



# PRODUCT CATALOG

855-489-7262

[www.itwadhesives.com](http://www.itwadhesives.com)



Quality, Innovation, Performance, Durability, Versatility, Sustainability





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*(AVAILABLE IN U.S. ONLY) For Canada, contact Permatex Canada (800-924-6994 or 905-693-8900)*

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# Product Capabilities

ITW Performance Polymers offers a wide range of products to mining, coal-fired power, alternative energy (wind), transportation, marine, composites, engineered construction and general industrial markets. Our products are designed to reduce customers' costs by eliminating steps in their manufacturing processes, reducing the number of parts in an assembly or improving the quality of customers' assembled finished goods. The development of such products is accomplished by working through the voice of our customers.

## Mining, Coal-Fired Power, Aggregate and Industrial

- Reduce maintenance/repair/energy costs
- Extend maintenance intervals
- Excellent sliding abrasion resistance
- Prolong equipment of scrubbers, pipe elbows, cyclones, chutes, bins and hoppers
- Protect fan blades, float cells, screw conveyors and augers



## Alternative Energy, Transportation, Marine, Composites, Engineered Construction and General Industrial

- High impact resistance, flexibility, and durability
- Ease of use
- Reduced cycle times
- Patented MMA technology and service
- Sprayable coring materials and barrier coats
- Sprayable filler/primers for use on many substrates
- Polyester adhesive putties for filling and bonding
- Sprayable mold and plug building materials
- Brushable and sprayable radius materials



# Services and Support

The answer is in our advanced adhesive and sealant technologies. The ITW Performance Polymers team understands how demanding today's production environments can be; that's why we take pride in providing you with options and innovative solutions, regardless of the industry. We will use our experience and support teams to help you make the right choices for you and your business.

- Test programs and support to aid in the understanding of how our products will behave on your substrates.
- Technical and sales support with guidance in product selection, application & dispense methods and equipment support.
- Access to the global distribution network via ITW and our strategic partners. Our customers have the ability to obtain quality ITW Performance Polymers branded products and services around the world. The ITW Performance Polymers team understands the challenges presented by the modern production environment and are always available to demonstrate the wide range of bonding products for your applications.

## STRUCTURAL ADHESIVES (1:1)

| Product | Description   | Color                    | Mix Ratio By Vol. | Viscosity, cP                            | Working Time (min) | Fixture Time (min) | Tensile Strength (psi) | Tensile Elongation (%) | Shear Strength (psi) | Gap Fill (inches) |
|---------|---|--------------------------|-------------------|--|--------------------|--------------------|------------------------|------------------------|----------------------|-------------------|
| MA300   | All Purpose, High Strength  | Mixed Color/Straw, Black | 1:1               | A: 40,000-70,000<br>B: 40,000-70,000     | 3-6                | 12-15              | 3,000-4,000            | 5-15                   | 3,000-3,800          | 0.03 - 0.125      |
| MA310   | High Strength Use With "Difficult To Bond" Plastics                         | Mixed Color/Straw        | 1:1               | A: 40,000-70,000<br>B: 40,000-70,000     | 15-18              | 45-55              | 3,500-4,500            | 5-15                   | 3,000-3,500          | 0.03 - 0.125      |
| MA330   | Use With "Difficult To Bond" Plastics                                       | Gray                     | 1:1               | A: 40,000-70,000<br>B: 40,000-70,000     | 15-18              | 30-45              | 3,500-4,500            | 5-15                   | 3,000-3,500          | 0.03 - 0.125      |
| MA530   | All Purpose, High Strength/High Toughness, Medium Open Time                 | Gray, White              | 1:1               | A: 130,000-180,000<br>B: 160,000-215,000 | 30-40              | 90-160             | 2,500-3,500            | 90-160                 | 1,600-2,200          | 0.03 - 0.70       |
| MA560-1 | All Purpose, High Strength/High Toughness, Long Open Time                   | Gray, White              | 1:1               | A: 145,000-185,000<br>B: 170,000-205,000 | 55-70              | 220-240            | 2,500-3,000            | >130                   | 1,600-2,200          | 0.03 - 1          |
| MA590   | All Purpose, High Strength/High Toughness, Long Open Time                   | Gray, White              | 1:1               | A: 175,000-220,000<br>B: 175,000-220,000 | 90-105             | 250-380            | 2,000-2,500            | 130-160                | 1,500-2,200          | 0.03 - 1.5        |
| MA8110  | Bonds metals and dissimilar materials with little to no surface preparation | Gray                     | 1:1               | A: 40,000-70,000<br>B: 40,000-70,000     | 9-11               | 35-50              | 3,100-3,600            | 10-20                  | 1,800-2,300          | 0.03 - 0.375      |
| MA8120  | Bonds metals and dissimilar materials with little to no surface preparation | Gray                     | 1:1               | A: 40,000-70,000<br>B: 40,000-70,000     | 18-22              | 75-90              | 2,500-3,000            | 45-65                  | 1,800-2,300          | 0.03 - 0.375      |

### Plexus® MA300

A two-part methacrylate adhesive designed for structural bonding of thermoplastic, metal, and composite assemblies. This product offers a combination of high strength and stiffness as well as the ability to bond a wide range of materials.

| Mix Ratio by Vol. | Item # (PX) | Size                  | Items Per Case | Color             |
|-------------------|-------------|-----------------------|----------------|-------------------|
| 1:1               | 14300       | 25 ml Twin Cartridge* | 12             | Mixed Color/Straw |
| 1:1               | IT410       | 50 ml Twin Cartridge* | 12             | Black             |
| 1:1               | 30500       | 50 ml Twin Cartridge* | 12             | Mixed Color/Straw |
| 1:1               | IT412       | 400 ml Twin Cartridge | 12             | Black             |
| 1:1               | 30000       | 400 ml Twin Cartridge | 12             | Mixed Color/Straw |
| 1:1               | IT405       | 5 gal Pail Adhesive   | 1              | Mixed Color/Straw |
| 1:1               | IT406       | 5 gal Pail Activator  | 1              | Mixed Color/Straw |
| 1:1               | IT407       | 50 gal Drum Adhesive  | 1              | Mixed Color/Straw |
| 1:1               | IT408       | 50 gal Drum Activator | 1              | Mixed Color/Straw |

### Plexus® MA310

A two-part methacrylate adhesive designed as a medium-curing adhesive system offering a combination of high strength and stiffness as well as the ability to bond a wide range of materials.

| Mix Ratio by Vol. | Item # (PX) | Size                  | Items Per Case | Color             |
|-------------------|-------------|-----------------------|----------------|-------------------|
| 1:1               | 31500       | 50 ml Twin Cartridge* | 12             | Mixed Color/Straw |
| 1:1               | 31000       | 400 ml Twin Cartridge | 12             | Mixed Color/Straw |
| 1:1               | IT435       | 5 gal Pail Adhesive   | 1              | Mixed Color/Straw |
| 1:1               | IT406       | 5 gal Pail Activator  | 1              | Mixed Color/Straw |
| 1:1               | IT408       | 50 gal Drum Activator | 1              | Mixed Color/Straw |
| 1:1               | IT437       | 50 gal Drum Adhesive  | 1              | Mixed Color/Straw |

### Plexus® MA330

A two-part methacrylate adhesive designed for structural bonding of thermoplastic, metal, and composite assemblies. MA330 offers a combination of high strength and stiffness as well as the ability to bond a wide range of materials. Plexus MA330 is gray when mixed.

| Mix Ratio by Vol. | Item # (PX) | Size                  | Items Per Case | Color |
|-------------------|-------------|-----------------------|----------------|-------|
| 1:1               | 33500       | 50 ml Twin Cartridge* | 12             | Gray  |
| 1:1               | 33000       | 400 ml Twin Cartridge | 12             | Gray  |
| 1:1               | IT731       | 5 gal Pail Adhesive   | 1              | White |
| 1:1               | IT732       | 5 gal Pail Activator  | 1              | Black |
| 1:1               | IT741       | 50 gal Drum Adhesive  | 1              | White |
| 1:1               | IT742       | 50 gal Drum Activator | 1              | Black |

\*Filled to approx. 47 ml.

### Plexus® MA530

A two-part methacrylate adhesive designed for use on large structures where a moderate open time product is needed. Plexus MA530 may be used for composite and metal bonding for small to large structures. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA530 is gray when mixed.

| Mix Ratio by Vol. | Item # | Size                  | Items Per Case | Color |
|-------------------|--------|-----------------------|----------------|-------|
| 1:1               | 53000  | 400 ml Twin Cartridge | 12             | Gray  |
| 1:1               | 53500  | 400 ml Twin Cartridge | 12             | White |
| 1:1               | IT203  | 5 gal Pail Adhesive   | 1              | White |
| 1:1               | IT205  | 5 gal Pail Activator  | 1              | Black |
| 1:1               | IT200  | 50 gal Drum Adhesive  | 1              | White |
| 1:1               | IT206  | 50 gal Drum Activator | 1              | Black |

### Plexus® MA560-1

A two-part methacrylate adhesive designed for use on large structures where a long open time product is needed. Plexus MA560-1 is commonly used for bonding stringers and liners into large fiberglass boats with bond lines up to 1" thick. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA560-1 is gray when mixed.

| Mix Ratio by Vol. | Item # | Size                  | Items Per Case | Color |
|-------------------|--------|-----------------------|----------------|-------|
| 1:1               | 56000  | 400 ml Twin Cartridge | 12             | Gray  |
| 1:1               | 56500  | 400 ml Twin Cartridge | 12             | White |
| 1:1               | IT213  | 5 gal Pail Adhesive   | 1              | White |
| 1:1               | IT219  | 5 gal Pail Activator  | 1              | Black |
| 1:1               | IT210  | 50 gal Drum Adhesive  | 1              | White |
| 1:1               | IT211  | 50 gal Drum Activator | 1              | Black |

### Plexus® MA590

A two-part methacrylate adhesive designed for use on large marine structures where a very long open time product is needed. Plexus MA590 is commonly used for bonding stringers and liners into large fiberglass boats with bond lines up to 1" thick. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA590 is gray when mixed.

| Mix Ratio by Vol. | Item # | Size                  | Items Per Case | Color |
|-------------------|--------|-----------------------|----------------|-------|
| 1:1               | 59000  | 400 ml Twin Cartridge | 12             | Gray  |
| 1:1               | IT177  | 5 gal Pail Adhesive   | 1              | White |
| 1:1               | IT178  | 5 gal Pail Activator  | 1              | Black |
| 1:1               | IT170  | 50 gal Drum Adhesive  | 1              | White |
| 1:1               | IT175  | 50 gal Drum Activator | 1              | Black |

| ALUMINIUM | CAST IRON | CHROMIUM | COLD ROLLED STEEL | PAINTED/COATED METALS | PLATED METALS | 6061/6063 | STAINLESS STEEL | ABS      | ACRYLICS (PMMA) | POLYAMIDES (NYLONS) | POLYCARBONATE | POLYESTERS (PBT, PET) | VINYL (PVC) | GEL COATS  | FIBERGLASS | PHENOLICS | RTM | SMC* |
|-----------|-----------|----------|-------------------|-----------------------|---------------|-----------|-----------------|----------|-----------------|---------------------|---------------|-----------------------|-------------|------------|------------|-----------|-----|------|
| METALS    |           |          |                   |                       |               |           |                 | PLASTICS |                 |                     |               |                       |             | COMPOSITES |            |           |     |      |
| ✓         | ✓         |          | ✓                 | ✓                     | ✓             |           | ✓               | ✓        | ✓               |                     | ✓             |                       | ✓           | ✓          | ✓          | ✓         | ✓   | ✓    |
| ✓         |           |          | ✓                 | ✓                     | ✓             |           | ✓               | ✓        | ✓               | ✓                   | ✓             | ✓                     | ✓           | ✓          | ✓          |           | ✓   | ✓    |
| ✓         |           |          | ✓                 | ✓                     | ✓             |           | ✓               | ✓        | ✓               | ✓                   | ✓             | ✓                     | ✓           | ✓          | ✓          |           | ✓   | ✓    |
| ✓         |           |          | ✓                 | ✓                     | ✓             |           | ✓               | ✓        | ✓               | ✓                   |               |                       |             | ✓          | ✓          |           | ✓   | ✓    |
| ✓         |           |          | ✓                 | ✓                     | ✓             |           | ✓               | ✓        | ✓               | ✓                   |               |                       |             | ✓          | ✓          |           | ✓   | ✓    |
| ✓         |           | ✓        | ✓                 | ✓                     | ✓             | ✓         | ✓               | ✓        | ✓               | ✓                   | ✓             | ✓                     | ✓           | ✓          | ✓          | ✓         | ✓   | ✓    |
| ✓         |           | ✓        | ✓                 | ✓                     | ✓             | ✓         | ✓               | ✓        | ✓               | ✓                   | ✓             | ✓                     | ✓           | ✓          | ✓          | ✓         | ✓   | ✓    |

\*Surface abrasion required.

### Plexus® MA8110

With an open time of approximately 10 minutes, MA8110 an advanced direct-to-metal, low halogen two-part methacrylate structural adhesive. It is designed for the structural bonding of various metals, coatings, plastics, and composite assemblies. MA8110 does a superb job of bonding metals without primers to other metals, engineered thermoplastics, and composite assemblies with little to no surface preparation. Combined at a 1:1 ratio by volume, MA8110 can bond hot-dip and electrogalvanized zinc steel and other metals to dissimilar substrates. This product provides an exceptional combination of high strength, toughness, environmental resistance, and fatigue endurance, for industrial and transportation assembly. See the Tech. Data Sheet for more details.

| Mix Ratio by Vol. | Item # | Size                  | Items Per Case | Color |
|-------------------|--------|-----------------------|----------------|-------|
| 1:1               | 81100  | 400 ml Twin Cartridge | 12             | Gray  |
| 1:1               | 81101  | 5 gal Pail Adhesive   | 1              | Gray  |
| 1:1               | 81103  | 5 gal Pail Activator  | 1              | Gray  |
| 1:1               | 81102  | 50 gal Drum Adhesive  | 1              | Gray  |
| 1:1               | 81104  | 50 gal Drum Activator | 1              | Gray  |

### Plexus® MA8120

With an open time of approximately 20 minutes, MA8120 is an advanced direct-to-metal, low halogen two-part methacrylate structural adhesive. It is designed for the structural bonding of various metals, coatings, plastics, and composite assemblies. MA8120 does a superb job of bonding metals without primers to other metals, engineered thermoplastics, and composite assemblies with little to no surface preparation. Combined at a 1:1 ratio by volume, MA8120 can bond hot-dip and electrogalvanized zinc steel and other metals to dissimilar substrates. This product provides an exceptional combination of high strength, toughness, environmental resistance, and fatigue endurance, for industrial and transportation assembly. See the Tech. Data Sheet for more details.

| Mix Ratio by Vol. | Item # | Size                  | Items Per Case | Color |
|-------------------|--------|-----------------------|----------------|-------|
| 1:1               | 81200  | 400 ml Twin Cartridge | 12             | Gray  |
| 1:1               | 81101  | 5 gal Pail Adhesive   | 1              | Gray  |
| 1:1               | 81203  | 5 gal Pail Activator  | 1              | Gray  |
| 1:1               | 81102  | 50 gal Drum Adhesive  | 1              | Gray  |
| 1:1               | 81204  | 50 gal Drum Activator | 1              | Gray  |

\*Filled to approx. 47 ml.

