



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

6875 Parkland Boulevard, Solon
Ohio 44139

Technical Data Sheet

Permatex® High Heat Epoxy

Revised 04/20

PRODUCT DESCRIPTION

Permatex® High Heat Epoxy is a unique two-part, heat resistant, general purpose epoxy. This formula resists temperatures up to 400°F continuously, and 500°F intermittently. It is designed with a longer set time to position repairs correctly before fixture, and is ideal for under the hood applications, home heating projects, and general purpose repairs.

PRODUCT BENEFITS

- Will not shrink
- No clamping needed
- Fills gaps
- High heat resistance
- Impact resistant
- Water resistant

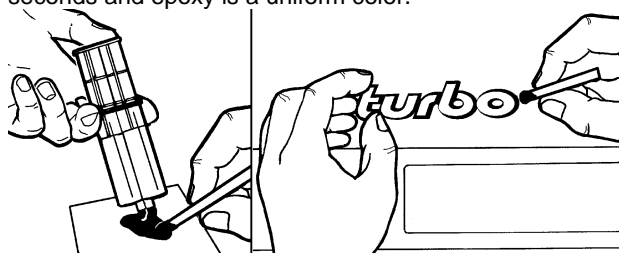
TYPICAL APPLICATIONS

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 for 30-60 seconds 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 10 minutes and may be handled in 20 – 30 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 Amine Resins
Mix ratio (volume)	1 : 1
Appearance	
Resin	Clear
Hardener	Clear to Amber Yellow
Odor	Mild
Specific Gravity	1.10 - 1.17
Flash Point, TCC	>200°F
Viscosity	Viscous Liquid

CURING PROPERTIES

	Working Time	Fixture Time
84102	10 - 15 minutes	20 - 30 minutes

Final color	Clear to slightly yellow
Temperature range	-60°F to +500°F (-51°C to 260°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
84102	High Heat 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.