



ISO 9001:2015 Certified Company

Technical Data Sheet ADB[®] 4 Minute Clear Epoxy

Revision: 02 November 2017

Characteristics

- ADB[®] 4 Minute Clear Epoxy is a fast setting, non shrinking clear epoxy adhesive.
- ADB[®] 4 Minute Clear Epoxy exhibits a remarkable combination of properties, high mechanical strength, excellent resistance to most chemical environments and reliable heat resistance. It fills gaps and makes strong water resistant and tolerant to most fuels and solvents.
- ADB[®] 4 Minute Clear Epoxy is a two part adhesive of high viscosity which have a good dimensional stability and strong adhesion to a variety of substrates.
- This adhesive also combines reasonable ease of handling with high chemical resistance and mechanical performance after use.
- Most suitable for plastics industries, casting impregnating and potting system industries, electrical or electronic industries and mortar industries.
- Bonding of metals and metal alloys, concrete and stone, rubber and concrete, ceramic materials, glassware, auto trimmings, knobs, china, porcelain, wood, leather, paper, textiles, fiberglass repair etc.

- Assemble bonding surface before mixture become gel.
- After assemble apply suitable pressure on the bonding surface to ensure the mixture would spread evenly and thoroughly between the bonding surfaces.
- Allow cure time for 4-10 minutes. The mixture will be fully cured after 24 hours.
- Application should be carried out in a well ventilated area.

Caution

- Flush immediately with water for any spillage on skin.
- If spill on eye, flush immediately with water and seek oculist treatment immediately.
- Highly inflammable product.

Storage

- Provided the resin and hardener are stored dry and cool in air tight containers, the storage stability will be at least 12 months (before mixing) from day of delivery ex-works.

Every endeavor has been made to ensure that the information given herein is true and reliable but it is given only for the guidance of our customers. The company cannot accept any responsibility for loss or damage that may result from the use of the information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. Users are advised to confirm suitability of this product by their own tests.

Typical Properties

Property	Value
Appearance	Resin (Clear Liquid) Hardener(Clear Liquid)
Viscosity@30°C	Resin 11,000-14,000 cps Hardener 7,000-10,000cps
Main Ingredient	Epoxy Resin
Mixing Ratio	1:1 (by volume)
Pot Life	3-5 minute at room temperature
Curing Time	4-10 minute at room temperature
100%Curing Time	24 hours at room temperature

Application

- In order to secure perfect bonding, it is recommended to pre-treat the surface by removing moisture, dust, grease, rust, paint, oxide and all other foreign matters from the bonding surface before application of ADB[®] 4 Minute Clear Epoxy.
- To obtain the best bonding result it is recommended to use suitable primer on bonding surfaces before applying the adhesive.
- Mixed ADB[®] 4 Minute Clear Resin to ADB[®] 4 Minute Clear Hardener thoroughly in a ratio of 1:1 by volume.
- After mixing, use the entire mixed adhesive within 1 hour.
- Apply a thin layer of ADB[®] 4 Minute Clear mixture on both side of the bonding surface.