



TECHNICAL DATA SHEET

CLEARBOND EPOXY

PRODUCT: H-3C 28.4 GR/1 OZ Clear Epoxy Adhesive Kit - TUBES
H-3S 25 ML/.85 OZ Clear Epoxy Adhesive Kit - SYRINGE

DESCRIPTION: A two-component epoxy formula highly concentrated with carefully selected modified curing agents and special high quality additives to provide maximum strength, durability, and ease of application. ClearBond will adhere to vertical surfaces and is formulated for clarity.

APPLICATIONS: Universally used for repairing and bonding electronic components, fiberglass, ceramics, plastic, wood and concrete.

PHYSICAL PROPERTIES:	
Color	Clear
Consistency	Liquid
Pot Life 1 lb. @ 24°C (75°F)	45 minutes
Mixed Viscosity	8,000 cps
Cure Shrinkage	0.0005 in/in
Temperature Resistance	250°F (121°C)
Hardness (Shore, ASTM D 1706)	80D
Compression Strength (ASTM D 695)	11,000 psi
Dielectric Strength (ASTM D 149)	600 volts/mil

CHEMICAL RESISTANCE:	
Hydrochloric Acid 10%	Fair
Hydrochloric Acid 50%	Fair
Sulfuric Acid 10%	Fair
Sulfuric Acid 50%	Fair
Water	Very Good
Ammonia	Very Good
Sodium Hydroxide 10%	Very Good
Gasoline, Oil, Kerosene	Very Good
Mineral Spirits	Very Good
Toluene	Good
Methanol	Fair



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DIRECTIONS: Surfaces must be clean, dry, and preferably roughened for maximum adhesion. For 1 lb. kits add all of the resin (Part A) to all of the hardener (Part B) in the hardener can. For smaller portions, dole out 1 part hardener to 1 parts resin by volume.

MIX THOROUGHLY, making certain that all of the hardener comes in contact with all of the resin. This will ensure proper cure and achieve the stated strengths.

Apply the mixed compound with putty knife, spatula, or similar tool.

CURING TIME: At 75°F (24°C) a ½” (12.5mm) layer of HY-POXY KLEARBOND putty will be hard in approximately 2 hours. FULL cure times are as follows:

<u>TEMPERATURE</u>	<u>WORKING TIME</u>	<u>FULL CURE TIME</u>
60°F (16°C)	90 Minutes	32 Hours
75°F (24°C)	45 Minutes	16 Hours
90°F (32°C)	25 Minutes	8 Hours

Heat lamp or sunlight will accelerate the cure.

NON-WARRANTY: We cannot accept any responsibility or liability for lack of results because the storage, handling, and application of the compound are beyond our control.

H-3C & H-3S ClearBond TDS