

DOUBLE/BUBBLE® Red Extra-Fast Setting Epoxy

DOUBLE/BUBBLE® Red Fast-Setting Epoxy is an extra fast setting, two-component, room temperature curing epoxy adhesive. The system will cure at as low as $-18\text{ }^{\circ}\text{C}$ ($0\text{ }^{\circ}\text{F}$). It has a convenient mix ratio, excellent cohesive strength and bonds to most substrates including metal, wood, concrete, ceramics and many plastics. It is recommended for fast patching, fixturing and other repairs requiring quick handling strength. DOUBLE/BUBBLE® Red Fast-Setting Epoxy is an excellent, general-purpose adhesive. This product can be used to repair tools, auto parts, electrical and electronic components, furniture and other applications that require a fast-setting adhesive.

Technology / Base	Epoxy
Type of Product	Structural Adhesive
Components	Two-component
Appearance / Color	Amber
Consistency	Thick Viscous Liquid

Features and Benefits

- Bonds plastic, metal, ceramic, concrete, wood, and stone
- Room temperature cure
- Extra fast setting
- Excellent cohesive strength

Technical Data

Typical Working Properties	Part A	Part B	Mixed
Color	Amber	Amber	Amber
Viscosity @ $25\text{ }^{\circ}\text{C}$, cps	55,000	10,000	40,000
Weight per Gallon, lbs.	10	9.4	9.7
Specific Gravity @ $25\text{ }^{\circ}\text{C}$	1.2	1.13	1.16
Flash Point, PMCC, $^{\circ}\text{C}$	157	132	---
Work Time, minutes	---	---	3
Handling Strength, minutes	---	---	15 - 30
Shelf Life, months	24	24	---

Typical Cured Physical Properties	Value
Hardness, Shore D	80
Maximum Service Temp.	$82\text{ }^{\circ}\text{C}$ ($180\text{ }^{\circ}\text{F}$)
Lap Shear Strength of Acid-etched Aluminum to Aluminum (various cure schedules)	
Shear Strength @ $25\text{ }^{\circ}\text{C}$ for 15 min	150 psi
Shear Strength @ $25\text{ }^{\circ}\text{C}$ for 30 min	1,000 psi
Shear Strength @ $25\text{ }^{\circ}\text{C}$ for 60 min	1,500 psi
Lap Shear Strength of Acid-etched Aluminum to Aluminum (cure schedule 24 hrs. @ $25\text{ }^{\circ}\text{C}$)	
Shear Strength @ $-40\text{ }^{\circ}\text{C}$	1,695 psi
Shear Strength @ $25\text{ }^{\circ}\text{C}$	3,000 psi
Shear Strength @ $38\text{ }^{\circ}\text{C}$	2,400 psi
Shear Strength @ $66\text{ }^{\circ}\text{C}$	1,100 psi
Shear Strength @ $82\text{ }^{\circ}\text{C}$	655 psi
Shear Strength @ $93\text{ }^{\circ}\text{C}$	300 psi
Shear Strength @ $149\text{ }^{\circ}\text{C}$	245 psi
T-Peel Strength of Acid-etched Aluminum to Aluminum (cure schedule 24 hrs. @ $25\text{ }^{\circ}\text{C}$)	
Peel Strength @ $-40\text{ }^{\circ}\text{C}$	1.5 pli
Peel Strength @ $25\text{ }^{\circ}\text{C}$	1.8 pli
Peel Strength @ $82\text{ }^{\circ}\text{C}$	2.5 pli

Recommended For

Metals	Plastic	Other
<ul style="list-style-type: none">• Carbon Steel• Stainless Steel• Aluminum	<ul style="list-style-type: none">• Epoxy	<ul style="list-style-type: none">• Stone• Wood• Glass• China• Leather

Storage Conditions

Store DOUBLE/BUBBLE adhesives at room temperature in a dry environment. Extreme low temperatures may cause crystallization. Extreme high temperatures may degrade the properties.

A wide variety of cleaning solutions are available for cured and uncured epoxies and polyurethanes

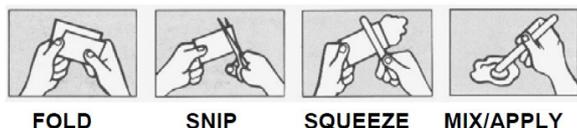
Typical Packaging

The DOUBLE/BUBBLE package is a handy, dual-pouch, one-shot, job-size packaging concept. It reduces the waste typically associated with the use of larger quantities of two-component adhesives. This unique packaging ensures that DOUBLE/BUBBLE adhesives are always factory fresh and accurately portioned for optimum adhesive performance.

DOUBLE/BUBBLE Fast-Setting Epoxy is also available in poly bottles, 1-gallon cans, 5-gallon pails and 55-gallon drums.

Application Instructions

Surface must be clean and dry before application. Remove all chemicals, dirt, wax and oil.



Fold the DOUBLE/BUBBLE package along the center seal, snip the end, squeeze out the contents, mix thoroughly and apply.

Safety and Disposal

These materials are intended for commercial and industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use. Although the system contains low volatility materials, care should be taken in handling. Use adequate ventilation in the work area.

These materials may cause dermatitis in susceptible individuals. Keep off skin and out of eyes. In case of accidental skin contact, wash thoroughly with soap and water. In case of eye contact, flush eyes thoroughly with water and consult a physician immediately.

Refer to Material Safety Data Sheet for additional information.

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