## DISPENSING EQUIPMENT (1:1)

### GUNS

| Item # | Description  |
|--------|--|
| 14280  | <b>Mark V™ Gun Manual Dispensing Gun</b><br>50/35 ml 1:1, 2:1, and 10:1 Ratio Applicator |
| 30020  | <b>Manual Cartridge Dispensing Gun</b><br>400 ml 1:1 and 2:1 Ratio Applicator            |
| 30010  | <b>Pneumatic Cartridge Dispensing Gun</b><br>400 ml 1:1 and 2:1 Ratio Applicator         |

### NOZZLES

| Item # | Description  |
|--------|--|
| 14285  | <b>Mark V™ Mix Nozzle</b><br>50/35 ml 1:1, 2:1, and 10:1 Mix Nozzle    |
| 30095  | <b>Static Mix Nozzle (500 series)</b><br>400 ml 1:1 and 2:1 Mix Nozzle |
| 3333   | <b>Static Mix Nozzle</b><br>1:1, 2:1 and 10:1 Mix Nozzle               |

## STRUCTURAL ADHESIVES (10:1)

| Product       | Description   | Color                           | Mix Ratio By Vol. | Viscosity, cP                              | Working Time (min) | Fixture Time (min) | Tensile Strength (psi) | Tensile Elongation (%) | Shear Strength (psi) | Gap Fill (inches) |
|---------------|---|---------------------------------|-------------------|--|--------------------|--------------------|------------------------|------------------------|----------------------|-------------------|
| MA205HV       | All Purpose, Fast Cure, Toughened   | Blue                            | 10:1              | A:100,000-130,000<br>B: 15,000-50,000      | 3-5                | 7-9                | 2,000-2,500            | 20-50                  | 1,800-2,500          | 0.03 - 0.25       |
| MA320         | Excellent Low Temperature, Toughness Properties   | Mixed Color/Straw, White, Black | 10:1              | A: 135,000-175,000<br>B: 30,000-70,000     | 8-12               | 25-30              | 2,000-2,500            | 100-140                | 1,500-2,000          | 0.03 - 0.375      |
| MA420 (A0420) | All Purpose, High Toughness   | Mixed Color/Straw, Blue, Black  | 10:1              | A: 100,000-125,000<br>B: 35,000-80,000     | 4-6                | 18-22              | 2,700-3,000            | 30-50                  | 3,000-3,800          | 0.03 - 0.375      |
| MA420FS       | Fast Set For Automated Systems  | Mixed Color/Straw, Blue, Black  | 10:1              | A: 80,000-100,000<br>B: 50,000-80,000      | 1-2                | 3-4                | 1,250-1,500            | 5-15                   | 1,300-1,600          | 0.03 - 0.125      |
| MA422         | All Purpose, Medium Open Time   | Mixed Color/Straw, Blue         | 10:1              | A: 100,000-125,000<br>B: 35,000-70,000     | 17-24              | 35-40              | 2,700-3,000            | 75-100                 | 1,600-2,300          | 0.03 - 0.375      |
| MA425         | All Purpose, Long Open Time   | Mixed Color/Straw, Blue         | 10:1              | A: 100,000-125,000<br>B: 35,000-70,000     | 30-35              | 80-90              | 2,000-2,500            | 120-140                | 1,600-2,300          | 0.03 - 0.375      |
| MA550         | Excellent Marine Adhesive, White, UV Stable   | White                           | 10:1              | A: 130,000-160,000<br>B: 35,000-70,000     | 40-50              | 70-75              | 2,000-2,500            | 35-45                  | 1,200-1,800          | 0.03 - 0.375      |
| MA685         | A highly translucent, two-part methacrylate adhesive, with excellent UV resistance. Offer superior adhesion to a variety of plastic materials | Translucent Clear               | 10:1              | A: 180,000 - 240,000<br>B: 30,000 - 40,000 | 8-12               | 15-25              | 3,500-4,500            | >20                    | 1200-1600            | 0.25              |
| MA830         | All Purpose, High Strength/High Toughness, No Primer Metal Bonding  | Gray, Gray GB                   | 10:1              | A: 80,000-120,000<br>B: 35,000-80,000      | 4-6                | 15-25              | 2,000-2,500            | 30-60                  | 2,000-2,800          | 0.012 - 0.50      |
| MA832         | All Purpose, High Strength/High Toughness, No Primer Metal Bonding  | Gray, Gray GB                   | 10:1              | A: 80,000-130,000<br>B: 35,000-80,000      | 12-16              | 55-60              | 2,700-3,000            | 30-60                  | 2,000-2,800          | 0.012 - 0.50      |
| MA920         | Low Odor, All Purpose, High Toughness   | Mixed Color/Straw, Blue, Gray   | 10:1              | A: 80,000-120,000<br>B: 40,000-80,000      | 4-6                | 15-18              | 1,700-2,200            | 80-100                 | 1,500-2,200          | 0.03 - 0.375      |
| MA1020        | Low Shrinkage, Low Odor, All Purpose  | Blue                            | 10:1              | A: 100,000-130,000<br>B: 40,000-80,000     | 4-6                | 15-20              | 1,750-2,000            | 90-110                 | 1,250-1,600          | 0.03 - 0.375      |
| MA1025        | Low Shrinkage, Low Odor, Bond Lines Up To 1" Thick  | Blue                            | 10:1              | A: 180,000-220,000<br>B: 35,000-70,000     | 20-25              | 40-45              | 1,700-2,300            | 90-110                 | 1,200-2,000          | 0.08 - 1.00       |
| MA2015 White  | Excellent UV and Yellowing resistant white adhesive, used for structural bonding composites, metals and thermoplastic assemblies              | White                           | 10:1              | A: 180,000-220,000<br>B: 35,000-70,000     | 12-18              | 40-50              | 2,700-3,200            | 20-40                  | 1,600-2,100          | 0.03 - 1.5        |
| MA2030 White  | Excellent UV and Yellowing resistant white adhesive, used for structural bonding composites, metals and thermoplastic assemblies              | White                           | 10:1              | A: 180,000-220,000<br>B: 35,000-70,000     | 26-34              | 70-90              | 2,700-3,200            | 20-40                  | 1,600-2,600          | 0.03 - 1.5        |
| MA2030        | Non Sag, High Gap Fill, Medium Work Time  | Blue                            | 10:1              | A: 180,000-220,000<br>B: 35,000-70,000     | 25-35              | 70-90              | 3,000-3,400            | 90-125                 | 1,600-2,100          | 0.03 - 1.5        |
| MA2045        | A two methacrylate, Non Sag, with excellent fatigue endurance, outstanding impact resistance, and superior toughness                          | Blue                            | 10:1              | A: 180,000 - 220,000<br>B: 35,000 - 70,000 | 40-50              | 100-130            | 3,000-3,400            | 90-125                 | 1,600-2,200          | .03 - 1.5         |
| MA2090        | Low Exotherm, Bond Lines Up To 1.5" Thick   | Blue                            | 10:1              | A: 180,000-220,000<br>B: 35,000-70,000     | 80-95              | 190-230            | 3,000-3,400            | 90-120                 | 1,600-2,100          | 0.03 - 1.5        |

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## STRUCTURAL ADHESIVES (10:1)

### Plexus® MA205HV

An advanced non-conductive two-part methacrylate adhesive designed for the structural bonding of various electronic assemblies. In addition, MA205HV does a superb job of bonding metals without primers and engineered thermoplastics and composite assemblies with little to no surface preparation. This product provides a unique combination of high-strength, excellent fatigue endurance, outstanding impact resistance, and superior toughness.

| Mix Ratio by Vol. | Item # | Size             | Items Per Case | Color |
|-------------------|--------|------------------|----------------|-------|
| 10:1              | IT025X | 490 ml Cartridge | 12             | Blue  |

### Plexus® MA320

A two-part methacrylate adhesive designed for composite bonding applications in the transportation, marine, and engineering construction industries because it requires virtually no surface preparation. MA320 provides superior toughness at temperatures below 1.4°F (-17°C).

| Mix Ratio by Vol. | Item #  | Size                 | Items Per Case | Color             |
|-------------------|---------|----------------------|----------------|-------------------|
| 10:1              | 32000BX | 490 ml Cartridge     | 12             | Black             |
| 10:1              | 32000X  | 490 ml Cartridge     | 12             | Mixed Color/Straw |
| 10:1              | 32000WX | 490 ml Cartridge     | 12             | White             |
| 10:1              | 32200   | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | 32400   | 5 gal Pail Activator | 1              | Mixed Color/Straw |
| 10:1              | 32900   | 5 gal Pail Activator | 1              | Black             |
| 10:1              | 35420   | 5 gal Pail Activator | 1              | White             |
| 10:1              | 32800   | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

| ALUMINUM | CAST IRON | CHROMATE | COLD ROLLED STEEL | PAINTED/COATED METALS | PLATED METALS | 660/680 | STAINLESS STEEL | ABS      | ACRYLICS (PMMA) | POLYAMIDES (NYLONS) | POLYCARBONATE | POLYESTERS (PB1, PET) | VINYL (PVC) | GEL COATS | FIBERGLASS | PHENOLICS | RTM | SMC* |
|----------|-----------|----------|-------------------|-----------------------|---------------|---------|-----------------|----------|-----------------|---------------------|---------------|-----------------------|-------------|-----------|------------|-----------|-----|------|
| METALS   |           |          |                   |                       |               |         |                 | PLASTICS |                 |                     |               |                       | COMPOSITES  |           |            |           |     |      |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        | ✓         |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        | ✓               | ✓                   | ✓             | ✓                     | ✓           | ✓         | ✓          | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
|          |           |          |                   |                       |               |         |                 | ✓        | ✓               |                     | ✓             |                       |             |           |            |           |     |      |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |
| ✓        |           |          | ✓                 | ✓                     | ✓             |         | ✓               | ✓        |                 | ✓                   |               |                       | ✓           | ✓         |            | ✓         | ✓   | ✓    |

\*Surface abrasion required.

### Plexus® MA420 (A0420)

A rapid curing two-part methacrylate adhesive designed for composite bonding applications in the transportation industry because it requires virtually no surface preparation. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness.

| Mix Ratio by Vol. | Item #  | Size                 | Items Per Case | Color             |
|-------------------|---------|----------------------|----------------|-------------------|
| 10:1              | 35701   | 490 ml Cartridge     | 12             | Black             |
| 10:1              | IT101BX | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT101X  | 490 ml Cartridge     | 12             | Mixed Color/Straw |
| 10:1              | IT102   | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT103   | 5 gal Pail Activator | 1              | Mixed Color/Straw |
| 10:1              | IT107   | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT140   | 5 gal Pail Activator | 1              | Black             |
| 10:1              | IT100   | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

### Plexus® MA420FS

A two-part methacrylate adhesive designed for structural bonding of thermoplastic, metal, and composite assemblies. Plexus MA420FS is a standard choice for composites automated bonding applications in the transportation industry, because it requires virtually no surface preparation and its rapid fixture time.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT800X | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT804X | 490 ml Cartridge     | 12             | Black             |
| 10:1              | IT103  | 5 gal Pail Activator | 1              | Mixed Color/Straw |
| 10:1              | IT107  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT140  | 5 gal Pail Activator | 1              | Black             |
| 10:1              | IT801  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

**OEM ADHESIVES/SEALANTS**

## Plexus® MA422

A two-part methacrylate adhesive designed for composite bonding applications in the transportation and marine industries because it requires virtually no surface preparation. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA422 is blue when mixed. Plexus MA422 is blue when mixed.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT133  | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT132  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT159  | 5 gal Pail Activator | 1              | Blue              |

## Plexus® MA425

A two-part methacrylate adhesive designed for composite bonding applications in the transportation and marine industries because it requires virtually no surface preparation. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA425 is blue when mixed. Plexus MA425 is blue when mixed.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT151X | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT152  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT159  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT150  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA550

A two-part methacrylate adhesive designed for secondary bonding applications in the marine industry because it requires virtually no surface preparation. In addition this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance and superior toughness. This adhesive is bright white and UV stable.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | 35000X | 490 ml Cartridge     | 12             | White             |
| 10:1              | 35420  | 5 gal Pail Activator | 1              | White             |
| 10:1              | 35200  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | 35800  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA685

A two-part methacrylate adhesive designed for thermoplastic and Thermoset assemblies where a clear adhesive is needed. MA685 is highly translucent and clear, with excellent UV stability. It offers excellent adhesion to a variety of Plastic materials including cast acrylic and cast/densified polyester, polycarbonate and PMMA. It exhibits high resistance to water, impact, and UV light. Combined with MA685 activator at a 10:1 ratio, it has a working time of 8 to 11 minutes and achieves handling strength in 20 to 25 minutes.

| Mix Ratio by Vol. | Item # | Size             | Items Per Case | Color              |
|-------------------|--------|------------------|----------------|--------------------|
| 10:1              | 68505  | 35 ml Cartridge  | 12             | Translucent, Clear |
| 10:1              | 68500X | 490 ml Cartridge | 12             | Translucent, Clear |

## Plexus® MA830

A two-part methacrylate adhesive designed for structural bonding of metals without primers. MA830 does a superb job of bonding thermoplastic and composite assemblies with little or no surface preparation. This product provides a unique combination of high strength, excellent fatigue endurance, outstanding impact resistance, and superior toughness.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT194  | 35 ml Cartridge*     | 25             | Gray GB           |
| 10:1              | IT186X | 490 ml Cartridge     | 12             | Gray              |
| 10:1              | IT187X | 490 ml Cartridge     | 12             | Gray GB           |
| 10:1              | IT185  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT262  | 5 gal Pail Activator | 1              | Gray              |
| 10:1              | IT284  | 5 gal Pail Activator | 1              | Gray GB           |
| 10:1              | IT188  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA832

An advanced two-part methacrylate adhesive designed for structural bonding of metals without primers. In addition, MA832 does a superb job of bonding thermoplastic and composite assemblies with little to no surface preparation. This product provides a unique combination of high strength, excellent fatigue endurance, outstanding impact resistance, and superior toughness.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT332X | 490 ml Cartridge     | 12             | Gray              |
| 10:1              | IT331X | 490 ml Cartridge     | 12             | Gray GB           |
| 10:1              | IT330  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT262  | 5 gal Pail Activator | 1              | Gray              |
| 10:1              | IT284  | 5 gal Pail Activator | 1              | Gray GB           |
| 10:1              | IT333  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA920

A breakthrough in methacrylate adhesive technology because it combines high strength, excellent fatigue endurance, and outstanding impact resistance into a low odor product. Plexus MA920 requires virtually no surface preparation on most substrates.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | 35900X | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT103  | 5 gal Pail Activator | 1              | Mixed Color/Straw |
| 10:1              | IT107  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT140  | 5 gal Pail Activator | 1              | Black             |
| 10:1              | 35910  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA1020

A two-part methacrylate adhesive with very low cure shrinkage and very low odor designed for structural bonding because it requires virtually no surface preparation. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA1020 is blue when mixed.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT222X | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT220  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT107  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT225  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA1025

A two-part methacrylate adhesive with very low cure shrinkage and very low odor designed for structural bonding in the marine industry because it requires virtually no surface preparation. Plexus MA1025 is designed to be used for bonding stringers and liners into fiberglass boats with bond lines up to 1" thick. Plexus MA1025 is blue when mixed.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT232X | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT236  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT237  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT235  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA2015 White

With an open time of approximately 15 minutes, MA2015W is a two-part methacrylate adhesive formulated as an excellent UV and yellowing resistant white solution. This product was designed for structural bonding of thermoplastic, metal, and composite assemblies in the marine and transportation industries. Combined at a 10:1 ratio, MA2015W requires minimal, or no surface preparation and provides an exceptional combination of fatigue endurance, impact resistance and superior toughness.

| Mix Ratio by Vol. | Item # | Size             | Items Per Case | Color |
|-------------------|--------|------------------|----------------|-------|
| 10:1              | 20155  | 490 ml Cartridge | 12             | White |



## Plexus® MA2030 White

With an open time of approximately 30 minutes, MA2230W is a two-part methacrylate adhesive formulated as an excellent UV and yellowing resistant white solution. This product was designed for structural bonding of thermoplastic, metal, and composite assemblies in the marine and transportation industries. Combined at a 10:1 mix ratio, MA2030W requires minimal, or no surface preparation and provides an exceptional combination of fatigue endurance, impact resistance and superior toughness.

| Mix Ratio by Vol. | Item # | Size             | Items Per Case | Color |
|-------------------|--------|------------------|----------------|-------|
| 10:1              | 20305  | 490 ml Cartridge | 12             | White |

## Plexus® MA2030

A two-part methacrylate adhesive designed to eliminate problems associated with adhesive sag and slide, even when applied to a vertical surface. In addition, MA2030 does not boil in gaps up to 1.5" thick. Plexus MA2030 is blue when mixed.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT247  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT030  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA2045

A two-part methacrylate adhesive designed for structural bonding of composite, thermoplastic, and metal assemblies. MA2045 was uniquely formulated to eliminate problems associated with adhesive sag, slide, and swim when applied to either a horizontal or a vertical surface. In addition, MA2045 does not boil in gaps up to 1.5 inches thick. Combined at a 10:1 ratio at 75°F (24°C), it has a working time of approximately 50 minutes and achieves 500 psi and 1000 psi in approximately 100 and 130 minutes, respectively. As with most other Plexus methacrylate systems, MA2045 requires little-or-no surface preparation. MA2045 provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT248X | 490 ml Cartridge     | 12             | Blue              |
| 10:1              | IT247  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT209  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® MA2090

A two-part methacrylate adhesive designed for structural bonding of composite, thermoplastic, and metal assemblies. Plexus MA2090 was uniquely formulated to eliminate problems associated with adhesive sag and slide, even when applied to a vertical surface. In addition, MA2090 does not boil in gaps up to 1.5" thick. As with most other Plexus methacrylate systems, MA2090 requires little to no surface preparation. MA2090 provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness. Plexus MA2090 is blue when mixed.

| Mix Ratio by Vol. | Item # | Size                 | Items Per Case | Color             |
|-------------------|--------|----------------------|----------------|-------------------|
| 10:1              | IT195  | 5 gal Pail Adhesive  | 1              | Mixed Color/Straw |
| 10:1              | IT247  | 5 gal Pail Activator | 1              | Blue              |
| 10:1              | IT221  | 50 gal Drum Adhesive | 1              | Mixed Color/Straw |

## Plexus® Cleaner Conditioner PC-120 (same as Devcon® Metal Prep 90™)

A chemical cleaner and conditioner designed to improve the long-term bond durability of Plexus adhesives when used for adhering aluminum and stainless steel assemblies. Fast drying at ambient temperatures, parts can be bonded 1 to 3 minutes after the conditioner is applied. Application can be performed by brushing or wiping. Allow the PC-120 to dry slightly before wiping away. Only a thin film of PC-120 is needed. The primer contains a red dye. As long as a red tint is slightly visible on the metal surfaces, sufficient conditioner has been applied. Once the conditioner is dry, the parts are ready to bond. Coverage is about 250 square feet per 500 ml.

| Item # | Size                              |
|--------|-----------------------------------|
| IP120  | 1 quart Bottle Primer/Conditioner |

## DISPENSING EQUIPMENT (10:1)

| GUNS    | Item # | Description   |
|---------|--------|---|
|         | 14280  | Mark V™ Gun Manual Dispensing Gun<br>50/35 ml 1:1, 2:1, and 10:1 Ratio Applicator |
|         | 30016  | Manual Cartridge Dispensing Gun<br>490 ml 10:1 Ratio Applicator                   |
|         | 30013  | Pneumatic Cartridge Dispensing Gun<br>490 ml 10:1 Ratio Applicator                |
| NOZZLES | Item # | Description   |
|         | 14285  | Mark V™ Mix Nozzle – 50/35 ml 1:1, 2:1, and 10:1 Mix Nozzle                       |
|         | 3333   | Static Mix Nozzle – 1:1, 2:1 and 10:1 Mix Nozzle                                  |
|         | 30076  | Static Mix Nozzle – 490 ml 10:1 Mix Nozzle  |
|         | 30077  | Mix Nozzle – 490 ml 10:1 Bulk Mix Nozzle (600)                                    |

## EPOXY ADHESIVES

Devcon® advanced epoxy adhesives are used for structural bonding, potting and encapsulating, and come in a variety of cure times and package sizes.

