MAS
TIME SAVING EPOXY RESINS

CRACKZILLA

EPOXY PASTE ADHESIVE

TECHNICAL DATA BULLETIN

SYSTEM BENEFITS:

MAS Crackzilla is two-part epoxy adhesive system conveniently packaged in a cartridge. Can be easily dispensed from a standard caulking gun eliminating the mixing and mess of working with epoxy. This quick curing clear epoxy is excellent for filling, sealing and laminating. Crackzilla has a low viscosity and conveniently mixes itself with the included mixing nozzles.

- Convenient cartridge fits a standard caulking gun
- Cures quickly for fast filling, laminating or gluing projects
- Can be drilled or tapped after full cure

HANDLING PROPERTIES	MAS CRACKZILLA	Test Method
Resin Density at 25°C, lbs/gal	9.4	ASTM D1475
Hardener Density at 25°C, lbs/gal	8.6	ASTM D1475
Resin Viscosity at 25°C, cP	2,300	ASTM D2196
Hardener Viscosity at 25°C, cP	470	ASTM D2196
Mix Ratio by Weight	100A : 46B	Calculated
Mix Ratio by Volume	2A : 1B	Calculated
Initial Mixed Viscosity 25°C, cP	1,100	ASTM D2196
Gel Time at 25°C, 150g mass, min.	10	ASTM D2471
Tack Free Time at 25°C, hours	2	Thin Film
Full Cure at 25°C, days	2	
Minimum Recommended Temp, °F	55	

PHYSICAL PROPERTIES	MAS CRACKZILLA	Test Method
Color	Clear	Visual
Izod Impact, Notched, ft-lb/in	0.69	ASTM D256
Tensile Strength, psi	9,500	ASTM D638
Tensile Modulus, psi	458,000	ASTM D638
Tensile Elongation, %	7.2	ASTM D638
HDT, Post Cure, °F	146	ASTM D648
Compressive Strength, psi	11,200	ASTM D695
Flexural Strength, psi	15,000	ASTM D790
Flexural Modulus, psi	415,000	ASTM D790
Cured Density, g/cm^3 (lbs/in^3)	1.15 (0.041)	ASTM D792
Volumetric Shrinkage, %	4.5	ASTM D792/2196
Hardness, Shore D	85	ASTM D2240
Tg, Midpoint, °F	153	ASTM D3418

INSTRUCTIONS FOR USE:

For best results use this product at or above 55°F. Surfaces should be clean, dry and sanded before application to remove dirt, dust, grease, loose paint, oils or other contaminants. The adhesive will gel in about 30 minutes at 77°F. Assemble and clamp parts in position before the adhesive begins to gel. Keep parts clamped until the adhesive is cured, about 24 hours. Cure time is faster at warmer temperatures and slower at cooler temperatures.

MIXING:

Remove retaining nut and nose plug from the top of the cartridge. Insert the cartridge into a caulk gun. Dispense a small amount of material from the cartridge before attaching the static mixing nozzle to ensure that the two components (Part A and Part B) are flowing from both sides of the cartridge nozzle. Attach the static mixing nozzle to the cartridge and if necessary, reinstall the retaining nut. Tighten firmly. Trim the tip of the static mixing nozzle to deliver the desired size bead. Material should flow from the static mixing nozzle in one uniform color when dispensed. The adhesive may also be dispensed without a static mixing nozzle, but must be dispensed into a cup and thoroughly mixed before application.

STORAGE AND CRYSTALLIZATION:

Store between 60-90°F in a dry place. After use, tightly reseal all containers and store products on a raised surface during cold weather and avoid storing near outside walls or doors. If available, purge with dry nitrogen to preserve color and minimize moisture contamination. Do not allow to freeze during winter storage. Do not use material with any signs of crystallization such as solid chunks, grainy texture or white color. Crystallization can be reversed by heating the material to 125-140°F, and stirring occasionally, until all crystals dissolve.

SAFETY HANDLING:

Wear protective gloves, clothing, and eye/face protection. Use only outdoors or in a well-ventilated area. Avoid contact to the skin and eyes. Avoid breathing dust, fumes, gas mist, vapors and spray. Wash hands thoroughly after handling. Take off contaminated clothing and wash before reuse. These products may cause skin and respiratory allergic reactions. Consult product Safety Data Sheets for complete precautions for use of this product.

Polytek Development Corp has experience only in the compounding of resins and hardeners and not in the actual manufacture of tools or parts. Each piece is different. The user should run tests to assure the suitability of the system for use in a particular application. The test data and results set forth herein are based on laboratory work and do not necessarily indicate the results that the buyer or user will attain.

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Revised March 2026