

# OCI®/Orgafix Fast-Set 4 Mins Epoxy (Tran)



## Technical Data Sheet

### Physical Data

|                     |   |
|---------------------|---|
| Appearance          | Fastset 4 mins Resin (White Liquid)<br>Fastset 4 mins Hardener (Black Liquid)               |
| Viscosity at 30 ° C | Fastset 4 Mins Resin - 15,000 - 17,000 cps<br>Fastset 4 Mins Hardener - 17,000 - 20,000 cps |
| Main Ingredient     | Epoxy Resin   |
| Mixing Ratio        | 1 : 1 (by volume)   |
| Pot Life            | 3-5 mins at room temperature  |
| Curing Time         | 6 -10 mins at room temperature  |
| 100 % Curing Time   | 24 hours at room temperature  |

### Characteristics

- OCI / Orgafix Fastset 4 Minutes Grey Epoxy is a fast setting, non shrinking grey epoxy adhesive.
- OCI / Orgafix Fastset (grey) Epoxy exhibit 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.
- OCI / Orgafix Fastset (grey) 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 combine 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 repairs etc.

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### Application

- In order to secure perfect bonding, it is recommended to pretreat the surface by removing moisture, dust, grease, rust, paint, oxide and all other foreign matters from the bonding surface before application of OCI / Orgafix Fastset 4 Mins (grey) Epoxy.
- To obtain the best bonding result it is recommended to use suitable primer on bonding surfaces before applying the adhesive.
- Mixed OCI / Orgafix Fastset resin to Fastset hardener thoroughly in a ratio of 1 : 1 by volume. After mixing, use all the mixed adhesive within 1 hour.
- Apply a thin layer of OCI / Orgafix Fastset 4 Mins mixture on both side of the bonding surface.
- 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 15 minutes. The mixture will be fully cure 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 9 months ( before mixing) from day of delivery ex-works.

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