

Working Time	4 to 8 minutes (at 75°F/ 24°C)
Fixture Time	10 to 15 minutes (at 75°F/ 24°C)
Can be Moved In	20 to 25 minutes
Operating Temp.	65°F to 85°F (18°C to 30°C)
Gap Filling	.250 inches
Mixed Density	8.1 lbs/gal (.97 g/cc)
Flash Point 51°F (11°C)	See MSDS for more safety information
Uncured Properties	Resin / Activator
Viscosity(cps)	25,000-60,000 / 100,000–140,000
Color	Translucent / Amber
Mix Ratio (wt or vol)	1:1

Lap Shear Performance	Substrate	Results	Failure Type
Strength, psi	Acrylic Solid Surface	2,500–3,000	Cohesive
Strength, psi	Polyester Solid Surface	2,500–3,000	Substrate
Strength, psi	Steel/Stainless Steel	2,800–3,500	Cohesive
Strength, psi	Aluminum	2,000–2,500	Cohesive