

2 Ton Epoxy

ORDERING INFORMATION

	<u>Stock No.</u>	<u>Package Size</u>
	14310	28ml Dev-Tube
	14260	50ml Cartridge
	20242	400ml Cartridge
Description	A high strength, non-shrinking, adhesive/potting compound specially formulated for high clarity, good impact strength, and water resistance. The adhesive bond is resistant to weathering, solvents, and wide variations in temperature.	
Features	<ul style="list-style-type: none"> • 100% reactive, no solvents • Good water and chemical resistance • Fills gaps and voids • Room temperature curing 	
Recommended applications	<ul style="list-style-type: none"> • Bonding or potting electronic components and assemblies • Creating moisture-resistant seals • Suitable for bonding ceramics, ferrous and non-ferrous, ferrites, wood, glass and concrete 	

PRODUCT DATA

Physical Properties (Uncured)	Colour	Clear
	Mixed Viscosity	8,000cps
	Mixed Ratio by Volume and weight	1:1
	Mixed Density	1.10 gm/cc
	Working time 28 grams @ 23°C	8 – 12 minutes
	Fixture time @ 23°C	30 – 35 minutes
	Functional cure @ 23°C	2 hours
	Full Cure	12 hours
Physical Properties (Cured)	7 days cured @ 24°C	
	Adhesive tensile shear, ASTM D1002	15.5 MPa (0.25 mm bondline)
	T peel	4-5 N/10mm
	Tensile Elongation	1%
	Service temperature, dry	-40 – 93°C
	Cured hardness, ASTM D2240	83D
	Dielectric strength, ASTM D149	600 volts/mil
	Compression strength, ASTM D695	75.86 MPa
	Specific Volume	909 cm ³ /kg
Chemical Resistance	7 days room temperature cure (30 days immersion)	
	Acetic (dilute) 10%	Poor
	Ammonia	Very Good
	Cutting oil	Excellent
	Petrol (unleaded)	Excellent
	Hydrochloric 10%	Poor
	Kerosene	Excellent
	Mineral Spirits	Excellent
	Sodium Hydroxide 10%	Very Good
	Acetone	Fair
	Corn Oil	Excellent
	Ethanol	Poor
	Glycols/Antifreeze	Excellent
	Isopropanol	Poor
	MEK	Poor
	Motor Oil	Excellent
	Sulphuric 10%	Poor

Please consult ITW Devcon for other chemicals

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APPLICATION INFORMATION

General Surface Preparation	2 Ton Epoxy works best on clean surfaces. Surfaces should be free of heavy deposits of grease, oil, dirt or other contaminants or cleaned with industrial cleaning equipment such as vapor degreasers or hot aqueous baths. Abrading or roughing the surfaces of metals will increase the microscopic bond area significantly and optimize the bond strength.
Mixing	<p>This product is available in cartridge and 28g Devtube form only.</p> <p>The cartridge should be used with the appropriate manual Applicator Gun and Static Mixer Nozzle.</p> <p>The Static Mixer Nozzle enables the epoxy to be dispensed, metered and directly applied to the surfaces to be bonded.</p> <p>Please note: Once the product cures in the nozzle it has to be thrown away and a new nozzle used.</p> <p>For small amounts use Devcon's 28g Devtube, which comes with its own plunger to extrude the two components at an equal rate.</p>
Application	<p>Apply mixed epoxy directly to one surface in an even film or as a bead. Assemble with the mating part within the recommended working time. Obtain firm contact between the parts to minimize any gap and ensure good contact of the epoxy with the mating part. A small fillet of epoxy should flow out the edges to show there is adequate gap filling. For very large gaps, apply epoxy to both surfaces and spread to cover the entire area, or make a bead pattern, which will allow flow throughout the joint.</p> <p>Let bonded assemblies stand for the recommended functional cure time before handling.</p> <p>They are capable of withstanding processing forces at this point, but should not be dropped, shock loaded or heavily loaded.</p>
Storage Shelf Life	Devcon Epoxy Adhesives should be stored in a cool dry place when not used for a long period of time. A shelf life of 3 years from date of manufacture can be expected when stored at room temperature (22°C) in their original containers
Precaution	For complete safety and handling information, please refer to the appropriate Material Safety Data Sheets prior to using this product.
Warranty	Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.
Disclaimer	<p>All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.</p> <p>For product information visit www.devconeurope.com alternatively for technical assistance please call +44 (0) 870 458 7388 (UK) or +49 431 718830 (Germany)</p>