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# Technical Data Sheet

## Permatex® 2 Ton Epoxy

Revised 04/20

### PRODUCT DESCRIPTION

Permatex® 2 Ton Epoxy is a unique two-part, high strength, clear, general purpose epoxy. The formula has a long set time to set up multiple repairs. Repositionable up to 15 minutes after application. Permatex® 2 Ton Epoxy is ideal for complex, multi-piece assemblies.

### PRODUCT BENEFITS

- Will not shrink
- Designed for multiple applications
- Fills gaps
- Nearly colorless
- Impact resistant
- Water resistant

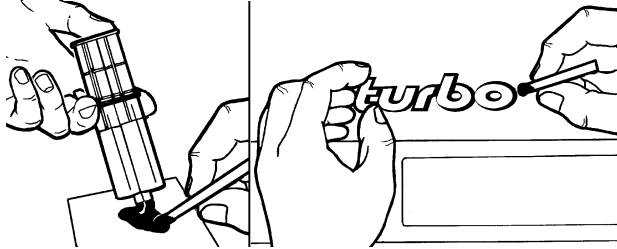
### TYPICAL APPLICATIONS

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 for 1 minute and epoxy is a uniform color.



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

NOTE: Epoxy sets in 20 - 30 minutes and may be handled in 60 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
84133	15 - 20 minutes	20 - 30 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
84133	30 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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