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## Technical Data Sheet

### Permatex® 4 min Multi Metal Epoxy

#### PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex™ 4 min Multi-Metal Epoxy is a two part, filled epoxy adhesive system. Permatex 4 min Multi-Metal Epoxy is a maximum strength formula and is ideal for complex, multi-piece assemblies. They are water and solvent resistant.

#### PRODUCT BENEFITS

- Will not shrink
- Various curing cycles
- No clamping needed
- Fills gaps
- Dark grey colour
- Impact resistant
- Water resistant
- High temperature resistant

#### TYPICAL APPLICATIONS

To bond rigid materials including:

- Aluminium
- Chrome
- Iron
- Steel
- Brass
- Copper
- Stainless Steel
- Cast

#### DIRECTIONS FOR USE

1. Protect work area from accidental spills.
2. Surface must be clean, dry and free of grease & oil.
3. Roughen surfaces with sandpaper or other abrasives.
4. Use a sharp blade to cut off the tips of both nozzles.
5. Depress plunger on syringe or squeeze out of tubes equal amounts of resin and hardener. Thoroughly mix resin and hardener on a clean discardable surface for at least one (1) minute or until uniform in colour.
6. Apply to surfaces being repaired. Assemble parts immediately. Remove excess epoxy immediately.
7. Allow bond to set for the fixture time before moving.

#### FOR CLEANUP

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

#### PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy and Mercaptan or Amine Resins
Mix ratio (volume)	1 : 1
Appearance	
Resin	Black
Hardener	Off white/white
Odour	Mild
Specific Gravity	1.75 - 1.85
Flash Point, TCC	>148°C
Viscosity	Paste

#### CURING PROPERTIES

841092	Working Time 4 - 5 minutes	Fixture Time 8 - 10 minutes
Final colour	Grey	
Temperature range	-50°C to +148°C(Continuous) +176°C(Intermittent)	

#### 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
35241 & 35242	25ml dual syringe, carded

#### STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C unless otherwise labelled. 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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