



46580/56580

46580/56580 is a thixotropic, extra fast setting, two-component epoxy adhesive. It has a convenient mix ratio, excellent sag resistance when applied to vertical surfaces, and a smooth paste consistency. It is recommended for rapid repairs and electrical and industrial staking. 46580/56580 Extra-Fast Setting Epoxy is an excellent, general-purpose adhesive. It is recommended for the following substrates: Metals, Carbon Steel, Stainless Steel, Aluminum, Plastics, Epoxy, Stone, Wood, Glass, China, and Leather. 46580/56580 is available in the unique DOUBLE-BUBBLE® job sized package as reorder no. 04008.

Technology / Base	Epoxy
Type of Product	Structural Adhesive
Components	Two Component
Curing	Room Temperature (secondary thermal cure)
Appearance / Color	Opaque White
Consistency	Non-sag Liquid

Features and Benefits

- Room temperature cure
- Extra fast setting
- Non Sag Formulation
- Excellent cohesive strength

Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A	465,000 cPs	at 25°C
Viscosity - Part B	400,000 cPs	at 25°C
Viscosity - Mixed	Thixotropic Paste	
Uncured Material Characteristics		
Specific Gravity - Part A	1.19	
Specific Gravity - Part B	1.15	
Specific Gravity - Mix	1.17	
Volume Mix Ratio	100 to 100	
Weight Mix Ratio	100 to 94	
Gel Time	3 to 5 min	at 25°C 4 gram
Handling Time	15 to 30 min	
Full Cure @ 23°C	24 hours	
Shelf Life	24 months unopened	
Mechanical Properties During Cure		
Overlap Shear Strength		
15 min at 25°C	346 psi	Aluminum, Acid Etched at 25°C
30 min at 25°C	717 psi	Aluminum, Acid Etched at 25°C
60 min at 25°C	1700 psi	Aluminum, Acid Etched at 25°C



Technical Data

Cured Mechanical Properties	Value	Condition/Method
Hardness	83 Shore D	ASTM D2240
Tensile Strength	7,250 psi	ASTM D638
Elongation at Break	8.5%	ASTM D638
Overlap Shear Strength		
Aluminum, Acid Etched at 25°C	3712 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at -40°C	830 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 38°C		ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 66°C		ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 82°C	425 psi	ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 93°C		ASTM D1002, 25°C 50% RH
Aluminum, Acid Etched at 149°C	174 psi	ASTM D1002, 25°C 50% RH
T-Peel Strength		
T-Peel Strength at 25°C	2.7 pli	Acid etched Al-Al
T-Peel Strength at -40°C	1.0 pli	Acid etched Al-Al
T-Peel Strength at 82°C	2.0 pli	Acid etched Al-Al
Operating Temperature	82°C (180°F)	

General Instructions

Fast-Setting Epoxy can be used to repair tools, auto parts, electrical and electronic components, furniture and other applications that require a fast-setting adhesive. Surface must be clean and dry before application. Remove all chemicals, dirt, wax and oil. To obtain the best cured properties, accurate proportioning and thorough mixing are essential.

Specifications and Approvals

Handling and Clean-Up

See SDS for handling and clean-up information.

Storage

These materials should be stored in a dry environment within a temperature range of 16 °C to 27 °C (60°F to 80 °F). Extremes of temperature beyond this range may result in crystallization or polymerization of the materials. Introduction of a nitrogen blanket into the containers before closing will improve the storage life of the products.

Safety and Disposal

See SDS for

Royal Adhesives and Sealants, LLC
 2001 W. Washington Street
 South Bend, IN 46628

www.hbfuller.com

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