### OEM Adhesive Selector Guide

|                             | OEM Material         | One Minute™ Epoxy Gel | 5 Minute™ Epoxy/Epoxy Gel | Dev-Thane™ Adhesives | 10 Minute™ Epoxy | 2 Ton® Clear Epoxy | Epoxy Plus™ 25 | HP 250 | ZipGrip® Adhesives |
|-----------------------------|----------------------|-----------------------|---------------------------|----------------------|------------------|--------------------|----------------|--------|--------------------|
| METAL                       | Aluminum             | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
|                             | Brass                | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
|                             | Cast Iron            | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
|                             | Copper               | ○                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
|                             | Ferrite              | ○                     | ○                         | ●                    | ○                | ○                  | ●              | ●      | ○                  |
|                             | Painted metals       | ○                     | ○                         | ●                    | ○                | ○                  | ○              | ○      | ○                  |
|                             | Plated metals        |                       |                           | ●                    | ○                |                    | ○              | ○      | ○                  |
|                             | Sheet metal          |                       |                           | ●                    | ○                |                    | ●              | ●      |                    |
|                             | Stainless steel      | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
|                             | Cold rolled steel    | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ●                  |
|                             | Galvanized           |                       |                           | ●                    |                  |                    | ○              | ○      |                    |
|                             | PLASTIC              | ABS                   |                           |                      | ○                | ○                  |                | ○      |                    |
| Acrylics (PMMA)             |                      |                       |                           | ○                    | ○                |                    | ●              | ○      | ○                  |
| Fiberglass                  |                      |                       |                           | ○                    | ○                | ○                  | ●              | ●      | ○                  |
| Gel coats                   |                      |                       |                           | ●                    |                  |                    | ●              | ●      |                    |
| Epoxy                       |                      | ○                     | ○                         |                      | ●                | ○                  | ●              | ●      | ○                  |
| Polyamides (Nylon) (6,6/6)  |                      |                       |                           |                      |                  |                    | ○              | ○      | ○                  |
| Polyesters (PET/PBA blends) |                      |                       |                           |                      |                  |                    | ●              | ○      | ●                  |
| Polycarbonate               |                      | ●                     |                           |                      |                  |                    | ○              | ○      | ○                  |
| PPO and PPO blends          |                      |                       |                           |                      |                  |                    |                |        | ○                  |
| Vinyls (PVC)                |                      | ○                     | ○                         |                      | ○                | ○                  | ○              | ○      | ●                  |
| RIM urethanes               |                      |                       |                           |                      |                  |                    |                |        |                    |
| SMCs                        |                      |                       |                           |                      |                  |                    | ○              | ○      |                    |
| Styrene resins              |                      |                       |                           |                      |                  |                    | ○              | ○      | ●                  |
| Polyacrylate                |                      |                       |                           |                      |                  |                    | ○              | ○      |                    |
| Polyurea                    |                      |                       |                           |                      |                  |                    |                |        | ○                  |
| Cellulosics (CAL, CAB, CAP) |                      |                       |                           |                      |                  |                    |                |        | ○                  |
| Polysulfone                 |                      |                       |                           |                      |                  |                    |                |        | ○                  |
| Phenolics                   |                      |                       |                           |                      |                  |                    | ○              | ●      | ○                  |
| Laminates                   |                      |                       |                           |                      |                  | ○                  | ●              | ●      |                    |
| WOOD                        | Wood (hard and soft) | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
|                             | Plywood              | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
|                             | Particle board       | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      | ○                  |
| OTHER                       | Brick                | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      |                    |
|                             | Concrete             | ●                     | ●                         | ●                    | ●                | ●                  | ●              | ●      |                    |
|                             | Rubber               |                       |                           | ●                    |                  |                    |                |        | ●                  |
|                             | Honeycomb            | ○                     | ○                         | ●                    | ○                | ○                  | ●              | ●      |                    |
|                             | Ceramics             | ○                     | ○                         | ●                    | ○                | ○                  | ●              | ●      | ○                  |
|                             | Glass                |                       |                           | ●                    |                  |                    |                |        |                    |

Key: ● Excellent Choice ○ Good Choice ○ Requires Metal Prep 90™ Blank – Not Recommended

### Devcon® 5 Minute® Epoxy

Rapid curing, general-purpose adhesive/encapsulant which easily dispenses and mixes in seconds, dries in 15 minutes and reaches functional strength in 1 hour.

| Item # | Size             | Items Per Case | Dispenser      | Nozzle |
|--------|------------------|----------------|----------------|--------|
| 14250  | 25 ml Dev-Tube™  | 24             | ---            |        |
| 14270  | 50 ml Cartridge  | 12             | 14280 (manual) | 14285  |
| 14210  | 2.5 oz           | 24             | ---            |        |
| DA051  | 400 ml Cartridge | 12             | 14410 (manual) | 3333   |
| 14200  | 15 oz            | 6              | ---            |        |
| 14630  | 9 lb             | 1              | ---            |        |

### Devcon® 5 Minute® Epoxy Gel

Thixotropic, non-migrating gel adhesive with excellent gap filling properties.

| Item # | Size             | Items Per Case | Dispenser      | Nozzle |
|--------|------------------|----------------|----------------|--------|
| 14240  | 25 ml Dev-Tube™  | 24             | ---            |        |
| 14265  | 50 ml Cartridge  | 12             | 14280 (manual) | 14285  |
| DA052  | 400 ml Cartridge | 12             | 14410 (manual) | 30095  |

### Devcon® One Minute™ Epoxy Gel

Lightning fast curing gel adhesive for filling gaps, cracks and holes.

| Item # | Size            | Items Per Case | Dispenser      | Nozzle |
|--------|-----------------|----------------|----------------|--------|
| 14277  | 50 ml Cartridge | 12             | 14280 (manual) | 14285  |

| Physical Properties  | 5 Minute® Epoxy    | 5 Minute® Epoxy Gel | One Minute™ Epoxy Gel | 10 Minute™ Epoxy |           | 2 Ton® Epoxy | Epoxy Plus™ 25 | HP 250    | Food Grade Pot & Seal |
|--|--------------------|---------------------|-----------------------|------------------|-----------|--------------|----------------|-----------|-----------------------|
| Color  | Clear              | Opaque              | Clear                 | Black            | Clear     | Clear        | Grey           | Straw     | White                 |
| Mix ratio (resin:hardener)                                 | 1:1                | 1:1                 | 1:1                   | 1:1              | 1:1       | 1:1          | 1:1            | 2:1       | 4:1                   |
| Mixed viscosity (cP)                                       | 10,000             | Gel                 | 70,000                | 90,000           | 80,000    | 8,000        | 70,000         | 105,000   | 100,000               |
| Working time <sup>1</sup> (minutes)                        | 3 ~ 6              | 4 ~ 7               | 45 sec                | 10               | 10        | 8 ~ 12       | 25             | 65        | 42 @ 75°F             |
| Fixture time <sup>2</sup> (minutes)                        | 10 ~ 15            | 10 ~ 15             | 1                     | 20               | 20        | 30 ~ 35      | 210            | 300       | 10 @ 200°F            |
| Functional cure (minutes)                                  | 90                 | 45 ~ 60             | 30 ~ 45               | 90               | 90        | 120          | 1,440          | 1,440     | 1,500 @ 200°F         |
| Adhesive tensile lap shear (ASTM D1002) <sup>3</sup> (psi) | 1,900 <sup>4</sup> | 2,500               | 1,600 <sup>4</sup>    | 2,400            | 2,400     | 2,250        | 2,750          | 3,200     | 1,980                 |
| Tensile elongation (%)                                     | 5                  | 1                   | 1                     | 5                | 5         | 1            | 20             | 25        | 1                     |
| Peel strength (pli)  | 2 ~ 3              | 2 ~ 3               | 2 ~ 3                 | 20 ~ 25          | 20 ~ 25   | 2 ~ 3        | 20 ~ 25        | 35 ~ 40   | 2 ~ 3                 |
| Impact resistance (ft-lb/in <sup>2</sup> )                 | 5.5                | 6.5                 | 4.5                   | 10               | 10        | 6.5          | 10             | 12        | 5.2                   |
| Maximum dry service temperature (°F)                       | -40 ~ 200          | -40 ~ 200           | -40 ~ 200             | -67 ~ 200        | -67 ~ 200 | -40 ~ 200    | -40 ~ 200      | -67 ~ 250 | -40 - 275             |

NOTES: <sup>1</sup>The maximum allowable time to mate and position parts after mixing and application of the adhesive. After this interval, parts must not be disturbed. <sup>2</sup>The time required for the adhesive to generate sufficient bond strength to allow parts to be handled without deformation of the bond line. <sup>3</sup>All tensile strength data per ASTM D1002 on grit-blasted steel, bond line thickness of 0.010". <sup>4</sup>Bond line thickness of 0.005".

| Chemical Resistance    | 5 Minute® Epoxy | 5 Minute® Epoxy Gel | One Minute™ Epoxy Gel | 10 Minute™ Epoxy | 2 Ton® Epoxy | Epoxy Plus™ 25 | HP 250 | Food Grade Pot & Seal |
|------------------------|-----------------|---------------------|-----------------------|------------------|--------------|----------------|--------|-----------------------|
| <b>ACIDS</b>           | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ⊗                     |
| Acetic 10%             | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ⊗                     |
| Hydrochloric 10%       | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ⊗                     |
| Sulfuric 10%           | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ⊗                     |
| <b>ALCOHOLS</b>        | ○               | ○                   | ○                     | ⊗                | ●            | ●              | ●      | ●                     |
| Glycol                 | ○               | ○                   | ○                     | ⊗                | ●            | ●              | ●      | ●                     |
| Isopropanol            | ○               | ○                   | ○                     | ⊗                | ●            | ●              | ●      | ●                     |
| Methanol               | ○               | ○                   | ○                     | ⊗                | ●            | ●              | ●      | ●                     |
| <b>KETONES</b>         | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ○                     |
| Acetone                | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ○                     |
| Methyl ethyl ketone    | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ○                     |
| <b>ALKALIS</b>         | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ●                     |
| Ammonium hydroxide 20% | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ●                     |
| Sodium hydroxide 10%   | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ●                     |
| <b>HYDROCARBONS</b>    | ●               | ●                   | ●                     | ○                | ●            | ○              | ○      | ●                     |
| Gasoline (unleaded)    | ●               | ●                   | ●                     | ○                | ●            | ○              | ○      | ●                     |
| Mineral spirits        | ●               | ●                   | ●                     | ○                | ●            | ○              | ○      | ●                     |
| Motor oil              | ●               | ●                   | ●                     | ○                | ●            | ○              | ○      | ●                     |
| <b>SALTS</b>           | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ●                     |
| Sodium chloride        | ⊗               | ⊗                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ●                     |
| Trisodium phosphate    | ⊗               | ○                   | ⊗                     | ⊗                | ⊗            | ⊗              | ⊗      | ●                     |

Key: ● Excellent ○ Very Good ○ Fair ⊗ Poor

## Devcon® 10 Minute™ Epoxy

Flexible epoxy provides excellent adhesion to metals and superior peel, impact and chemical resistance.

| Item # | Size                    | Items Per Case | Dispenser      | Nozzle |
|--------|-------------------------|----------------|----------------|--------|
| 14251  | 50 ml Cartridge (Clear) | 12             | 14280 (manual) | 14285  |
| 14255  | 50 ml Cartridge (Black) | 12             | 14280 (manual) | 14285  |

## Devcon® 2 Ton® Epoxy

Extremely strong, medium-cure, water-resistant adhesive.

| Item # | Size             | Items Per Case | Dispenser      | Nozzle |
|--------|------------------|----------------|----------------|--------|
| 14310  | 25 ml Dev-Tube™  | 24             | —              | —      |
| 14260  | 50 ml Cartridge  | 12             | 14280 (manual) | 14285  |
| 14355  | 400 ml Cartridge | 12             | 14410 (manual) | 3333   |
| 14360  | 9 lb             | 1              | —              | —      |

## Devcon® Epoxy Plus™ 25

Rubber-toughened structural adhesive with superior peel, impact and fatigue resistance.

| Item # | Size             | Items Per Case | Dispenser      | Nozzle |
|--------|------------------|----------------|----------------|--------|
| 14278  | 50 ml Cartridge  | 12             | 14280 (manual) | 14285  |
| 14350  | 400 ml Cartridge | 12             | 14410 (manual) | 30095  |

## Devcon® HP 250

High-performance, toughened structural adhesive with outstanding environmental, impact and chemical resistance.

| Item # | Size             | Items Per Case | Dispenser      | Nozzle |
|--------|------------------|----------------|----------------|--------|
| 14315  | 50 ml Cartridge  | 12             | 14280 (manual) | 14285  |
| 14415  | 400 ml Cartridge | 1              | 14410 (manual) | 30095  |

## Devcon® Food Grade Pot & Seal

An epoxy potting compound acceptable for meat and poultry plants. It is ideal for bonding filter screens to frames.

| Item # | Size             | Items Per Case | Dispenser | Nozzle |
|--------|------------------|----------------|-----------|--------|
| DA999  | 400 ml Cartridge | 6              | 15043     | 15047  |

## Permatex® ZipGrip® General Purpose Instant Adhesives

General purpose formulations for bonding metals, plastics and rubber in all combinations. Gels are ideal for vertical or inverted surfaces.

| Item# | Size          | Items Per Case |
|-------|---------------|----------------|
| 70144 | 14 g Bottle   | 12             |
| 70145 | 2 g Tube      | 12             |
| 70213 | 1/3 oz Bottle | 12             |
| 70350 | 1 oz Bottle   | 10             |
| 70450 | 1 oz Bottle   | 10             |

## Permatex® ZipGrip® Toughened Purpose Instant Adhesives

Toughened ethyl versions are modified with elastomeric compounds to improve impact, peel and general toughness of cyanoacrylates.

| Item# | Size        | Items Per Case |
|-------|-------------|----------------|
| 72161 | 1 lb Bottle | 1              |
| 72250 | 1 oz Bottle | 10             |
| 72261 | 1 lb Bottle | 1              |

## Devcon® Silite® Silicone RTV

Single-component sealant for gasketing, sealing, bonding, and weatherproofing applications. Cures at room temperature to a clear, flexible silicone rubber. Can be used to seal window plates, ceramic tile, and bond gaskets. Excellent resistance to a wide range of weather and temperatures ranging from -60° to 450°F (-50° to 232°C). Acceptable for use in meat and poultry plants. Listed under NSN Stock #8040-01-193-3312, qualifies under MIL-A-46106A, Galv. Repair.



| Item # | Size              | Items Per Case | Color |
|--------|-------------------|----------------|-------|
| 17100  | 3 oz Tube, Boxed  | 24             | Clear |
| 17150  | 10.3 oz Cartridge | 12             | Clear |
| 17140  | 10.3 oz Cartridge | 12             | White |
| 17130  | 10.3 oz Cartridge | 12             | Red   |

| Product              | Item Number    | Container Size             | Viscosity | Mixed Color | Type         | Gap Filling | Adhesive Tensile Shear | Service Temperature | Cure Speed Steel-Plastic-Rubber |
|----------------------|----------------|----------------------------|-----------|-------------|--------------|-------------|------------------------|---------------------|---------------------------------|
| GPE 3 <sup>1</sup>   | 70144<br>70145 | 14 g bottle<br>2 g tube    | 3 cP      | Clear       | Ethyl        | 0.003"      | 3,200 psi              | -65 to 200°F        | 5-10 / 3-5 / <2 sec             |
| GPE 15 <sup>1</sup>  | 70213          | 1/3 oz bottle              | 15 cP     | Clear       | Ethyl        | 0.005"      | 3,200 psi              | -65 to 200°F        | 5-10 / 4-10 / <3 sec            |
| GPE 30 <sup>1</sup>  | 70350          | 1 oz bottle                | 30 cP     | Clear       | Neomer Ethyl | 0.004"      | 3,200 psi              | -65 to 200°F        | 5-12 / 5-13 / <6 sec            |
| GPE 100 <sup>2</sup> | 70450          | 1 oz bottle                | 100 cP    | Clear       | Ethyl        | 0.004"      | 3,200 psi              | -65 to 200°F        | 10-20 / 10-20 / <5 sec          |
| TE 1000 <sup>3</sup> | 72161          | 1 lb bottle                | 1,000 cP  | Clear       | Ethyl        | 0.008"      | 3,700 psi              | -65 to 280°F        | 25-40 / 25-50 / 20-50 sec       |
| TE 2400 <sup>3</sup> | 72250<br>72261 | 1 oz bottle<br>1 lb bottle | 2,400 cP  | Clear       | Ethyl        | 0.009"      | 3,700 psi              | -65 to 280°F        | 40-70 / 25-50 / 25-50 sec       |

NOTES: <sup>1</sup> Commercial Item Standard A-A-3097, Type II, Class 1    <sup>2</sup> Commercial Item Standard A-A-3097, Type II, Class 2    <sup>3</sup> Commercial Item Standard A-A-3097, Type II, Class 3

## URETHANE ADHESIVES

Devcon® urethane formulations are primerless adhesives that bond metals, plastic, galvanized metal and other hard-to-bond substrates. They offer rapid curing and exceptional flexibility.



