

### SYSTEM BENEFITS:

MAS Gluzilla Fast is a Fast setting two-part epoxy paste adhesive 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 opaque colored epoxy paste is excellent for bonding, sealing, and filleting applications. Vaseline like consistency holds glue lines without dripping or sagging. Gluzilla Fast can be painted, drilled, machined, sanded, tapped or cut after full cure.

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

### HANDLING PROPERTIES

|                                      | MAS GLUZILLA FAST | Test Method |
|--------------------------------------|-------------------|-------------|
| Resin Color                          | Buff              | Visual      |
| Hardener Color                       | Amber             | Visual      |
| Resin Density at 25°C, lbs/gal       | 9.6               | ASTM D1475  |
| Hardener Density at 25°C, lbs/gal    | 9.2               | ASTM D1475  |
| Mix Ratio by Weight                  | 100A : 46         | Calculated  |
| Mix Ratio by Volume                  | 2A : 1B           | Calculated  |
| Initial Mixed Viscosity 25°C, cP     | Thixotropic       | ASTM D2196  |
| Thixotropic Index, 1/10 RPM          | 7.5               | ASTM D2196  |
| Gel Time at 25°C, 150g mass, minutes | 10-15             | ASTM D2471  |
| Vertical Sag Resistance, inches      | 0.5               |             |

### PHYSICAL PROPERTIES

|                                       | MAS GLUZILLA FAST | Test Method |
|---------------------------------------|-------------------|-------------|
| Color                                 | Buff              | Visual      |
| Tensile Strength, psi                 | 8,500             | ASTM D638   |
| Tensile Modulus, psi                  | 372,000           | ASTM D638   |
| Tensile Elongation, %                 | 7.4               | ASTM D638   |
| HDT, Post Cure, °F                    | 122               | ASTM D648   |
| Compressive Strength, psi             | 9,600             | ASTM D695   |
| Flexural Strength, psi                | 13,200            | ASTM D790   |
| Flexural Modulus, psi                 | 393,000           | ASTM D790   |
| Hardness, Shore D                     | 82                | ASTM D2240  |
| Tensile Adhesion, Wood, psi           | 1,380             | ASTM D4541  |
| Tensile Adhesion, Aluminum, psi       | 1,890             | ASTM D4541  |
| Tensile Adhesion, G-10, Laminate, psi | 2,030             | ASTM D4541  |

## 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. For best results use a caulk gun with an 8 to 1 thrust ratio or higher. 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.

Endurance Technologies, Inc. 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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