

TECHNICAL BULLETIN

SetWORX™ 05 FAST SETTING EPOXY ADHESIVE

SetWORX™ 05 is a fast cure, high strength, structural epoxy adhesive. This adhesive has an excellent combination of shear and peel strength. It has also excellent impact and vibration resistance and low temperature flexibility. This high performance epoxy adhesive exhibits very good physical, thermal, and electrical insulation properties. The high performance epoxy provides excellent bond strengths to a wide variety of plastics and metals.

TYPICAL HANDLING PROPERTIES:

Color	Resin (PART-A)	Clear
	Hardener (PART-B)	Light Amber
Viscosity (25°C), cps	Resin (PART-A)	9,000-12,000
	Hardener (PART-B)	9,000-12,000
Mix Ratio (Resin/Hardener)		1:1
	by weight or volume	
Pot Life at 25°C (20 grams)		3-5 minutes
Shelf life at 25°C		1 Year
Fixture Time, min		10-15 @ 25°C
Recommended Cure		12 hrs. @ 25°C

TYPICAL CURED PROPERTIES:

Color	Light Amber
Specific Gravity	1.1
Hardness, Shore D	85
Lap Shear Strength to Aluminum, psi	1900
Tensile Elongation, %	1
Service Temperature range, °C	-55 to 120
Dielectric Strength, Volts/mil	490
Dielectric Constant, 1 kHz	4.28
Dissipation Factor, 1 kHz	0.4
Volume Resistivity, ohm-cm	1.0 x 10 ¹⁴

INSTRUCTIONS FOR USE:

- For high strength structural bonds, removal of surface contaminants such as paint, oxide films, oils, dust, mold release agents and all other surface contaminants
- Dual Cartridges:** To use simply insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. If automatic mixing of resin and hardener is desired, attach the mixing nozzle to the end of the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of the adhesive and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.
- Bulk Containers:** Mix thoroughly by weight or volume in the proportions specified in Properties of Uncured Material section. Mix vigorously approximately 15 seconds after uniform color is obtained

FOR INDUSTRIAL USE ONLY:

These materials are intended for industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

PACKAGING OPTIONS:

Available in Pint, Quart, Gallon, and 5-gallon kits. Also available in 50mL and 400mL dual cartridge systems.

WARNING!

Although the system contains low volatility materials, care should be taken in handling. Adequate ventilation of work place and ovens is essential. These materials may cause injury to the skin following prolonged or repeated contact and dermatitis in susceptible individuals. Refer to Safety Data Sheet (SDS) for additional health and safety information.

DISCLAIMER: All data given here is offered as a guide to the use of these materials and not as a guarantee of their performance. The user should evaluate their suitability for own purposes. Properties are typical and should not be used in preparing specifications. Statements are not to be construed as recommendations to infringe any patent.