2-TON EPOXY

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

- Formulated for clarity
- Good water and chemical resistance
- Fills gaps and voids
- 100% reactive, no solvents
- Room temperature curing
- Non-corrosive

RECOMMENDED APPLICATIONS

- Bonding or potting electronic components and assemblies
- Creating moisture-resistant seals
- Suitable for bonding ceramic, ferrous and non-ferrous metals, ferrites, wood, concrete

PRODUCT DATA:

Physical Properties - (uncured)

Color	Clear
Mix Ratio by Volume	1:1
Mixed Viscosity	8,000 cps
Working Time 28 GRAMS @ 75°F	10 minutes
Functional Cure @ 75°F	2 hours
Coverage (Based on 25 ml)	152 sq.in. @ .010"
Specific Volume	25.2 in^3/lb.
% Solids by Volume	100

Performance Characteristics - (7 days cured @ 75°F)

Adhesive tensile shear, ASTM D1002	2,250 psi
Operating temperature, dry	-40°F to +200°F
Cured density ASTM D792	1.10 gm/cm^3
Cured hardness, ASTM D2240	83D
Dielectric strength ASTM D149 (volts/mil)	600
Compression strength (ASTM D 695)	11,000 psi
Coefficient of thermal conductivity (ASTM D 696)	.83

Chemical Resistance: 7 days room temperature cure (30 days immersion @ 75°F)

Kerosene	VG	Methanol	F
Hydrochloric Acid	F	Toluene	VG
Chlorinated Solvent	VG	Ammonia	VG
Sulfuric Acid, 10%	F	Sodium Hydroide, 10%	VG

KEY: VG = Very Good F = Fair

PLEASE CONSULT FACTORY FOR OTHER CHEMICALS.

Epoxies are very good in water, saturated salt solution, leaded gasoline, mineral spirits, ASTM #3 oil and propylene glycol. Epoxies are generally not recommended for long-term exposure to concentrated acids and organic solvents.

ITW Devcon, 30 Endicott St., Danvers, MA 01923

APPLICATION INFORMATION

Surface Preparation:

2-Ton Epoxy works best on clean surfaces. Surfaces should be solvent-wiped, free of heavy deposits of grease, oil, dirt or other contaminants, or cleaned with industrial cleaning equipment such as vapor phase 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:

Proper homogeneous mixing of the two epoxy components of resin and hardener are essential for the curing and development of stated strengths. Always mix the two components with clean tools, preferably of a disposable design.

For small amounts, use Devcon's 25 ml Dev-Tube™ package or the 50 ml Dev-Pak with Mark 5 Applicator. If used with a static mix nozzle, the epoxy can be dispensed, metered, mixed, and directly applied to the surfaces to be bonded.

APPLICATION:

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.

Let bonded assemblies stand for the recommended functional cure time before handling. They are capable of withstanding processing forces at this point, but should not be dropped, shock loaded, or heavily loaded.

CURE:

Full bond strength is reached in 16 hours.

STORAGE AND 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 70°F (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.

For technical assistance, please call 1-800-933-8266.

ORDERING INFORMATION: *

Stock No.	Unit Size
14310	25 ml Dev-Tube
14260	50 ml Mark 5 (Dev-Pak)
14360	9 lb.
14280	Mark 5 Applicator Gun
14285	Mark 5 Mix Nozzle
14355	380ml cartridge

*** Consult Customer Service for special packaging at 1-800-626-7226.**

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: 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.