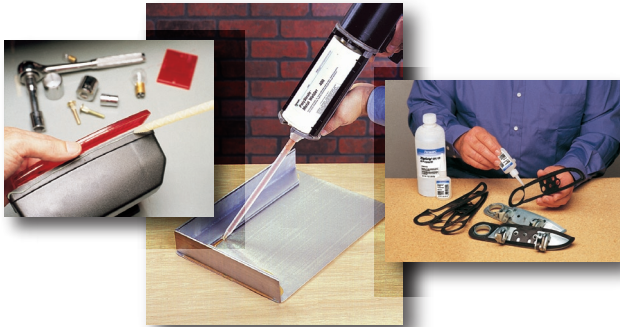




SELECTOR GUIDE

OEM Original Equipment Manufacturer Adhesives



PRODUCT	DESCRIPTION	COLOR	MIXED VISCOSITY (cps) ¹	WORKING TIME (min.) ²	FIXTURE TIME (hrs.) ³	FUNCTIONAL CURE (hrs)	OPERATING TEMP. (DRY) RANGE (°F)	TENSILE SHEAR (psi) ⁴	PEEL STRENGTH (pli) ⁵	IMPACT RESISTANCE (ft-lb/inch ²)	TENSILE ELONGATION (%)
CYANOACRYLATES											
ZipGrip® TE 500	• Low viscosity • Toughened black	Black	500	5-10 sec	-	24	-65-280	3,700	2	5	-
ZipGrip® TE 1000	• Medium viscosity • Gap filling	Clear	1,000	10-20 sec	-	24	-65-280	3,700	2	5	-
ZipGrip® TE 2400	• Medium viscosity • Gap filling • High temp.	Clear	2,400	20-40 sec	-	24	-65-280	3,700	10	8	-
ZipGrip® TE 5000	• High viscosity • Gap filling	Black	5,000	40-70 sec	-	24	-65-280	3,700	10	8	-
METHACRYLATES											
Plastic Welder™	• Toughened fast-setting structural acrylic • For bonding dissimilar substrates, unprepared metals, ceramics, wood and standard engineered plastics • Virtually no surface preparation is required	Off-White	50,000	4-6	10-15	3/4-1	-67 to 250	3,500	35-40	22.0	15-25
Plastic Welder™ White	• Toughened fast-setting structural acrylic • For bonding dissimilar substrates, unprepared metals, ceramics, wood and standard engineered plastics • Virtually no surface preparation is required	White	50,000	4-6	10-15	3/4-1	-67 to 250	3,000	35-40	22.0	15-25
Plastic Welder™ Black	• Toughened fast-setting structural acrylic • For bonding dissimilar substrates, metals, ceramics, wood and standard engineered plastics • Virtually no surface preparation is required	Black	50,000	4-6	10-15	3/4-1	-67 to 250	3,000	35-40	22.0	15-25
Plastic Welder™ II	• Structural acrylic adhesive • For hard-to-bond substrates like nylon 6/6, modified polyesters and epoxy composites • Superior environmental and chemical resistance • Medium set speed	Off-White	56,000	15-20	30-35	2-4	-67 to 250	3,000	15-20	17.0	5-15
Flex Welder™	• Toughened, highly-filled structural acrylic • Superior gap-filling, flexibility, and broad substrate bonding capabilities	Off-White	52,000	9-12	40-45	2-4	-67 to 250	1,500	22-27	20.0	120
Flex Welder™ FC	• Toughened, Fast Curing highly-filled structural acrylic • Superior gap-filling, flexibility, and broad substrate bonding capabilities	Off-White	53,000	3-5	11-15	1	-67 to 250	1,500	22-30	19.0	110
Composite Welder™ FS	• Flexible adhesive for structural bonding of thermoplastic, thermoset, metal and composite assemblies • Flexible, high strength physical properties on dissimilar substrates	Blue/Green	120,000	4-8	10-15	3/4-1	-40 to 250	2,250	60-65	22.0	100-125
Composite Welder™ FS Black	• Flexible adhesive for structural bonding of thermoplastic, thermoset, metal and composite assemblies • Flexible, high strength physical properties on dissimilar substrates	Black	120,000	4-8	10-15	3/4-1	-40 to 250	2,250	60-65	22.0	100-125
Metal Welder™	• Fast-curing adhesive for structural bonding of aluminum, steel, and stainless steel • Little to no surface preparation or primers	Gray/Beads	55,000	4-6	25-30	1-2	-67 to 250	2,450	>80	20.0	50-75
Metal Welder™ II	• Slower curing methacrylate for structural bonding of aluminum, steel, and stainless steel with • Little to no surface preparation	Gray/Beads	90,000	14-16	35-40	4	-67 to 250	2,520	50	20.0	90-110
Flexbond™ Pipe Sealant	• Low viscosity high strength methacrylate sealant • For joining and sealing PVC, ABS and plastic pipe	Purple	1,580	3-4	9-10	1	200*	1,482	50	-	16
PRIMERS											
Metal Prep 90™	• Fast drying primer for methacrylate adhesives • Durably bonds aluminum and stainless steel alloys • Provides durability in corrosive environments	Light Red	1 in IPA alcohol	-	-	-	-40 to 250	See Data Sheet	See Data Sheet	-	-