### Devcon® Dev-Thane™ 5

Primerless, fast-setting, two-part urethane adhesive for high-performance bonding of a variety of substrates such as aluminum, steel, ABS, urethane and composites.

| Item # | Size             | Items Per Case | Dispenser      | Nozzle |
|--------|------------------|----------------|----------------|--------|
| 14503  | 50 ml Cartridge  | 12             | 14280 (manual) | 14285  |
| 14500  | 400 ml Cartridge | 10             | 14410 (manual) | 3333   |

| Physical Properties                           | Dev-Thane™ 5 |
|---|--------------|
| Color   | Grey         |
| Mix ratio (resin: hardener)                   | 1:1          |
| Mixed viscosity (cP)                          | 45,000       |
| Fixture time (minutes)                        | 45           |
| Working time (minutes)                        | 5            |
| Peel strength (pli)                           | 60 ~ 75      |
| Functional cure <sup>1</sup> (hours)          | 4            |
| Tensile Elongation (%)                        | 200          |
| Cured hardness (ASTM D2240) (Shore D)         | 63           |
| Adhesion Tensile Lap Shear (ASTM D1002) (psi) | 2,750        |

NOTES: <sup>1</sup> Faster cure times can be achieved by heating.

| Chemical Resistance    | Dev-Thane™ 5 |
|------------------------|--------------|
| <b>ACIDS</b>           |              |
| Acetic 10%             | ○            |
| Hydrochloric 10%       | ●            |
| Sulfuric 10%           | ●            |
| <b>ALCOHOLS</b>        |              |
| Glycol                 | ○            |
| Isopropanol            | ●            |
| Methanol               | ○            |
| <b>KETONES</b>         |              |
| Acetone                | ○            |
| Methyl ethyl ketone    | ○            |
| <b>ALKALIS</b>         |              |
| Ammonium hydroxide 20% | ○            |
| Sodium hydroxide 10%   | ●            |
| <b>HYDROCARBONS</b>    |              |
| Gasoline (unleaded)    | ●            |
| Mineral spirits        | ●            |
| Motor oil              | ●            |
| <b>SALTS</b>           |              |
| Sodium chloride        | ○            |
| Trisodium phosphate    | ○            |

Key: ● Excellent    ● Very Good    ○ Fair    ○ Poor

## Sprayable Syntactic Materials

- Excellent strength-to-weight ratio
- **Labor Savings** – SprayCore® is applied to a controlled thickness by a single person
- **Increase Productivity** – Fast cure cycle with low exotherm
- Excellent core material that can be applied up to a thickness of ¾ inches
- **Superior Bonding Strength** – Excellent bedding material for products such as plywood, balsa, and other coring materials
- Will not rot like wood cores
- **Stop bulk laminate print through**
- Parts have a high impact resistance and high core shear since there is a total chemical bond from the skin coat through to the bulk laminate
- Superior cosmetics and better gloss
- Build stronger and lighter parts faster



## BARRIER COAT

### SC 1500-LS

A sprayable premium vinylester barrier coat applied directly behind the gel coat. MEKP catalyst is not included.

| Item # | Description          | Items Per Case |
|--------|----------------------|----------------|
| 103993 | 1500-LS Drum Unlined | 1              |

### SC 1800-LS AND 1800-LS BLACK

A sprayable premium vinylester barrier coat applied directly behind the gel coat. MEKP catalyst is not included.

| Item # | Description                     | Items Per Case |
|--------|---------------------------------|----------------|
| 103995 | 1800-LS Light Gray Drum Unlined | 1              |
| 103975 | 1800-LS Black Drum Unlined      | 1              |

## CORING/BULK PRINT BLOCKER

### SC 2000-0S and 2000-0S LS

A sprayable resin based matrix filled with multi-sized, hollow microspheres that is VOC compliant. It can be used as a bulk print blocker and a coring material. It makes parts stronger, lighter, improves impact resistance, cosmetics while increasing productivity and profitability; MEKP catalyst is not included.

| Item # | Description             | Items Per Case |
|--------|-------------------------|----------------|
| 103927 | 2000-0S Drum Lined      | 1              |
| 103827 | 2000-0S Drum Unlined    | 1              |
| 103994 | 2000-0S LS Drum Unlined | 1              |

### SC 2045

A uniquely blended compounded resin that can be used as a coring material or a bulk print blocker to enhance the cosmetic appearance, rigidity and speed of production of fiberglass reinforced plastic products. When used as a fiberglass print barrier, SC 2045 is applied behind the "skin coat" laminate. It greatly reduces the transfer of the fiberglass pattern of the laminates behind the coring material onto the gel coat surface. MEKP catalyst is not included.

| Item # | Description               | Items Per Case |
|--------|---------------------------|----------------|
| 103202 | SHLD-2045 LS Drum Lined   | 1              |
| 103211 | SHLD-2045 LS Drum Unlined | 1              |
| 103412 | MR-100 Blowing Agnt       | 1              |

### SC 4000 HDT

A multi-functional, high heat distortion, sprayable material for mold building that is VOC compliant. MEKP catalyst is not included.

| Item # | Description           | Items Per Case |
|--------|-----------------------|----------------|
| 103979 | 4000 HDT Drum Unlined | 1              |

### SC 6000

A unique resin matrix that can be used in a variety of ways to enhance the cosmetic appearance, rigidity and speed of production of fiberglass reinforced plastic products. MEKP catalyst is not included.

| Item # | Description          | Items Per Case |
|--------|----------------------|----------------|
| 103201 | CORE-6000 Drum Lined | 1              |

### SC 7315

A unique micro balloon filled resin matrix that can be used in a variety of ways to enhance the cosmetic appearance, rigidity and speed of production of fiberglass reinforced plastic products. It is an attractive alternative to other core materials such as plywood, PVC foams, end-grained balsa and polyester mats. SC 7315 is sprayed into place at the desired thickness and is typically lower in cost than other core materials. MEKP catalyst is not included.

| Item # | Description            | Items Per Case |
|--------|------------------------|----------------|
| 103216 | CORE-7315 Drum Unlined | 1              |
| 103412 | MR-100 Blowing Agnt    | 1              |

## RADIUS COMPOUND

### SC 900

A ceramic compound resin used to prevent air voids between the gel coat and the fiberglass laminate, most commonly used in tight radii. Works well in open and closed mold processes. MEKP catalyst is not included.

| Item # | Description      | Items Per Case |
|--------|------------------|----------------|
| 103350 | 900 Drum Unlined | 1              |

### SC 1050

A ceramic compound resin used to prevent air voids between the gel coat and the fiberglass laminate, most commonly used in tight radii. MEKP catalyst is not included.

| Item # | Description                  | Items Per Case |
|--------|------------------------------|----------------|
| 103212 | 1050-LS Neutral Drum Unlined | 1              |

### SC 1060

A ceramic compound resin used to prevent air voids between the gel coat and the fiberglass laminate, most commonly used in tight radii. MEKP catalyst is not included.

| Item # | Description     | Items Per Case |
|--------|-----------------|----------------|
| 103305 | 1060 5 gal Pail | 1              |

## ADHESIVE PUTTIES

### SC PDR 6000

Strong, ultra-light (6 lbs/gal) polyester adhesive putty that is primarily used to bond fiberglass parts. MEKP catalyst is not included.

| Item # | Description              | Items Per Case |
|--------|--------------------------|----------------|
| 103108 | PDR 6000 Slow Drum Lined | 1              |

### SC PDR 9000

A strong, lightweight (9 lbs/gal) polyester adhesive filler that is used to bond fiberglass parts. MEKP catalyst is not included.

| Item # | Description                    | Items Per Case |
|--------|--------------------------------|----------------|
| 103100 | PDR 9000 Ultra Fast Drum Lined | 1              |
| 103104 | PDR 9000 Slow Drum Lined       | 1              |
| 103109 | PDR 9000 Fast Drum Lined       | 1              |
| 103121 | PDR 9000 Slow 5 gal Pail       | 1              |
| 103130 | PDR 9000 Slow Drum Unlined     | 1              |

### SC ALPHAFILL LIGHTWEIGHT

A high quality, tack-free, lightweight putty with excellent adhesion to metal, galvanized metal, aluminum, fiberglass and wood. BPO catalyst is not included.

| Item # | Description          | Items Per Case |
|--------|----------------------|----------------|
| 100009 | AlphaFill 5 gal Pail | 1              |

## PLUG BUILDING

### SC 2000-HS

A CNC machined, sprayable polyester resin matrix used for plug building. Catalyst is not included.

| Item # | Description          | Items Per Case |
|--------|----------------------|----------------|
| 103837 | 2000-HS Drum Unlined | 1              |

### SC 4500

A CNC machined vinylester blend matrix used for plug building. Catalyst is not included.

| Item # | Description       | Items Per Case |
|--------|-------------------|----------------|
| 103840 | 4500 Drum Unlined | 1              |

## MOLD BUILDING

### SC VELR 4000

A DCPD/vinylester laminating resin. This product is a low shrink resin that rapidly wets out the fiberglass reinforcement and cures uniformly with a low exotherm. MEKP catalyst is not included.

| Item # | Description                     | Items Per Case |
|--------|---------------------------------|----------------|
| 103409 | VELR-4000 VE Resin Drum Unlined | 1              |

### SC 4055

A ceramic compounded vinylester/polyester resin blend that was formulated for the production of fiberglass molds. This product will enhance the cosmetic appearance, rigidity and speed of production of fiberglass reinforced molds. MEKP is not included.

| Item # | Description                         | Items Per Case |
|--------|-------------------------------------|----------------|
| 103404 | VE-TOL-4055 Drum Molding Shld Lined | 1              |

### SC 4600 HTT

A promoted, vinylester blended premium mold building resin developed for the fabrication of FRP tooling in multiple pull and high temperature applications.

| Item # | Description           | Items Per Case |
|--------|-----------------------|----------------|
| 103846 | 4600 HTT Drum Unlined | 1              |

### SC 4700

A high performance, shrink controlled, filled Tooling Resin; it is formulated to reproduce exact shapes of master and a unique low HAP chemistry. SC 4700 is MACT compliant and meets all current federal regulations regarding emissions.



| Item # | Description       | Items Per Case |
|--------|-------------------|----------------|
| 103855 | 4700 5 gal Pail   | 1              |
| 103850 | 4700 Drum Unlined | 1              |

## SPRAYABLE FILLER

### SC ALPHACOAT® 1700 AND ALPHACOAT® 1710

A sprayable two-part polyester based filler/ glazing compound that is VOC compliant. Excellent for application over iron, metal, aluminum, fiberglass, wood, and polyester fillers. MEKP catalyst is not included.

| Item # | Description                  | Items Per Case |
|--------|------------------------------|----------------|
| 100065 | AlphaCoat® 1700 Drum Unlined | 1              |
| 100066 | AlphaCoat® 1710 Drum Unlined | 1              |

## SPECIALTY PRODUCTS

### SC 2000-CM

A sprayable polyester matrix filled with multi-sized, hollow microspheres developed specifically for compression molding. It also can be injected into an empty closed mold cavity to make preform cores. MEKP catalyst is not included.

| Item # | Description          | Items Per Case |
|--------|----------------------|----------------|
| 103981 | 2000 CM Drum Unlined | 1              |

### SC 5000

A pourable or injectable syntactic transom coring material. MEKP catalyst is not included.

| Item # | Description       | Items Per Case |
|--------|-------------------|----------------|
| 103865 | 5000 5 Gal Pail   | 1              |
| 103866 | 5000 Drum Unlined | 1              |



