the static mixer on the syringe when application is complete. The mixer serves as a seal and should be discarded and replaced with a fresh Fixmaster Mixer Product No. 39634 for the next application.

For use of syringe:

1. Cut ends of tips.
2. Dispense material onto a clean and dry mixing surface by pushing plunger with equal force on each side.
3. Mix thoroughly.
4. To store unused portions, break cap from plungers and insert in end of syringe.

TECHNICAL TIPS FOR WORKING WITH EPOXIES

Working time and cure time depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of the material mixed, the faster the cure.

To speed the cure of epoxies at low temperatures:

- Store epoxy at room temperature.
- Pre-heat repair surface until warm to the touch.

To slow the cure of epoxies at high temperatures:

- Mix epoxy in small masses to prevent rapid curing.
- Cool resin/hardener component(s).

PROPERTIES OF UNCURED MIXED MATERIAL

	Typical Value
Appearance	Thick Translucent Liquid
Mix Ratio (R:H) by Volume	1:1
by Weight	1:1
Coverage	41 cm ³ 2.5 in ³

TYPICAL CURING PERFORMANCE

Curing Properties

(@ 25°C unless noted)	Typical Value
Working Life, minutes	3-4
Cure Time, minutes	10-15

TYPICAL PROPERTIES OF CURED MATERIAL

(@ 25°C unless noted)

Physical Properties

	Typical Value
Tensile Strength, ASTM D638, psi (N/mm ²)	3,000 (20.7)
Shear Strength ASTM D1002, psi (N/mm ²)	2,000 (13.8)
.005" gap, acid etched aluminum	
Hardness ASTM D-2240, Shore D	80

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
97434	50 ml cartridge

Storage

Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C (46°F to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. For further specific shelf life information, contact your local Technical Service Center.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

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THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.

ROCKY HILL, CT FAX: +1 (860)-571-5473

DUBLIN, IRELAND FAX: +353-(1)-451 - 9959

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