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EPOXIES (ASTM Test Method)			(D-1084)				(D-1002)	(D-1876)	(D-256)		
One Minute® Epoxy Gel	• Thixotropic, high strength epoxy adhesive • Fast fixturing	Amber	70,000	0:45	3/4-1	1/2-3/4	-40-200	1,600	2-3	4.5	1
5 Minute® Epoxy	• Rapid curing • General purpose • Clear rigid bond or coating in minutes • Bonds metals, fabrics, ceramics, wood, concrete	Light Amber	10,000	3-6	10-15	3/4-1	-40-200	1,900	2-3	5.5	1
5 Minute® Epoxy FR	• Flame retardant • Rapid curing • Clear, rigid bond in minutes	Gray	115,000	3-5	10-15	2-3	-40-200	2,800	2-3	5.5	1
5 Minute® Epoxy Gel	• Non-migrating creamy gel • Fast curing • Fills gaps • Bonds metals and rigid substrates	Amber	150,000	4-7	10-15	3/4-1	-40-200	2,500	2-3	6.5	1
10 Minute® Epoxy Black and Clear	• Flexible • High peel strength • Ideal for aluminum, steel, brass, galvanized steel, plastics, epoxy and FRP composites	Black Clear	90,000 80,000	10 10	20 20	1 1/2 1 1/2	-67-200 -67-200	2,400 2,400	20-25 20-25	10 10	5 5
2 Ton® Epoxy	• Adhesive/potting compound • High Strength • Non-shrinking • High clarity, good impact strength, & water resistance • Weather & solvent resistant • Wide temperature range	Clear	8,000	8-12	30-35	2	-40-200	2,250	2-3	6.5	1
Epoxy Plus™ 25	• Rubber toughened, non-corrosive structural adhesive • Bonds metals, ceramics composites, & many thermoset plastics • 25 minute working time	Gray	70,000	25	210	24	-40-200	2,750	20-25	10	20
HP 250	• High Performance structural adhesive for assembly applications • High shear strength & impact toughness • High chemical, fatigue and stress resistance • Bonds dissimilar substrates	Straw	105,000	65	5	24	-67-250	3,200	35-40	12	25
Permatex® ANAEROBICS				(GAP FILL)							
Low Strength Purple	• Low strength threadlocker • For spiral screws less than 1/4"	Purple	1,200	.007"	10	6	-65-300	600	-	-	-
Medium Strength Blue	• Medium strength threadlocker • For nuts, bolts and screws up to 3/4" dia.	Blue	1,200	.007"	10	6	-65-300	1,200	-	-	-
Permanent Strength Red	• High strength locking/sealing threadlocker • Provides controlled torque/tension and clamp load on larger nuts and bolts	Red	1,800	.010"	10	6	-65-300	3,000	-	-	-
High Strength Red	• High strength threadlocker • For permanent locking of fasteners up to 1" dia.	Red	500	.007"	10	6	-65-300	3,000	-	-	-
Large Diameter Red	• High strength threadlocker • High viscosity • For fasteners 1" dia. or greater	Red	7,000	.016"	15	6	-65-400	3,000	-	-	-
Penetrating Green	• Low viscosity threadlocker • Wicking grade • High strength	Green	12	.003"	10	6	-65-300	2,000	-	-	-
Bearing Mount for Close Fits	• Low viscosity • For locking cylindrical parts requiring a press fit	Green	125	.005"	10	8	-65-400	3,000	-	-	-
Bearing Mount for Relaxed Fits	• High viscosity • For locking cylindrical parts requiring a slip fit	Green	1,250	.015"	10	8	-65-300	4,000	-	-	-
Hi-Temp. Thread Sealant	• Lock and seal threaded fittings	White	350,000	.020"	60	24	-65-400	800	-	-	-

NOTES

- 1 Viscosity: The thickness of the material as measured by Brookfield Viscometer @ 10 RPM @ 77 °F (25°C).
- 2 Working Time: The maximum allowable time after mixing for application of the adhesive to mate and position parts. This is to insure good surface wetting prior to the start of curing. After the working time, parts must not be disturbed.
- 3 Fixture Time: The time required for the parts to generate sufficient bond strength so as to be handled without deformation of the bond line.
- 4 All tensile shear data as per ASTM D1002 on grit-blasted steel @ a bond line thickness of 0.010".
- 5 T-peel data for epoxies tested @ 7 days cure @ 75 °F per ASTM D1876 on 1" wide 0.020" abraded steel @ 20" per minute separation rate. T-peel data for methacrylates tested on 24 hours cure @ 75 °F per ASTM D1876 on 1" wide alcohol wiped 0.060" 6061-T6 aluminum @ 10" per minute separation rate.