| Product                          | Description  | Mix Ratio (%)                          | Preferred Red-Dye Catalyst        | Styrene (%) | Approx. Gel Time (min)                             | Approx. Gel to Peak Range (min) | Density Range (lbs/gal)  | Viscosity (cps)  | Peak Exotherm (°F)               |
|----------------------------------|--|--|-----------------------------------|-------------|--|---------------------------------|--------------------------|--|----------------------------------|
| <b>BARRIER COAT</b>              |  |  |                                   |             |  |                                 |                          |  |                                  |
| 1500-LS                          | Fast cure time   | 1.50 MEKP                              | HP-90, DHD-9 MEKP-925             | 22          | 1-3  | 3-5                             | 6.20-6.80                | 4,000-7,000 (HB #4 @ 20rpm)  | 360-400°                         |
| 1800-LS<br>1800-LS Black         | Medium cure time   | 1.50 MEKP                              | HP-90, DHD-9 MEKP-925             | 22          | 3-5  | 3-7                             | 6.20-6.80                | 4,000-7,000 (HB #4 @ 20rpm)  | 360-400°                         |
| <b>CORING/BULK PRINT BLOCKER</b> |  |  |                                   |             |  |                                 |                          |  |                                  |
| 2045*                            | Ceramic compounded resin with a very fast gel and cure cycles; Adjustable high and low densities                                   | 1.50 MEKP<br>2.00 MEKP/<br>1.50 MR-100 | HP-90                             | 30          | 4-8<br>0.5-1.5                                     | 5-8<br>4-8                      | 10.00-10.50 (~8.70-9.14) | 3,000-5,000 (RVF #4 @ 20rpm)   | 250-325°<br>325-375°             |
| 2000-OS**                        | Effectively blocks bulk print through in minimum thickness of .090" and can be used to imbed plywood or other sheet core materials | 1.75-2.25 MEKP                         | HP-90<br>DHD-9<br>MEKP-900        | 35          | 2.5-3.5  | 7-9                             | 5.60-6.00                | 13,000-15,000 (HB #4 @ 20rpm)  | 285-345°                         |
| 2000-OS LS**                     | Effectively blocks bulk print through in minimum thickness of .090" and can be used to imbed plywood or other sheet core materials | 1.75-2.25 MEKP                         | HP-90<br>DHD-9<br>MEKP-900        | 27          | 2.5-3.5  | 6-9                             | 5.60-6.00                | 13,000-15,000 (HB #4 @ 20rpm)  | 285-345°                         |
| 6000                             | Economical solution for a variety of applications  | 1.50 MEKP                              | HP-90, DHD-9 MEKP-900             | 31          | 5-10   | 15-20                           | 5.80-6.30                | 13,000-15,000 (RVF #5 @ 20rpm)   | 200-250°                         |
| 7315*                            | Unique micro balloon ceramic resin with adjustable low and high densities  | 1.50 MEKP<br>2.00 MEKP/<br>1.50 MR-100 | HP-90                             | 32          | 4-8<br>0.5-1.5                                     | 6-10<br>4-8                     | 5.80-6.30 (~4.29-4.67)   | 10,000-14,000 (RVF #5 @ 20rpm)   | 300-350°                         |
| <b>RADIUS COMPOUND</b>           |  |  |                                   |             |  |                                 |                          |  |                                  |
| 900                              | Longer gel time allows good working time with rollers  | 1.50 MEKP                              | HP-90<br>DHD-9<br>MEKP-900        | 25          | 21-26  | 21-26                           | 10.80-11.30              | 20,000-25,000 (RVF #6 @ 20rpm)   | 250-300°                         |
| 1050                             | Can be sprayed and chopped while wet   | 1.50 MEKP                              | HP-90<br>DHD-9<br>MEKP-900        | 27          | 25-35  | 10-17                           | 10.80-11.30              | 15,000-20,000 (RVF #6 @ 20rpm)   | 250-300°                         |
| 1060                             | Can be brushed and chopped while wet   | 1.50 MEKP                              | HP-90<br>DHD-9<br>MEKP-900        | 30          | 20-30  | 10-17                           | 10.80-11.30              | 25,000-35,000 (RVF #6 @ 20rpm)   | 250-300°                         |
| <b>ADHESIVE PUTTIES</b>          |  |  |                                   |             |  |                                 |                          |  |                                  |
| PDR 6000                         | Formulated for slow gel time   | 1.50 MEKP                              | DDM-9<br>MEKP-9<br>DDM-30         | 25          | 75-105   | 15-30                           | 6.10-6.60                | 600,000-700,000 (RVF T-E @ 5rpm)   | 200-250°                         |
| PDR 9000                         | Formulated for 3 different gel times   | 1.50 MEKP                              | DDM-9<br>MEKP-9<br>DDM-30         | 20          | 10-20 (Ultrafast)<br>40-50 (Fast)<br>80-105 (Slow) | 5-15<br>10-25<br>25-50          | 8.70-9.50                | Ultrafast:<br>650,000-750,000 (RVF T-E @ 5rpm)<br>Fast and Slow:<br>750,000-850,000 (RVF T-E @ 5rpm) | 180-250°<br>180-225°<br>150-225° |
| AlphaFill<br>Lightweight         | Excellent adhesion and featheredge   | 2.00 BPO                               | BPO                               | 15-20       | 3-5  | N/A                             | 9.70                     | 102,000-120,000 (SSA W/T-E Bar @ 5rpm)   | N/A                              |
| <b>PLUG BUILDING</b>             |  |  |                                   |             |  |                                 |                          |  |                                  |
| 2000-HS                          | Developed for easy routing with CNC equipment  | 1.75-2.25 MEKP                         | HP-90<br>DHD-9<br>MEKP-900        | 33          | 2.5-3.5  | 7-9                             | 4.80-5.20                | 16,000-18,000 (HB #4 @ 20rpm)  | 290-325°                         |
| 4500                             | High HDT   | 1.75-2.25 MEKP                         | HP-90                             | 26          | 8-13   | 14-20                           | 5.30-6.00                | 9,000-15,000 (HB #4 @ 20rpm)   | 280-320°                         |
| <b>MOLD BUILDING</b>             |  |  |                                   |             |  |                                 |                          |  |                                  |
| 4000 HDT                         | Coring material w/ high heat tolerance when used with MR-100 Blowing Agent****   | 1.50-2.20 MEKP                         | HP-9<br>DHD-9<br>MEKP 925         | 29          | 3-4  | 5-8                             | 5.25-5.75                | 12,000-14,000 (HB #4 @ 20rpm)  | 300-350°                         |
| 4055***                          | Can be applied at 20-30 mils directly onto the gelcoat   | 1.50 MEKP<br>2.00 MEKP/<br>1.50 MR-100 | HP-9<br>DHD-9<br>MEKP 925         | 26          | 8-13   | 7-13                            | 9.70-10.70               | 8,000-11,000 (RVF #5 @ 20rpm)  | 270-305°<br>325-375°             |
| VELR 4000                        | Rapidly wets out and cures uniformly with a low exotherm   | 1.50 MEKP                              | HP-9<br>DHD-9<br>MEKP-925         | 32          | 15-25  | 4-10                            | 8.80-9.20                | 450-650 (RVF #2 @ 20rpm)   | 325-375°                         |
| 4600 HTT                         | Vinylester blended premium mold building resin   | 1.50 MEKP                              | MEKP-925<br>HP-90<br>DHD-9        | 20-24       | 12-20  | 20-30                           | 10.40-11.10              | 7,000-11,000 (RVF #5 @ 2.5/20rpm)  | 210-255°                         |
| 4700                             | High performance shrink controlled filled Tooling Resin  | 1.50 MEKP                              | MEKP-900<br>MEKP-925<br>MEKP-925H | 23          | 13-30  | 5-12                            | 12.3-12.8                | 3,000-4,500 (LVT #3 @ 30rpm)   | 280-330°                         |
| <b>SPRAYABLE FILLER</b>          |  |  |                                   |             |  |                                 |                          |  |                                  |
| AlphaCoat<br>1700                | Extremely fast cure time   | 2.00 MEKP                              | MEKP-9H<br>DDM-9                  | 20          | 3-6  | 60-90 (Dry to sand)             | 9.20-9.70                | 1,200-1,400 (LVT #3 @ 30rpm)   | N/A                              |
| AlphaCoat<br>1710                | Extremely fast cure time   | 2.00 MEKP                              | MEKP-9H<br>DDM-9                  | 20          | 3-6  | 60-90 (Dry to sand)             | 11.75-12.25              | 1,600-1,850 (LVT #3 @ 30rpm)   | N/A                              |
| <b>SPECIALTY PRODUCTS</b>        |  |  |                                   |             |  |                                 |                          |  |                                  |
| 2000-CM                          | Developed specifically for compression molding. Makes a product stiffer without adding more fiberglass laminates                   | 1.75-2.25 MEKP                         | DHD-9, DDM-9<br>MEKP-900<br>HP-90 | 28          | 20-30  | 20-30                           | 4.80-5.20                | 18,000-22,000 (HB #4 @ 20rpm)  | >220°                            |
| 5000                             | Pourable or injectable syntactic transom coring material   | 1.00 MEKP                              | MEKP-9H<br>DDM-9                  | 17          | 20-30  | 20-30                           | 8.25-8.75                | 25,000-35,000 (HB #4 @ 20rpm)  | 125-160°                         |

\*Can be used with or without the MR-100 Blowing Agent for density weight reduction. \*\*Does not use MR 100 Blowing Agent however, can be used to bed other materials.  
 \*\*\*Can be used with MR-100 Blowing Agent for added stiffness. \*\*\*\*Addition of MR-100 Blowing Agent is optional.



## DISPENSING EQUIPMENT

### GUNS

| Item # | Description   |
|--------|---|
| 14280  | Mark V™ Gun Manual Dispensing Gun<br>50/35 ml 1:1, 2:1, and 10:1 Ratio Applicator |
| 30016  | Manual Cartridge Dispensing Gun<br>490 ml 10:1 Ratio Applicator                   |
| 30020  | Manual Cartridge Dispensing Gun<br>400 ml 1:1 and 2:1 Ratio Applicator            |
| 15043  | Manual Cartridge Dispensing Gun<br>400 ml 4:1 Ratio Applicator                    |
| 30010  | Pneumatic Cartridge Dispensing Gun<br>400 ml 1:1 and 2:1 Ratio Applicator         |
| 30013  | Pneumatic Cartridge Dispensing Gun<br>490 ml 10:1 Ratio Applicator                |



15043  
30016  
30020



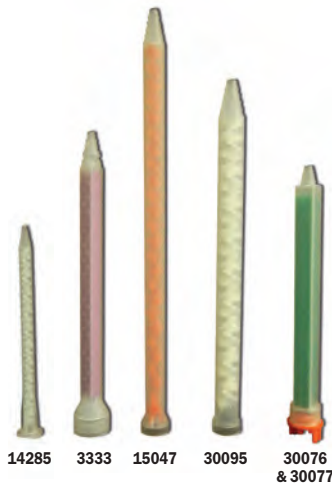
14280



30010  
30011  
30013

### NOZZLES

| Item # | Description   |
|--------|---|
| 14285  | Mark V™ Mix Nozzle<br>50/35 ml 1:1, 2:1, and 10:1 Mix Nozzle    |
| 3333   | Static Mix Nozzle<br>1:1, 2:1 and 10:1 Mix Nozzle               |
| 15047  | Static Mix Nozzle<br>4:1 Mix Nozzle                             |
| 30095  | Static Mix Nozzle (500 series)<br>400 ml 1:1 and 2:1 Mix Nozzle |
| 30076  | Static Mix Nozzle<br>490 ml 10:1 Mix Nozzle                     |
| 30077  | Mix Nozzle<br>490 ml 10:1 Bulk Mix Nozzle (600)                 |



14285 3333 15047 30095 30076 & 30077



### Approved Equipment Manufacturers

For more information, please contact:

#### GS Manufacturing

985 W. 18th Street  
Costa Mesa, CA 92627  
Phone: (949) 642-1500  
E-mail: gsmfg@pacbell.net  
www.gsmfg.com

#### MVP Corporate Headquarters

10535 Hardin Valley Road  
Knoxville, TN 37932  
Phone: (865) 686-5670  
E-mail: info@mvpind.com  
www.mvpind.com

The key to a successful repair is proper preparation and thorough cleaning prior to applying repair products or protective coatings.

## General Surface Preparation

In general, the following steps will help you properly prepare a surface prior to applying Devcon® products:

- 1) Make sure the surface is completely dry. Moisture will adversely affect the strength of the bond to the surface.
- 2) Remove all surface contamination (paint, rust and grime) by abrasive blasting, sanding or other mechanical means.
- 3) Degrease with Devcon® Cleaner Blend 300.
- 4) Abrade the surface to roughen it and create a surface profile.
- 5) Use the appropriate Devcon® primer.

For detailed surface preparation procedures, refer to the appropriate substrate category and tech data sheet.

## Aluminum Surfaces

Oxidation on aluminum surfaces reduces epoxy adhesion. This oxidation film must be removed before repairing aluminum with Devcon® Metal Repair Epoxies.

To properly prepare an aluminum surface:

- 1) Remove oxidation by mechanical means such as grit-blasting or by chemical means such as acid etching.
- 2) Follow the General Surface Preparation guidelines.

## Metal

To properly prepare a metal surface:

- 1) If the surface is oily or greasy, degrease it with Devcon® Cleaner Blend 300.
- 2) Abrasive-blast the surface with 25-40 grit (or coarser) to produce a good surface profile. If you cannot abrasive-blast the surface, use a 60 grit or coarser sandpaper to achieve a similar result.
- 3) Immediately coat the metal surface with Flexane® FL-10 Primer to prevent it from rusting.
- 4) Make repairs as soon as possible after blasting the substrate to avoid oxidation or flash rusting.

## Rubber

To properly prepare a rubber surface:

- 1) Abrade the surface using a rubber rasp or a grinder with a wire wheel to produce a good surface profile. (Oils and contaminants imbedded in the rubber surface are typically released in this process.)
- 2) Remove all oil and grease from the rubber surface with Devcon® Cleaner Blend 300 and an abrasive pad.
- 3) Wipe the surface with a clean, lint-free cloth continuously until black residue is no longer picked up by the white cloth.
- 4) Prime the surface as follows:

Rubber to metal: Coat all metal surfaces (including stainless steel and aluminum) with two coats of Flexane® FL-10 Primer. The primer will significantly improve adhesion of Devcon products to metal.

## Rubber

### Rubber to metal (for immersion service):

Coat any metal that will be immersed in an aqueous solution with Flexane® FL-10 Primer and Flexane® FL-20 Primer. First apply the FL-10 Primer and let dry for 60 minutes. Next, coat with the FL-20 Primer. Let dry for 30 minutes before applying the Devcon® product.

**Rubber to rubber:** Coat all gum rubbers, neoprene or cured urethanes with a thin coat of Flexane® FL-20 Primer. For ultimate peel strength, use Surface Conditioner (on rubber only).

**Rubber to concrete:** Coat concrete with Flexane® FL-20 Primer. Multiple coats may be necessary because concrete is very porous. Let the primer dry for 30 minutes between coats.

**Rubber to wood or fiberglass:** Coat these surfaces with Flexane® FL-20 Primer. Soft woods will require a second coat due to their absorption characteristics.

When bonding rubber to other surfaces, contact Technical Service for a recommendation on primers and surface preparation procedures.

## Concrete

To properly prepare a concrete surface:

- 1) Degrease the surface with Devcon® Cleaner Blend 300 or any water-based emulsifying cleaner and rinse thoroughly. Multiple cleanings may be necessary. Power washers or steam cleaners are very effective and can reduce the number of passes needed to clean the surface. Let the surface dry thoroughly before proceeding.
- 2) Remove any cap-curing agents that were applied to the concrete when it was poured. These agents form a dense, impenetrable finish, making it almost impossible for coatings to adhere to them.
- 3) Shot blast (Blastrac®) the concrete to create a porous surface profile. This will improve surface "wetting" and coating or repair product adhesion.

## Wet Surfaces

In general, Devcon® repair products and protective coatings will not adhere to wet surfaces.

To properly repair a wet surface:

- 1) Review the General Surface Preparation guidelines.
  - 2) Thoroughly dry the surface. (If you are using Devcon® Underwater Repair Putty (UW), refer to Underwater Surfaces section.)
  - 3) Stop all leaks or seepage as follows:
    - Shut off the flow or pressure;
    - Fit a wooden peg or a sheet metal screw into the hole; or
    - Stuff wax, cork, plumber's caulk, Mortite or a cloth into the opening.
- If the leak is caused by corrosion, the sidewall might be weak. Open the orifice until sound metal is exposed and the wall is thick enough to be plugged.
- 4) Remove surface condensation (sweating) or dampness with a heat gun or similar device.

## Underwater Surfaces

To properly prepare an underwater surface:

- 1) Remove all dirt, barnacles, flaking paint or algae/seaweed from the surface.
- 2) Wipe the surface with a clean cloth to remove any film. Although you cannot degrease underwater, wiping and turning a clean cloth will often remove any film from the surface.
- 3) Abrade the surface if possible. (Use a file or other mechanical means.)
- 4) Remove oxidation by mechanical means such as high-pressure water or grit-blasting, or by chemical means such as acid etching.

Blastrac® is a registered trademark of Blastrac, NA

## MRO Product Selector Guide

| MRO Applications                       | Plastic Steel® Putty (A) | Aluminum Putty (F) | Plastic Steel® (B)/ Aluminum Liquid (F-2) | Titanium Putty | Stainless Steel Putty (ST) | Ceramic Repair Putty/Compound | Brushable Ceramic | Wear Guard™ High-Temp/High Impact | DFense Blok™/DFense Blok™ Fast Cure (FC) | DFense Blok™ Quick Patch | Underwater Repair Putty (UW) |
|--|--------------------------|--------------------|---|----------------|----------------------------|-------------------------------|-------------------|-----------------------------------|--|--------------------------|------------------------------|
| Acid Resistant Coating                 |                          |                    |   | ▼              |                            | ▼                             | ▼                 |                                   |  |                          |                              |
| Casting Repair                         | ▼                        | ▼                  |   | ▼              | ▼                          |                               |                   |                                   |  |                          | ▼                            |
| Chemical Resistant Products / Coatings |                          |                    |   | ▼              |                            | ▼                             | ▼                 |                                   |  |                          |                              |
| Chocking, Leveling Compound            |                          |                    | ▼   |                |                            |                               |                   |                                   |  |                          |                              |
| Coating (Impact, Abrasion)             |                          |                    |   | ▼              |                            | ▼                             | ▼                 | ▼                                 | ▼  | ▼                        |                              |
| Collection Bins                        |                          |                    |   |                |                            |                               |                   |                                   | ▼  |                          |                              |
| Condenser Tube Sheet Coating           |                          |                    |   |                |                            | ▼                             | ▼                 |                                   | ▼  |                          |                              |
| Corrosion Resistant Coating            |                          |                    |   |                |                            | ▼                             | ▼                 | ▼                                 | ▼  |                          |                              |
| Cyclones                               |                          |                    |   |                |                            |                               |                   | ▼                                 | ▼  |                          |                              |
| Fans/Exhauster Fan Blades              |                          |                    |   |                |                            | ▼                             |                   | ▼                                 | ▼  |                          |                              |
| Flotation Cells                        |                          |                    |   |                |                            |                               | ▼                 |                                   | ▼  |                          |                              |
| Holding Fixtures (Making Molds)        |                          |                    | ▼   |                |                            |                               |                   |                                   |  |                          |                              |
| Hoppers (Rebuild & Coat)               |                          |                    |   |                |                            |                               | ▼                 | ▼                                 | ▼  |                          |                              |
| Leaks (Drums, Pipes, Tanks)            | ▼                        |                    |   | ▼              |                            |                               |                   |                                   |  | ▼                        | ▼                            |
| Lining Coal Chutes                     |                          |                    |   |                |                            |                               |                   | ▼                                 | ▼  | ▼                        |                              |
| Machinable Repair Material             | ▼                        | ▼                  | ▼   | ▼              | ▼                          |                               |                   |                                   |  |                          |                              |
| Meat and Poultry Plants                | ▼                        |                    |   | ▼              | ▼                          |                               | ▼                 |                                   |  |                          |                              |
| Pipe Elbow Coatings/Linings            |                          |                    |   |                |                            |                               |                   | ▼                                 | ▼  |                          |                              |
| Pulverizers/Mills                      |                          |                    |   |                |                            |                               |                   | ▼                                 | ▼  |                          |                              |
| Pump Repairs – Slurry                  |                          |                    |   | ▼              |                            | ▼                             |                   |                                   | ▼  |                          |                              |
| Pump Repairs – Water                   |                          |                    |   | ▼              |                            | ▼                             | ▼                 |                                   |  |                          | ▼                            |
| Rebuild Worn Threads/Keyways/Metal     | ▼                        |                    | ▼   | ▼              |                            |                               |                   |                                   |  |                          |                              |
| Repairing Engine Blocks                | ▼                        |                    |   | ▼              |                            |                               |                   |                                   |  |                          |                              |
| Screw Conveyors                        |                          |                    |   |                |                            |                               |                   |                                   | ▼  |                          |                              |
| Shaft Repairs                          |                          |                    |   | ▼              |                            |                               |                   |                                   |  |                          |                              |
| Tank Linings                           |                          |                    |   |                |                            | ▼                             | ▼                 |                                   |  |                          | ▼                            |
| Tank Repairs (Holes)                   | ▼                        |                    |   | ▼              |                            |                               |                   |                                   |  |                          | ▼                            |
| Valve Rebuild/Repairs                  | ▼                        | ▼                  |   | ▼              |                            | ▼                             | ▼                 |                                   |  |                          |                              |
| Wet/Damp Surface Bonding               |                          |                    |   |                |                            |                               |                   |                                   |  |                          | ▼                            |



Before



After

If you have questions,  
please contact  
Technical Service:  
855-489-7262

## Devcon® DFense Blok™ WEARING COMPOUNDS

Specially formulated wear-resistant epoxy coatings that protect dry materials handling and storage equipment from abrasion, corrosion and wear. The DFense Blok™ product line is truly an advanced epoxy technology with quicker functional cure times and better abrasion resistance.

