



# TECHNICAL DATA SHEET

## CLEARFAST 4-MINUTE CLEAR EPOXY

**PRODUCT:** H-4C 28.4 GR/1 OZ. 4-Minute Cure Clear Epoxy Adhesive Kit - Tubes  
H-4S 25 ML/.85 OZ. 4-Minute Cure Clear Epoxy Adhesive Dual Syringe

**DESCRIPTION:** A two-component fast-cure epoxy formula highly concentrated with modified curing agents and special high quality additives to provide maximum strength, durability and ease of application. CLEARFAST is not affected by gasoline, oil and grease.

**APPLICATIONS:** Repairs and bonds electronic components, fiberglass, ceramics, most plastics, fabrics, glass, wood and concrete.

<b>PHYSICAL PROPERTIES:</b>	
Color	Clear
Consistency	Liquid
Pot Life 1 lb. @ 24°C (75°F)	4 minutes
Mixed Viscosity	9,000 cps
Cure Shrinkage	0.0005 in/in
Temperature Resistance	200°F (94°C)
Hardness (Shore, ASTM D 1706)	85D
Compression Strength (ASTM D 695)	9,000 psi
Dielectric Strength (ASTM D 149)	500 volts/mil

<b>CHEMICAL RESISTANCE:</b>	
Hydrochloric Acid 10%	Fair
Ethanol	Fair
Sulfuric Acid 10%	Fair
Antifreeze-Glycols	Fair
Water	Fair
Ammonia	Fair
Sodium Hydroxide 10%	Fair
Gasoline, Oil, Kerosene	Very Good
Mineral Spirits	Very Good
Toluene	Fair
Methanol	Poor



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**DIRECTIONS:** Surfaces must be clean, dry, and preferably roughened for maximum adhesion. Mix ratio is 1 part hardener to 1 parts resin by volume.

**MIX THOROUGHLY,** for 2 minutes making certain that all of the hardener comes in contact with all of the resin. CLEARFAST sets in approximately 4 minutes.

**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 CLEARFAST putty will be hard in approximately 4 minutes. FULL cure times are as follows:

<b><u>TEMPERATURE</u></b>	<b><u>WORKING TIME</u></b>	<b><u>FULL CURE TIME</u></b>
60°F (16°C)	5 Minutes	20 Hours
75°F (24°C)	4 Minutes	12 Hours
90°F (32°C)	3 Minutes	6 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-4C & H-4S CLEARFAST TDS