

### TotalBoat 4-Minute Epoxy -- Tech Data Sheet

TotalBoat 4-Minute Epoxy is a clear, two-part epoxy adhesive that bonds metal, fiberglass, many plastics, ceramics, glass, and more. This moisture- & solvent-resistant epoxy system is suitable for use in all temperatures, and cures in only four hours. The calibrated syringe automatically dispenses the right ratio of resin and hardener, for reliable bonds and no waste. Fast 4-minute set time and no clamping necessary make TotalBoat 4-Minute Epoxy perfect for quick repairs and larger projects alike. Resistant to diesel, oils, gasoline, and water.

#### COMPATIBLE SUBSTRATES:

- Fabric, Fiberglass, Glass, Metals, Rubber, Most Plastics, Wood
- \*\*Not for use with polyethylene or polypropylene.

#### SURFACE PREPARATION:

- Abrade the surfaces that are to be bonded, then completely remove any surface contaminants such as dust, grease, oil, water, or wax.

#### APPLICATION:

- Apply between 50-90°F. Remove the mixing stick from between the black plungers. Point the tip of the syringe up prior to removing the cap from the end. Do not remove the cap until all air bubbles have completely risen up. Snap off the tip and save it, as it functions as a cap between uses. Dispense equal amounts of resin/hardener components onto a piece of cardboard or plastic by slowly depressing the plunger. To stop the flow, pull the plunger back slightly after dispensing epoxy. Mix the epoxy with the provided mixing stick very thoroughly for 1-2 minutes. The total working time is four minutes, including mixing time. Glued items may need to be held in position for up to 10 minutes while the epoxy sets. Full cure is 24 hours. Wipe the syringe tips clean and replace the cap when finished dispensing epoxy.

**EXOTHERMIC REACTION!** EXOTHERMIC REACTION! Mixing the epoxy resin and hardener components together will create an exothermic reaction that generates heat. The more epoxy that is mixed, the hotter the mixture will get.

#### STORAGE:

Store at 60-90°F, in a dry place. Ensure that containers are thoroughly sealed directly after use. Store products on a raised surface off the floor during cold weather, and avoid storing near outside walls or doors. Epoxy resins that are contaminated with dust or moisture, or are subjected to low temperatures, may crystallize. Do not use material that has any sign of crystallization, until it has been liquefied. A CRYSTALLIZED RESIN OR HARDENER CAN BE EASILY RETURNED TO ITS ORIGINAL STATE BY HEATING THE MATERIAL TO 140°F-150°F AND STIRRING UNTIL IT RETURNS TO THE LIQUID STATE.

#### SAFETY AND HANDLING:

Work in well-ventilated areas. Wear gloves, eye protection, and clothing protection. Avoid contact to the skin and eyes. Avoid clothing contamination. Wash hands thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult Safety Data Sheets (SDS) for complete health and safety information.

#### APPLICATION DATA:

**Application Temperature:** 50°F to 90°F  
**Mix Ratio:** 1:1 (Syringe dispenses at the required ratio)  
**Mixed Viscosity @ 77°F:** Heavy syrup  
**Working Time @ 77°F:** 4 minutes (Volume dependent)  
**Fixture Time:** 8-10 Minutes (Volume dependent)  
**Full Cure Time:** 24 Hours

#### PHYSICAL DATA:

**Resin Color:** Clear  
**Hardener Color:** Clear  
**Mixed/Cured Color:** Clear to a slight yellow  
**Tensile Strength:** 3,400 psi  
**HDT (Room Temperature Cure):** 118°F  
**HDT (Post Cure):** 122°F  
**Compressive Strength:** 11,260 psi  
**Cured Density:** 1.10-1.17g/cm<sup>3</sup>

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