### Devcon® DFense Blok™

A bead-filled epoxy compound formulated to significantly outlast traditional wear and abrasion products while providing superior protection.

- 4X better abrasion resistance than competition
- 7X better drop impact

| Item # | Items Per Case | Size  |
|--------|----------------|-------|
| 11330  | 1              | 30 lb |

### Devcon® DFense Blok™ Fast Cure (FC)

A bead-filled epoxy compound that allows equipment to be returned to service in 2 hours.

- Non-sagging, good adhesion
- Withstands operating temperature, as high as 300 °F

| Item # | Items Per Case | Size |
|--------|----------------|------|
| 11350  | 1              | 9 lb |

### Devcon® DFense Blok™ Quick Patch

The only ceramic bead-filled wear and abrasion resistant epoxy for emergency repair.

- Eliminates down-time with exceptionally fast cure
- Repairs holes, leaks and cracks

| Item # | Items Per Case | Size |
|--------|----------------|------|
| 11320  | 6              | 1 lb |

### Devcon® DFense Blok™ Surface Wetting Agent

A thixotropic epoxy gel system that improves the ease of application and cured adhesion properties of DFense Blok™.

- Zero wait time before applying DFense Blok™
- Orange color for easy visual inspection

| Item # | Items Per Case | Size |
|--------|----------------|------|
| 11340  | 2              | 1 lb |

### Devcon® DFense Blok™ Power Mixer

Recommended for most effective way to thoroughly mix DFense Blok™ Wearing Compound.

- Durable steel paddle with three blades;
- 2X faster than drill-style mixers
- Plugs into standard 120V outlet.

| Item # | Items Per Case | Size        |
|--------|----------------|-------------|
| 11301  | 1              | 5 gal Mixer |

# DFENSE BLOK™



**Watch our  
Impact Test!**



| Physical Properties   | Devcon®<br>DFense Blok™<br>With Surface Wetting Agent | Devcon®<br>DFense Blok™<br>Fast Cure (FC) | Devcon®<br>DFense Blok™<br>Quick Patch | Devcon®<br>DFense Blok™<br>Surface Wetting Agent |
|---|---|---|--|--|
| Color   | Grey  | Grey                                      | Grey                                   | Orange   |
| Mix ratio by weight/volume (resin:hardener)                         | 2:1/100:45  | 2:1/2:1                                   | 1:1/1:1                                | 2:1/100:44                                       |
| Mixed viscosity (cP)  | Putty   | Putty                                     | Putty                                  | Thixotropic Gel                                  |
| Functional cure (hours)   | 4-5   | 2-3                                       | 30 minutes                             | 4-5  |
| Pot life (minutes @ 75°F)   | 25  | 15  | 4                                      | 12-15  |
| Specific volume (inches³/pound)                                     | 12.6  | 13.5                                      | 14.89                                  | 24.7   |
| Coverage per pound (inches² @ 1/4" thickness)                       | 47  | 53  | 60                                     | 1,860 @ 12 mils                                  |
| Cured hardness (ASTM D2240) (Shore D)                               | 77  | 80  | 84                                     | 71   |
| Cured shrinkage (ASTM D2566) (inch/inch)                            | 0.0005  | 0.0008                                    | 0.0010                                 | N/A  |
| Adhesive tensile shear (ASTM D1002) (psi)                           | 2,616   | 2,764                                     | 2,495                                  | 2,616  |
| Compressive strength (ASTM D695) (psi)                              | 7,145   | 7,178                                     | 6,166                                  | 5,032  |
| Flexural strength (ASTM D790) (psi)                                 | 7,876   | 7,488                                     | 4,880                                  | 6,700  |
| Coefficient of thermal expansion (ASTM D696)[(in)/(in x °F)] x 10⁻⁶ | 29  | 33  | 31                                     | N/A  |
| Dielectric constant (ASTM D150) (1 kHz)                             | 49  | 45  | 51                                     | N/A  |
| Maximum continuous dry service temperature (°F)                     | 300   | 300                                       | 200                                    | 300  |
| Maximum continuous wet service temperature (°F)                     | 140   | 140                                       | N/A                                    | 140  |

| Chemical Resistance             | Devcon®<br>DFense Blok™<br>With Surface Wetting Agent | Devcon®<br>DFense Blok™<br>Fast Cure (FC) | Devcon®<br>DFense Blok™<br>Quick Patch | Devcon®<br>DFense Blok™<br>Surface Wetting Agent |
|---------------------------------|---|---|--|--|
| <b>ACIDS</b>                    | ⊗   | ⊗   | ⊗                                      | ⊗  |
| Acetic 10%                      | ●   | ●   | ●                                      | ●  |
| Hydrochloric 10%                | ●   | ●   | ●                                      | ●  |
| Sulfuric 10%                    | ●   | ●   | ●                                      | ●  |
| <b>ALCOHOLS</b>                 | ⊗   | ⊗   | ○                                      | ⊗  |
| Methanol                        | ○   | ⊗   | ○                                      | ○  |
| Isopropanol                     | ○   | ⊗   | ○                                      | ○  |
| <b>KETONES</b>                  | ○   | ⊗   | ○                                      | ○  |
| Acetone                         | ○   | ⊗   | ○                                      | ○  |
| Methyl ethyl ketone             | ○   | ⊗   | ○                                      | ○  |
| <b>ALKALIS</b>                  | ●   | ●   | ●                                      | ●  |
| Ammonium hydroxide 20%          | ●   | ●   | ●                                      | ●  |
| Sodium hydroxide 10%            | ●   | ●   | ●                                      | ●  |
| <b>HYDROCARBONS</b>             | ○   | ○   | ●                                      | ○  |
| Gasoline (unleaded)             | ○   | ○   | ●                                      | ○  |
| Mineral spirits                 | ●   | ●   | ●                                      | ●  |
| <b>CHLORINATED HYDROCARBONS</b> | ○   | ○   | ●                                      | ○  |
| 1-1-1 Trichloroethane           | ●   | ●   | ●                                      | ●  |
| <b>SALTS</b>                    | ●   | ●   | ●                                      | ●  |
| Sodium chloride                 | ●   | ●   | ●                                      | ●  |
| Trisodium phosphate             | ●   | ●   | ●                                      | ●  |

Key: ● Excellent   ● Very Good   ○ Fair   ⊗ Poor

## WEARING COMPOUNDS

Specially formulated wear-resistant epoxy coatings that protect dry materials handling and storage equipment from abrasion, corrosion and wear. These products are trowelable, non-sag putties available in large particulate, high impact, and high temperature formulas.

### Devcon® Wear Guard™ Fine Load

High-density, micro-alumina ceramic bead-filled epoxy system for protecting equipment that handles particulate smaller than 1/8".

- Withstands operating temperatures as high as 300 °F
- Outstanding resistance to a wide range of chemicals

| Item # | Items Per Case | Size  |
|--------|----------------|-------|
| 11470  | 1              | 30 lb |

### Devcon® Wear Guard™ High Load

Alumina ceramic bead-filled epoxy system with outstanding abrasion resistance for severe service conditions with particulate greater than 1/8".

- Trowels onto overhead or vertical surfaces without sagging
- Ideal for repairing scrubbers, ash handling systems, pipe elbows, screens, and chutes

| Item # | Items Per Case | Size  |
|--------|----------------|-------|
| 11490  | 1              | 30 lb |

### Devcon® Wear Guard™ High Temp

High-density, ceramic bead-filled epoxy system for maximum wear and abrasion resistance in high temperature applications.

- Heat-cured, trowelable system that gives up to 30% improvement over conventional wear compounds
- Withstands continuous service temperatures to 450 °F

| Item # | Items Per Case | Size  |
|--------|----------------|-------|
| 11480  | 1              | 30 lb |

### Devcon® Tile Adhesive

High-strength, trowelable adhesive that cures at room temperature.

- Bonds ceramic tile to vertical, curved, and overhead surfaces and repairs loose ceramic tiles
- Excellent chemical resistance to acids and alkalis

| Item # | Items Per Case | Size  |
|--------|----------------|-------|
| 11495  | 1              | 20 lb |

### Devcon® HV Tile Adhesive

High-strength, trowelable adhesive compound for bonding tile, with a 35 minute working time.

- High viscosity, great non-sag adhesive
- Fills gaps and joints in crushers prior to backing compounds

| Item # | Items Per Case | Size  |
|--------|----------------|-------|
| 11489  | 1              | 20 lb |

### Plexus® MMA Tile Adhesive

Primeless, high strength, creamy trowelable compound for bonding tile with a 14 minutes working time.

- Non-sag seams tiles to surface in 8 minutes
- Functional cure and back in seam in 1.5 hours

| Item # | Items Per Case | Size            |
|--------|----------------|-----------------|
| 11481  | 1              | 1 gal Adhesive  |
| 11486  | 1              | 1 gal Activator |



| Physical Properties   | Devcon®<br>Wear Guard™<br>Fine Load | Devcon®<br>Wear Guard™<br>High Load | Devcon®<br>Wear Guard™<br>High Temp | Devcon®<br>Tile Adhesive | Devcon®<br>HV Tile Adhesive | Plexus®<br>MMA Tile Adhesive |
|---|-------------------------------------|-------------------------------------|-------------------------------------|--------------------------|-----------------------------|------------------------------|
| Color   | Grey                                | Grey                                | Grey                                | White                    | Grey                        | White                        |
| Mix ratio by weight/volume (resin:hardener)                                     | 2:1 / 2:1                           | 2:1 / 2:1                           | 13.7:1 / 6:1                        | 1.1:1 / 1:1              | 1.1:1 / 1:1                 | 1.1:1 / 1:1                  |
| Mixed viscosity (cP)  | Putty                               | Putty                               | Putty                               | Putty                    | Putty                       | Putty                        |
| Functional cure (hours)   | 6-8                                 | 6-8                                 | Heat Cured                          | 12                       | 8                           | 1.5                          |
| Pot life (minutes @ 75°F)   | 30                                  | 30                                  | 120                                 | 240                      | 35                          | 14                           |
| Specific volume (inches <sup>3</sup> /pound)                                    | 12.4                                | 12.9                                | 14.3                                | 19.2                     | 19                          | 27.7                         |
| Coverage per pound (inches <sup>2</sup> @ 1/4" thickness)                       | 50                                  | 50                                  | 60                                  | 76.8                     | 76                          | 118                          |
| Cured hardness (ASTM D2240) (Shore D)   | 87                                  | 87                                  | 87                                  | 81                       | 81                          | 60                           |
| Cured shrinkage (ASTM D2566) (inch/inch)  | 0.0006                              | 0.0006                              | 0.0010                              | 0.0010                   | 0.0010                      | 0.005                        |
| Adhesive tensile shear (ASTM D1002) (psi)                                       | 1,375                               | 1,474                               | 2,300                               | 2,890                    | 1,825                       | 2,458                        |
| Compressive strength (ASTM D695) (psi)  | 11,000                              | 11,000                              | 13,200                              | 9,620                    | 11,800                      | 3,254                        |
| Flexural strength (ASTM D790) (psi)   | 7,190                               | 7,140                               | 8,220                               | 5,480                    | 5,400                       | 4,719                        |
| Coefficient of thermal expansion (ASTM D696)[(in)/(in x °F)] x 10 <sup>-6</sup> | 34                                  | 32                                  | 27                                  | 14                       | 14                          | 18                           |
| Dielectric constant (ASTM D150) (1 kHz)   | 46.0                                | 41.0                                | 38.0                                | 46.0                     | 45.0                        | 43.0                         |
| Maximum continuous dry service temperature (°F)                                 | 300                                 | 300                                 | 450                                 | 200                      | 200                         | 180                          |
| Maximum continuous wet service temperature (°F)                                 | 140                                 | 140                                 | 150                                 | 150                      | N/A                         | 150                          |

NOTES: 2 Three-part system, beads separate

| Chemical Resistance             | Devcon®<br>Wear Guard™<br>Fine Load | Devcon®<br>Wear Guard™<br>High Load | Devcon®<br>Wear Guard™<br>High Temp | Devcon®<br>Tile Adhesive | Devcon®<br>HV Tile Adhesive | Plexus®<br>MMA Tile Adhesive |
|---------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|--------------------------|-----------------------------|------------------------------|
| <b>ACIDS</b>                    | ⊗                                   | ⊗                                   | ⊗                                   | ⊗                        | ⊗                           | ⊗                            |
| Acetic 10%                      | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| Hydrochloric 10%                | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| Sulfuric 10%                    | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| <b>ALCOHOLS</b>                 | ⊗                                   | ⊗                                   | ⊗                                   | ⊗                        | ⊗                           | ⊗                            |
| Methanol                        | ⊗                                   | ⊗                                   | ⊗                                   | ⊗                        | ⊗                           | ⊗                            |
| Isopropanol                     | ⊗                                   | ⊗                                   | ⊗                                   | ○                        | ○                           | ○                            |
| <b>KETONES</b>                  | ⊗                                   | ⊗                                   | ⊗                                   | ⊗                        | ⊗                           | ⊗                            |
| Acetone                         | ⊗                                   | ⊗                                   | ⊗                                   | ●                        | ●                           | ⊗                            |
| Methyl ethyl ketone             | ⊗                                   | ⊗                                   | ⊗                                   | ●                        | ●                           | ⊗                            |
| <b>ALKALIS</b>                  | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| Ammonium hydroxide 20%          | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| Sodium hydroxide 10%            | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| <b>HYDROCARBONS</b>             | ●                                   | ●                                   | ●                                   | ⊕                        | ⊕                           | ⊗                            |
| Gasoline (unleaded)             | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| Mineral spirits                 | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| <b>CHLORINATED HYDROCARBONS</b> | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| 1-1-1 Trichloroethane           | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| <b>SALTS</b>                    | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| Sodium chloride                 | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |
| Trisodium phosphate             | ●                                   | ●                                   | ●                                   | ●                        | ●                           | ●                            |

Key: ● Excellent   ● Very Good   ○ Fair   ⊗ Poor

## THE NEWEST BELT REPAIR COMPOUND ...

### Devcon® R-Flex®

Devcon® R-Flex® is a self-leveling urethane kit for repairing holes, tears, gouges, and now metal splice clips, in SBR heavy weight conveyor belts. With greater flexibility, Devcon® R-Flex® can now be used to coat directly over metal clips to extend the life of previous repairs made. The kit includes: resin, curing agent, surface conditioner, metal clip primer, mix bucket (4 lb size only), scrub pad, gloves, paper towels, and plastic spatula. The coverage for 15550 4 lb kit is 440 sq inches at 1/4" thickness and for 15565 1.5 lb kit is 110 sq. inches at 1/4" thickness. Devcon® Surface Conditioner is a 2-part system that enhances the adhesion of Devcon® R-Flex® to SBR rubber. The fluorescence in surface conditioner allows for visual inspection to ensure greatest adhesion to the belt. It's easy to see in dark locations or bright sun light where the surface conditioner has been applied.

#### Key Product Features:

- Self-leveling liquid while applying then becomes a non-sag gel in 4 minutes
- Rapid initial adhesion
- Back in service in 90 minutes
- Easy to mix and pour
- Available in two kit sizes for large and small repairs

#### Devcon® R-Flex®

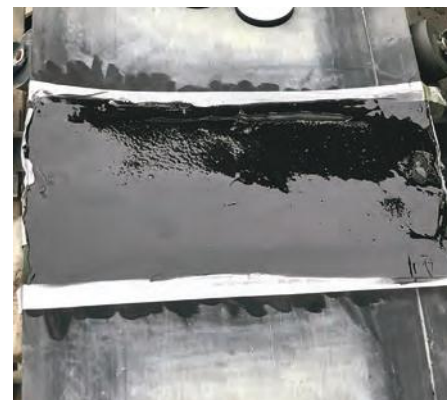
The newest belt repair product in the market place. A self-leveling urethane kit for repairing holes and tears in conveyor belts. Also used to cover and protect clips/pins from scrapers.

- Functional cure in 90 minutes
- High adhesion with surface pull of the SBR rubber
- Kit includes surface conditioner

| Item # | Items Per Case | Size   |
|--------|----------------|--------|
| 15550  | 1              | 4 lb   |
| 15565  | 4              | 1.5 lb |



Before Metal Clips Splice Repair



After Metal Clips Splice Repair



Before Repair: Large tear in belt due to rocks getting caught under the scraper blade.



After Repair: Belt flap cut down, Devcon Surface Conditioner and R-Flex applied to belt.



