



A Meridian Adhesives Group Company

## Fast Cure Thixotropic Epoxy Adhesives

**10-3005 NS – 5 MINUTE SET NON-SAG EPOXY**

**10-3020 NS – 20 MINUTE SET NON-SAG EPOXY**

**10-3046 NS – 46 MINUTE SET NON-SAG EPOXY**

### DESCRIPTION:

These high bond strength adhesives are clear 100% solids, two component, non-sag adhesives with a quick setting time of 5-46 minutes at room temperature. They are excellent for bonding plated metals, pewter, glass, wood, ceramic, felt, cement, gemstones, most plastics and rubbers, etc...

These adhesives were tested in our laboratory for flame retardancy properties. According to our test results they meet the requirements of UL94HB.

### APPLICATIONS:

These unique adhesives are ideally suited for a wide range of electronic, electrical, industrial, structural, and jewelry applications. These adhesives are also an excellent choice for field repairs. They are offered in the popular TriggerBond® dual barrel cartridge dispensing system and bulk packaging.

### FEATURES:

- Non-sag consistency
- High bond strength
- Fast room temperature cure – three speeds to choose from
- Water & chemical resistance
- Outstanding thermal shock resistance
- 1:1 mix ratio
- Impact resistance

### TYPICAL SPECIFICATIONS (10-3005NS)

Mixed viscosity, 25°C cps*	Non-Sag
Color	Semi-transparent (available in black)
Hardness, Shore D	
10-3005NS	86
10-3020NS	72
10-3046NS	65
Mix ratio by volume	1:1
Work Life, 25°C, minutes	
10-3005NS	3-5
10-3020NS	10-15
10-3046NS	25-30
Handling time, 25°C, minutes	
10-3005NS	15-20
10-3020NS	30-35
10-3046NS	55-60
Operating temperature range, °C	-50 to +130
Specific gravity, 25°C	1.15

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21 Starline Way  
Cranston, RI 02921 USA

t 401.946.5564

f 401.946.5526



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Cure time, 25°C, hours	24-48
Solids content, %	100
Dielectric Constant, 25°C, 1 kHz	4.00
Dissipation Factor, 25°C, 1 kHz	.017
Dielectric Strength, V/mil	420
Volume Resistivity, 25°C, ohm-cm	$2.0 \times 10^{14}$
Coefficient of Expansion, 1/k	60

Izod Impact, ft-lb/in	2.7
Shear strength, psi	
Aluminum (etched)	1,500
Cold rolled steel	1,000
Copper	960
Brass	725
Stainless Steel	750
Galvanized Steel	900
ABS	500
PVC	335
Polycarbonate	250
Compression strength, psi	8,500
Coverage, .005 in. bond line,	
sq. ft./gallon	320

\* Also available in lower viscosity versions (10-3005, 10-3020, 10-3046).

## INSTRUCTIONS FOR USE:

1. Thoroughly mix equal parts of resin to catalyst by weight or volume.
2. Apply evenly to both surfaces within five minutes. Larger quantities and/or higher temperatures will reduce the working time and may create a high exothermic reaction.
3. Join the coated surfaces. Cure at 16°C or higher until the adhesive is set. Heat may be added up to 93°C to accelerate the cure.
4. Avoid moving parts during cure. Pressure to the substrates is recommended. Maximum shear strength is obtained with a 3-5 mil bond line.

## PREPARATION OF SURFACES:

Surfaces to be bonded must be clean and grease free. Adhesion can be substantially increased by abrading the surface with sandpaper or similar abrasives. A roughened porous surface will produce the best results. Any oxidized metal films should be removed just prior to application of the adhesives.

## PACKAGING:

Available in the TriggerBond® 50ml, 75ml, 200ml and 400ml dual barrel cartridges. Also packaged in quarts, gallons, and 5-gallon pails.

## STORAGE & HANDLING

Store at room temperature. Expected shelf life is 12 months in original unopened containers. Please read the Safety Data Sheet before using this or any other chemical.

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