## BELTING & RUBBER REPAIR

Flexible urethane technologies for repairing worn or damaged SBR conveyor belts, rubber lined equipment such as pipes and tanks in mines, quarries, and coal-fired power plants. These products are in a non-sag putty for patching and repairing linings along with self-leveling thixotropic versions that create a smooth surface for repairing conveyor belts.

### Devcon® Flexane® 80 Putty

Trowelable urethane for repairing and lining process equipment exposed to wear, abrasion, vibration or expansion/contraction.

- Service temperatures to 180°F in dry environments and 120°F in wet environments
- Bonds to metal, concrete, rubber, wood, and fiberglass surfaces

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 15820  | 1 lb | 6              |
| 15850  | 4 lb | 1              |

### Devcon® Flexane® Brushable

High-performance brushable urethane for protection against abrasion and impact.

- Excellent for repairing/coating rubber-lined pumps, tanks and valves
- Applies in thicknesses of 50 mils in one application

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 15350  | 1 lb | 6              |



### Devcon® Flexane® High Performance Putty

Trowelable lining for maximum protection against abrasion, gouging and impact.

- Cures to a tough (tear strength 400 pli), resilient rubber compound (Hardness 78 Shore A)
- Bonds to metal, rubber, wood, fiberglass, and concrete

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 15330  | 1 lb | 6              |

### Devcon® Flexane® Fast Cure Putty

Black Flexane® Fast Cure thickens to a putty in seconds providing superior flexibility, elongation and adhesion to rubber.

- Light service duty in 3 hours
- Thixotropic, creamy formula which thickens in time
- Dispenser #15043 (manual) Nozzle #15047

| Item # | Size             | Items Per Case |
|--------|------------------|----------------|
| 15049  | 400 ml Cartridge | 4              |

### Devcon® Flexane® 80 Liquid

Medium-viscosity (10,000 cP) urethane fills voids completely and faithfully reproduces mold detail.

- Cures to semi-rigid rubber (Shore A 87)
- Cures at room temperature to a semi-rigid rubber material

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 15800  | 1 lb  | 6              |
| 15810  | 10 lb | 1              |

### Devcon® Flexane® FC Liquid

A convenient, time-saving method of filling expansion joints and repairing rubber.

- 8-minute working time
- No-mess dispensing with fast, easy, 400 ml reusable cartridges
- Dispenser #15043 (manual) Nozzle #15047

| Item # | Size             | Items Per Case |
|--------|------------------|----------------|
| 15050  | 400 ml Cartridge | 4              |

### Devcon® Flexane® 94 Liquid

Low-viscosity (6,000 cP) urethane fills voids completely and faithfully reproduces mold detail.

- Similar to Flexane® 80 Liquid, but cures to (Shore A 97)
- Requires only a five hour demolding time

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 15250  | 1 lb  | 6              |
| 15260  | 10 lb | 1              |

### Devcon® Flex-Add™

Used with Flexane® 80 Liquid to produce a more flexible urethane.

- Creates a lower durometer castable urethane
- Can match existing hardness of rubber

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 15940  | 8 oz | 6              |

### Devcon® Liquid Release Agent

Silicone release agent prevents Devcon's epoxy and urethane compounds from sticking to patterns or mold surfaces.

- Produces a high gloss finish
- Facilitates the accurate duplication of intricate details

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 19600  | 1 pt | 6              |

### Devcon® Flexane® Primer

Required for maximum adhesion of Flexane® products. FL-10 Primer for all metals. FL-20 Primer for rubber, wood, fiberglass and concrete. Ensures ultimate peel strength (greater than 80 psi).

| Item # | Primer | Size | Items Per Case |
|--------|--------|------|----------------|
| 15980  | FL-10  | 4 oz | 6              |
| 15985  | FL-20  | 4 oz | 6              |

# Belting and Rubber Repair

| Physical Properties                                       | Devcon® R-Flex® | Devcon® Flexane® 80 Putty | Devcon® Flexane® Brushable | Devcon® Flexane® High Performance Putty | Devcon® Flexane® Fast Cure Putty | Devcon® Flexane® Fast Cure Liquid | Devcon® Flexane® 80 Liquid | Devcon® Flexane® 94 Liquid |
|---|-----------------|---------------------------|----------------------------|---|----------------------------------|-----------------------------------|----------------------------|----------------------------|
| Color   | Black           | Black                     | Black                      | Black                                   | Black                            | Grey                              | Black                      | Black                      |
| Mix ratio by weight (resin:hardener)                      | 88:12           | 72:28                     | 80:20                      | 94:6                                    | 80:20                            | 80:20                             | 77:23                      | 69:31                      |
| Mixed viscosity (cP)                                      | Putty           | Putty                     | 40,000                     | Putty                                   | Putty                            | 5,800                             | 10,000                     | 6,000                      |
| Pot life (minutes @ 75°F)                                 | 4               | 20                        | 45                         | 10                                      | 8                                | 8                                 | 30                         | 10                         |
| Specific volume (inches <sup>3</sup> /pound)              | 27.4            | 23.5                      | 26.0                       | 23.5                                    | 23.5                             | 26.5                              | 26.5                       | 26.5                       |
| Coverage per pound (inches <sup>2</sup> @ 1/4" thickness) | 440/110         | 94                        | 104                        | 94                                      | 94                               | 106                               | 106                        | 106                        |
| Functional cure (hours)                                   | 1 1/2           | 12                        | 18                         | 16                                      | 3                                | 2                                 | 16                         | 16                         |
| Demolding time (hours)                                    | N/A             | N/A                       | N/A                        | N/A                                     | N/A                              | N/A                               | 10                         | 5                          |
| Cured hardness (ASTM D2240) (Shore A)                     | 92              | 87                        | 86                         | 78                                      | 88                               | 94                                | 87                         | 97                         |
| Cured shrinkage (ASTM D2566) (inch/inch)                  | NA              | 0.0014                    | 0.232                      | 0.12 <sup>2</sup>                       | 0.0014                           | 0.0018                            | 0.0018                     | 0.0014                     |
| Tensile strength (ASTM D412) (psi)                        | 1,462           | 1,700                     | 3,500                      | 4,500                                   | 2,400                            | 3,300                             | 2,100                      | 2,800                      |
| Tear resistance (ASTM D624) (pli)                         | 270             | 300                       | 400                        | 400                                     | 275                              | 430                               | 350                        | 415                        |
| Abrasion resistance weight loss <sup>1</sup> (mg)         | 270             | 280                       | 90                         | 140                                     | 220                              | 330                               | 285                        | 330                        |
| Maximum elongation (ASTM D412) (%)                        | 421             | 300                       | 600                        | 600                                     | 500                              | 450                               | 650                        | 500                        |
| Dielectric strength (ASTM D149) (volts/mil)               | 350             | 350                       | 340                        | 350                                     | 350                              | 350                               | 350                        | 350                        |
| Maximum continuous wet service temperature (°F)           | 120             | 120                       | 120                        | 120                                     | 120                              | 120                               | 120                        | 120                        |
| Maximum continuous dry service temperature (°F)           | 180             | 180                       | 180                        | 180                                     | 180                              | 180                               | 180                        | 180                        |
| Maximum continuous wet service temperature (°F)           | 120             | 120                       | N/A                        | 120                                     | 120                              | 120                               | 120                        | 120                        |

NOTES: <sup>1</sup> Taber H-18 wheel (mg/1,000 revolutions @ 1,000 gram load) <sup>2</sup> Due to solvent loss

| Chemical Resistance    | Devcon® R-Flex® | Devcon® Flexane® 80 Putty | Devcon® Flexane® Brushable | Devcon® Flexane® High Performance Putty | Devcon® Flexane® Fast Cure Putty | Devcon® Flexane® Fast Cure Liquid | Devcon® Flexane® 80 Liquid | Devcon® Flexane® 94 Liquid |
|------------------------|-----------------|---------------------------|----------------------------|---|----------------------------------|-----------------------------------|----------------------------|----------------------------|
| <b>ACIDS</b>           | ⊗               | ⊗                         | ⊗                          | ⊗                                       | ⊗                                | ⊗                                 | ⊗                          | ⊗                          |
| Acetic 10%             | ○               | ◐                         | ○                          | ○                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Hydrochloric 10%       | ○               | ◐                         | ○                          | ○                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Sulfuric 10%           | ○               | ◐                         | ○                          | ○                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Sulfuric 50%           | ○               | ◐                         | ○                          | ○                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Phosphoric 10%         | ○               | ◐                         | ○                          | ○                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| <b>ALCOHOLS</b>        |                 |                           |                            |   |                                  |                                   |                            |                            |
| Methanol               | ⊗               | ⊗                         | ⊗                          | ⊗                                       | ⊗                                | ⊗                                 | ⊗                          | ⊗                          |
| Isopropanol            | ⊗               | ⊗                         | ⊗                          | ⊗                                       | ⊗                                | ⊗                                 | ⊗                          | ⊗                          |
| <b>KETONES</b>         |                 |                           |                            |   |                                  |                                   |                            |                            |
| Acetone                | ⊗               | ⊗                         | ⊗                          | ⊗                                       | ⊗                                | ⊗                                 | ⊗                          | ⊗                          |
| Methyl ethyl ketone    | ⊗               | ⊗                         | ⊗                          | ⊗                                       | ⊗                                | ⊗                                 | ⊗                          | ⊗                          |
| <b>ALKALIS</b>         |                 |                           |                            |   |                                  |                                   |                            |                            |
| Ammonium hydroxide 20% | ◐               | ◐                         | ◐                          | ◐                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Sodium hydroxide 10%   | ◐               | ◐                         | ◐                          | ◐                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| <b>HYDROCARBONS</b>    |                 |                           |                            |   |                                  |                                   |                            |                            |
| Gasoline (unleaded)    | ○               | ⊗                         | ⊗                          | ⊗                                       | ⊗                                | ⊗                                 | ⊗                          | ⊗                          |
| Mineral spirits        | ○               | ⊗                         | ⊗                          | ⊗                                       | ⊗                                | ⊗                                 | ⊗                          | ⊗                          |
| <b>SALTS</b>           |                 |                           |                            |   |                                  |                                   |                            |                            |
| Sodium chloride        | ◐               | ◐                         | ◐                          | ◐                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Trisodium phosphate    | ◐               | ◐                         | ◐                          | ◐                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Aluminum sulfate 10%   | ◐               | ◐                         | ◐                          | ◐                                       | ◐                                | ◐                                 | ◐                          | ◐                          |
| Sodium carbonate 10%   | ◐               | ◐                         | ◐                          | ◐                                       | ◐                                | ◐                                 | ◐                          | ◐                          |

Key: ● Excellent ◐ Very Good ○ Fair ⊗ Poor

## CORROSION REPAIR COMPOUNDS

Ceramic filled epoxy technology used to make permanent repairs to pumps, shafts, pipes, and tanks where a corrosion-resistant polymer is needed to protect all metals against corrosion and erosion in slurry applications. These products apply easily with a brush or trowel.

### Devcon® Titanium Putty

High-performance, non-rusting titanium-reinforced epoxy putty for making repairs that can be precision machined.

- Withstands heavy loads in harsh chemical environments
- High compressive strength

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 10760  | 1 lb | 6              |
| 10770  | 2 lb | 6              |



### Devcon® Brushable Ceramic

When applied in a 15-20 mil coating, this low-viscosity, alumina-filled, brushable epoxy compound produces a smooth, protective barrier against wear, abrasion, corrosion, erosion and chemical attack.

- Temperature range up to 350° F
- Brushable Ceramic white is NSF 61 Certified

| Item # | Size         | Items Per Case |
|--------|--------------|----------------|
| 11760  | 2 lb (Red)   | 6              |
| 11762  | 12 lb (Red)  | 1              |
| 11765  | 2 lb (Blue)  | 6              |
| 11767  | 12 lb (Blue) | 1              |
| 11770  | 2 lb (White) | 6              |



### Devcon® Ceramic Repair Putty

Trowelable, alumina-filled epoxy compound for rebuilding, smoothing and protecting processing equipment exposed to corrosion, erosion, cavitation, chemicals and acids.

- Temperature range up to 350° F
- Excellent for filling voids and rebuilding metal castings

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 11700  | 3 lb | 6              |



### Devcon® Ceramic Repair Compound

Trowelable, alumina-filled epoxy compound with a 45-minute pot life and larger kit size for bigger jobs of rebuilding, smoothing and protecting processing equipment.

- Temperature range up to 350° F
- Excellent for filling voids and rebuilding metal castings

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 11730  | 32 lb | 1              |

# Corrosion Resistant Epoxies



| Physical Properties   | Devcon® Titanium Putty | Devcon® Brushable Ceramic Red, Blue | Devcon® Brushable Ceramic White | Devcon® Ceramic Repair Putty | Devcon® Ceramic Repair Compound |
|---|------------------------|-------------------------------------|---------------------------------|------------------------------|---------------------------------|
| Color   | Grey                   | Red, Blue                           | White                           | Dark Blue                    | Dark Blue                       |
| Mix ratio by weight/volume (resin:hardener)   | 4.3:1 / 3:1            | 5.6:1 / 3.4:1                       | 8.5:1 / 5.6:1                   | 7:1 / 4.3:1                  | 4.7:1 / 3.3:1                   |
| Mixed viscosity (cP)  | Putty                  | 32,000                              | 40,000                          | Putty                        | Putty                           |
| Functional cure (hours)   | 16                     | 16                                  | 16                              | 16                           | 16                              |
| Pot life (minutes @ 75°F)   | 21                     | 40                                  | 21                              | 25                           | 45                              |
| Specific volume (inches <sup>3</sup> /pound)  | 11.7                   | 17.5                                | 16.5                            | 16.4                         | 17.9                            |
| Coverage per pound (inches <sup>2</sup> @ 1/4" thickness)                                     | 47                     | 7.6 <sup>1</sup>                    | 7.6 <sup>1</sup>                | 66                           | 72                              |
| Cured hardness (ASTM D2240) (Shore D)   | 87                     | 85                                  | 84                              | 86                           | 86                              |
| Cured shrinkage (ASTM D2566) (inch/inch)  | 0.0010                 | 0.0020                              | 0.0020                          | 0.0022                       | 0.0024                          |
| Adhesive tensile shear (ASTM D1002) (psi)   | 2,000                  | 2,000                               | 2,000                           | 2,000                        | 2,231                           |
| Compressive strength (ASTM D695) (psi)  | 15,200                 | 13,700                              | 13,200                          | 12,700                       | 10,240                          |
| Flexural strength (ASTM D790) (psi)   | 7,700                  | 8,000                               | 8,000                           | 6,475                        | 5,870                           |
| Modulus of elasticity (ASTM D638) (psi x 10 <sup>5</sup> )                                    | 9.5                    | 8.0                                 | 8.0                             | 8.1                          | 8.1                             |
| Coefficient of thermal expansion (ASTM D696) [(in)/(in x °F)] x 10 <sup>-6</sup>              | 22                     | 25.6                                | 27.25                           | 23.8                         | 24.2                            |
| Thermal conductivity (ASTM C177) [(cal x cm)/(sec x cm <sup>2</sup> x °C)] x 10 <sup>-3</sup> | 1.95                   | 19                                  | 19                              | 1.88                         | 1.72                            |
| Dielectric constant (ASTM D150) (1 kHz)   | 44.8                   | 1.92                                | 1.92                            | 4.1                          | 3.8                             |
| Dielectric strength (ASTM D149) (volts/mil)   | 56                     | 382                                 | 382                             | 370                          | 350                             |
| Maximum continuous dry service temperature (°F)   | 350                    | 350                                 | 350                             | 350                          | 350                             |
| Maximum continuous wet service temperature (°F)   | 150                    | 150                                 | 150                             | 150                          | 150                             |

NOTES: <sup>1</sup> Coverage (feet<sup>2</sup> @ 15 mils)

| Chemical Resistance             | Devcon® Titanium Putty | Devcon® Brushable Ceramic Red, Blue | Devcon® Brushable Ceramic White | Devcon® Ceramic Repair Putty | Devcon® Ceramic Repair Compound |
|---------------------------------|------------------------|-------------------------------------|---------------------------------|------------------------------|---------------------------------|
| <b>ACIDS</b>                    | ○                      | ○                                   | ○                               | ○                            | ○                               |
| Acetic 10%                      | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Hydrochloric 10%                | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Sulfuric 10%                    | ◐                      | ◐                                   | ◐                               | ◐                            | ◐                               |
| <b>ALCOHOLS</b>                 | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Methanol                        | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Isopropanol                     | ●                      | ●                                   | ●                               | ●                            | ●                               |
| <b>KETONES</b>                  | ○                      | ○                                   | ○                               | ○                            | ○                               |
| Acetone                         | ○                      | ○                                   | ○                               | ○                            | ○                               |
| Methyl ethyl ketone             | ○                      | ○                                   | ○                               | ○                            | ○                               |
| <b>ALKALIS</b>                  | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Ammonium hydroxide 20%          | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Sodium hydroxide 10%            | ●                      | ●                                   | ●                               | ●                            | ●                               |
| <b>HYDROCARBONS</b>             | ●                      | ◐                                   | ◐                               | ●                            | ●                               |
| Gasoline (unleaded)             | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Mineral spirits                 | ●                      | ●                                   | ●                               | ●                            | ●                               |
| <b>CHLORINATED HYDROCARBONS</b> | ●                      | ●                                   | ●                               | ●                            | ●                               |
| 1-1-1 Trichloroethane           | ●                      | ●                                   | ●                               | ●                            | ●                               |
| <b>SALTS</b>                    | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Sodium chloride                 | ●                      | ●                                   | ●                               | ●                            | ●                               |
| Trisodium phosphate             | ●                      | ●                                   | ●                               | ●                            | ●                               |

Key: ● Excellent ◐ Very Good ○ Fair ○ Poor

## METAL REPAIR EPOXIES

Metal-filled epoxy technology that allow for fast economical permanent repairs to power plant and mining equipment. They can be machined, tapped and drilled, and corrosion resistant to harsh chemicals. These products are available in pourable versions that can be used to provide accurate detail reproductions for short run prototype mold patterns, holding fixtures and forming dies.



### Devcon® Plastic Steel® Putty (A)

The original metal-filled epoxy putty, it is ideal for repairing areas where welding or brazing would be impractical.

- Can be drilled, tapped and machined.
- Conforms to the requirements of MIL-PRF-24176C, Type I

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 10110  | 1 lb  | 6              |
| 10120  | 4 lb  | 6              |
| 10130  | 25 lb | 1              |



### Devcon® Plastic Steel® Liquid (B)

A pourable steel-filled epoxy that provides accurate detail reproduction in making holding fixtures, light gauge forming dies and molds.

- Can be drilled, tapped and machined
- Qualifies under Federal Specification MMM-A-1754, Adhesive/Sealing

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 10210  | 1 lb  | 6              |
| 10220  | 4 lb  | 6              |
| 10230  | 25 lb | 1              |



### Devcon® Plastic Steel® 5 Minute® Putty (SF)

Fast-curing, steel-filled epoxy for emergency repairs at temperatures as low as 40°F.

- Repaired parts can be returned to service within one hour
- Mixes, applies, and cures at temperatures as low as 40°F

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 10240  | 1 lb | 6              |



### Devcon® Stainless Steel Putty (ST)

Stainless steel-filled epoxy putty for patching, repairing and rebuilding stainless steel surfaces as well as food processing equipment.

- Bonds to ferrous and non-ferrous metals
- NSF 61 Certified

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 10270  | 1 lb | 6              |



### Devcon® Aluminum Putty

Aluminum-filled epoxy putty for dependable nonrusting repairs to aluminum castings, machinery and equipment.

- Can be machined drilled or tapped using conventional metalworking tools
- Widely used in HVAC applications, it conforms to requirements of MIL-PRF-24176C, Type II

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 10610  | 1 lb | 6              |
| 10620  | 3 lb | 6              |



### Devcon® Aluminum Liquid (F-2)

Aluminum-filled pourable epoxy for making molds, patterns and holding fixtures.

- It can be drilled, tapped and machined
- Hardens in just over 1 hour; cures in 16 hours
- Qualifies under Federal Specification MMM-A-1754, Adhesive/Sealing

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 10710  | 1 lb | 6              |
| 10720  | 3 lb | 6              |



### Devcon® Underwater Repair Putty (UW)

High-performance technology for repairing, patching, and rebuilding equipment in habitually wet environments, including under water.

- Non-rusting; easy-to-mix and apply
- Eliminates the need for substrate to be thoroughly dry before repair

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 11800  | 1 lb | 6              |



| Physical Properties  | Devcon® Plastic Steel® Putty (A) | Devcon® Plastic Steel® Liquid (B) | Devcon® Plastic Steel® 5 Minute® Putty (SF) | Devcon® Stainless Steel Putty (ST) | Devcon® Aluminum Putty (F) | Devcon® Aluminum Liquid (F-2) | Devcon® Underwater Repair Putty (UW) |
|--|----------------------------------|-----------------------------------|---|------------------------------------|----------------------------|-------------------------------|--------------------------------------|
| Color  | Dark Grey                        | Dark Grey                         | Dark Grey                                   | Grey                               | Aluminum                   | Aluminum                      | Grey                                 |
| Mix ratio by weight/volume (resin:hardener)  | 9:1 / 2.5:1                      | 9:1 / 3:1                         | 1.7:1 / 1:1                                 | 11:1 / 3.75:1                      | 9:1 / 4:1                  | 9:1 / 5:1                     | 1.4:1 / 1:1                          |
| Mixed viscosity (cP)   | Putty                            | 15 / 25,000                       | Putty                                       | Putty                              | Putty                      | 15 / 25,000                   | Putty                                |
| Functional cure (hours)  | 16                               | 16                                | 1   | 16                                 | 16                         | 16                            | 24                                   |
| Pot life (minutes @ 75°F)  | 45                               | 45                                | 5   | 58                                 | 60                         | 75                            | 45                                   |
| Specific volume (inches <sup>3</sup> /pound)   | 11.9                             | 13.1                              | 12.2  | 12.4                               | 17.5                       | 17.5                          | 17.0                                 |
| Coverage per pound (inches <sup>2</sup> @ 1/4" thickness)                                    | 48                               | 52                                | 49  | 50                                 | 70                         | 70                            | 68                                   |
| Cured hardness (ASTM D2240) (Shore D)  | 85                               | 85                                | 85  | 85                                 | 85                         | 85                            | 82                                   |
| Cured shrinkage (ASTM D2566) (inch/inch)   | 0.0006                           | 0.0006                            | 0.0006                                      | 0.0010                             | 0.0008                     | 0.0009                        | 0.0020                               |
| Adhesive tensile shear (ASTM D1002) (psi)  | 2,800                            | 2,800                             | 2,026                                       | 2,385                              | 2,600                      | 2,700                         | 2,685                                |
| Compressive strength (ASTM D695) (psi)   | 8,260                            | 10,200                            | 10,400                                      | 8,400                              | 8,420                      | 9,820                         | 5,625                                |
| Flexural strength (ASTM D790) (psi)  | 5,600                            | 7,480                             | 7,680                                       | 5,280                              | 6,760                      | 7,180                         | 4,990                                |
| Modulus of elasticity (ASTM D638) (psi x 10 <sup>5</sup> )                                   | 8.5                              | 8.5                               | 7.5   | 8.0                                | 8.0                        | 7.5                           | 7.5                                  |
| Coefficient of thermal expansion (ASTM D696) [(in)/(in x °F)] x 10 <sup>-6</sup>             | 48                               | 38                                | 34  | 34                                 | 29                         | 50                            | 18                                   |
| Thermal conductivity (ASTM C177) [(cal x cm)/(sec x cm <sup>2</sup> x °C)] x 10 <sup>3</sup> | 1.37                             | 1.39                              | 2.65  | 1.23                               | 1.73                       | 1.58                          | 1.41                                 |
| Dielectric constant (ASTM D150) (1 kHz)  | 67.5                             | 67.5                              | 35.0  | 75.0                               | 21.4                       | 8.6                           | 8.6                                  |
| Dielectric strength (ASTM D149) (volts/mil)  | 30                               | 30                                | 30  | 30                                 | 100                        | 100                           | 150                                  |
| Maximum continuous dry service temperature (°F)  | 250                              | 250                               | 200   | 250                                | 250                        | 250                           | 250                                  |
| Maximum continuous wet service temperature (°F)  | 120                              | 120                               | N/A   | 120                                | 120                        | 120                           | 120                                  |

| Chemical Resistance             | Devcon® Plastic Steel® Putty (A) | Devcon® Plastic Steel® Liquid (B) | Devcon® Plastic Steel® 5 Minute® Putty (SF) | Devcon® Stainless Steel Putty (ST) | Devcon® Aluminum Putty (F) | Devcon® Aluminum Liquid (F-2) | Devcon® Underwater Repair Putty (UW) |
|---------------------------------|----------------------------------|-----------------------------------|---|------------------------------------|----------------------------|-------------------------------|--------------------------------------|
| <b>ACIDS</b>                    | ⊗                                | ⊗                                 | ⊗   | ⊗                                  | ⊗                          | ⊗                             | ⊗                                    |
| Acetic 10%                      | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ○                                    |
| Hydrochloric 10%                | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ○                                    |
| Sulfuric 10%                    | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ○                                    |
| <b>ALCOHOLS</b>                 | ⊗                                | ⊗                                 | ⊗   | ⊗                                  | ○                          | ⊗                             | ⊗                                    |
| Methanol                        | ⊗                                | ⊗                                 | ⊗   | ⊗                                  | ○                          | ⊗                             | ⊗                                    |
| Isopropanol                     | ⊗                                | ⊗                                 | ⊗   | ⊗                                  | ○                          | ⊗                             | ⊗                                    |
| <b>KETONES</b>                  | ⊗                                | ⊗                                 | ⊗   | ⊗                                  | ⊗                          | ⊗                             | ⊗                                    |
| Acetone                         | ⊗                                | ⊗                                 | ⊗   | ⊗                                  | ⊗                          | ⊗                             | ⊗                                    |
| Methyl ethyl ketone             | ⊗                                | ⊗                                 | ⊗   | ⊗                                  | ⊗                          | ⊗                             | ⊗                                    |
| <b>ALKALIS</b>                  | ●                                | ●                                 | ○   | ●                                  | ○                          | ○                             | ●                                    |
| Ammonium hydroxide 20%          | ●                                | ●                                 | ○   | ●                                  | ○                          | ○                             | ●                                    |
| Sodium hydroxide 10%            | ●                                | ●                                 | ○   | ●                                  | ○                          | ○                             | ●                                    |
| <b>HYDROCARBONS</b>             | ●                                | ●                                 | ●   | ●                                  | ●                          | ●                             | ●                                    |
| Gasoline (unleaded)             | ●                                | ●                                 | ●   | ●                                  | ●                          | ●                             | ●                                    |
| Mineral spirits                 | ●                                | ●                                 | ●   | ●                                  | ●                          | ●                             | ●                                    |
| <b>CHLORINATED HYDROCARBONS</b> | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ●                                    |
| 1-1-1 Trichloroethane           | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ●                                    |
| <b>SALTS</b>                    | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ●                                    |
| Sodium chloride                 | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ●                                    |
| Trisodium phosphate             | ●                                | ●                                 | ○   | ●                                  | ●                          | ●                             | ●                                    |

Key: ● Excellent ○ Very Good ⊗ Fair ⊗ Poor

## METAL REPAIR EPOXIES

Metal-filled epoxy technology that allow for fast economical permanent repairs to power plant and mining equipment. They can be machined, tapped and drilled, and corrosion resistant to harsh chemicals. These products are available in pourable versions that can be used to provide accurate detail reproductions for short run prototype mold patterns, holding fixtures and forming dies.

### Devcon® Bronze Putty

Bronze-filled epoxy putty for repairing bronze and brass bushings, shafts, castings and equipment parts.

- Repairs and rebuilds areas where brazing would be undesirable or impossible
- Bonds securely to bronze alloys, brass, copper, and ferrous metals



| Item # | Size | Items Per Case |
|--------|------|----------------|
| 10260  | 1 lb | 6              |

### Devcon® Wear Resistant Putty (WR-2)

Smooth, non-rusting, all-purpose epoxy putty for repairs requiring low-friction finishes, such as machine lathe beds.

- Bonds to steel, iron, aluminum, ceramic, concrete, brass, and some plastics
- Contains wear-resistant fillers for low friction applications

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 11410  | 1 lb | 6              |
| 11420  | 3 lb | 6              |

### Devcon® FasMetal™

High-performance, alumina-filled epoxy for making fast, dependable emergency repairs to leaks in pipes.

- Hardens in 5 minutes
- Economical and convenient



| Item # | Size   | Items Per Case |
|--------|--------|----------------|
| 10780  | .75 lb | 6              |

### Devcon® HVAC Repair (Special F)

Aluminum-filled epoxy adhesive for HVAC repairs.

- Repairs coils in compressors
- Hardens to a rigid bond that can be ground, drilled or tapped

| Item # | Size   | Items Per Case |
|--------|--------|----------------|
| 19770  | 6.5 oz | 12             |

### Devcon® Zip Patch™

Easy-to-use adhesive patch kit for permanent waterproof repairs to pipes, tanks and drums. Hardens in minutes at room temperature.

| Item # | Size          | Items Per Case |
|--------|---------------|----------------|
| 11500  | 4" x 9" Patch | 6              |



### Devcon® Liquid Release Agent

Silicone release agent prevents Devcon's epoxy and urethane compounds from sticking to patterns or mold surfaces.

- Produces a high gloss finish
- Facilitates the accurate duplication of intricate details

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 19600  | 1 pt | 6              |

### Devcon® Cleaner Blend 300

Safe, multi-purpose, non-trichloroethane based degreaser for removing heavy grease and oil from metal surfaces.

- Needs no rinsing; leaves no residue
- Evaporates fast

| Item # | Size | Items Per Case |
|--------|------|----------------|
| 19510  | 1 pt | 6              |

| Physical Properties  | Devcon®<br>Bronze Putty (BR) | Devcon® Wear Resistant<br>Putty (WR-2) | Devcon®<br>FasMetal™ | Devcon® HVAC Repair<br>(Special F) | Devcon®<br>Zip Patch™ |
|--|------------------------------|--|----------------------|------------------------------------|-----------------------|
| Color  | Bronze                       | Dark Grey                              | Grey                 | Grey                               | Brown                 |
| Mix ratio by weight / volume<br>(resin:hardener)   | 9:1 / 3:1                    | 9:1 / 4:1                              | 1.07:1 / 1:1         | 0.9:1 / 1:1                        | N / A                 |
| Mixed viscosity (cP)   | Putty                        | Putty                                  | Putty                | 40,000                             | 17,000                |
| Functional cure (hours)  | 16                           | 16                                     | 1                    | 16                                 | 1                     |
| Pot life (minutes @ 75°F)  | 35                           | 45                                     | 4                    | 60                                 | 5                     |
| Specific volume<br>(inches <sup>3</sup> /pound)  | 12.4                         | 13.9                                   | 17.2                 | 16.1                               | N / A                 |
| Coverage per pound<br>(inches <sup>2</sup> @ 1/4" thickness)   | 50                           | 56                                     | 69                   | 64                                 | N / A                 |
| Cured hardness<br>(ASTM D2240) (Shore D)   | 85                           | 85                                     | 90                   | 85                                 | 70                    |
| Cured shrinkage<br>(ASTM D2566) (inch/inch)  | 0.0010                       | 0.0005                                 | 0.0093               | 0.0008                             | 0.0010                |
| Adhesive tensile shear<br>(ASTM D1002) (psi)   | 2,680                        | 2,200                                  | 2,000                | 2,500                              | 2,400                 |
| Compressive strength<br>(ASTM D695) (psi)  | 8,540                        | 9,800                                  | 12,700               | 8,420                              | N / A                 |
| Flexural strength<br>(ASTM D790) (psi)   | 6,180                        | 6,500                                  | 7,700                | 6,260                              | 19,000                |
| Modulus of elasticity<br>(ASTM D638) (psi x 10 <sup>5</sup> )  | 8.0                          | 7.5                                    | 8.5                  | 7.8                                | 2.9                   |
| Coefficient of thermal<br>expansion (ASTM D696)<br>[(in)/(in x °F)] x 10 <sup>-6</sup>               | 33                           | 32                                     | 32                   | 29                                 | 64                    |
| Thermal conductivity<br>(ASTM C177) [(cal x cm)/<br>(sec x cm <sup>2</sup> x °C)] x 10 <sup>-3</sup> | 1.57                         | 1.67                                   | 2.04                 | 1.73                               | 1.71                  |
| Dielectric constant<br>(ASTM D150) (1 kHz)   | 75.0                         | 6.3                                    | 18.6                 | 21.4                               | 43.5                  |
| Dielectric strength<br>(ASTM D149) (volts/mil)   | 25                           | 400                                    | 370                  | 100                                | 250                   |
| Maximum continuous dry<br>service temperature (°F)   | 250                          | 250                                    | 250                  | 250                                | 200                   |
| Maximum continuous wet<br>service temperature (°F)   | 120                          | 120                                    | 120                  | 110                                | N/A                   |

| Chemical Resistance                 | Devcon®<br>Bronze Putty (BR) | Devcon® Wear Resistant<br>Putty (WR-2) | Devcon®<br>FasMetal™ | Devcon® HVAC Repair<br>(Special F) | Devcon®<br>Zip Patch™ |
|-------------------------------------|------------------------------|--|----------------------|------------------------------------|-----------------------|
| <b>ACIDS</b>                        | ⊗                            | ⊗                                      | ⊗                    | ⊗                                  | ⊗                     |
| Acetic 10%                          | ●                            | ●                                      | ●                    | ●                                  | ●                     |
| Hydrochloric 10%                    | ●                            | ●                                      | ●                    | ●                                  | ●                     |
| Sulfuric 10%                        | ●                            | ●                                      | ●                    | ●                                  | ●                     |
| <b>ALCOHOLS</b>                     | ⊗                            | ⊗                                      | ⊗                    | ⊗                                  | ⊗                     |
| Methanol                            | ⊗                            | ⊗                                      | ⊗                    | ⊗                                  | ⊗                     |
| Isopropanol                         | ⊗                            | ⊗                                      | ⊗                    | ⊗                                  | ⊗                     |
| <b>KETONES</b>                      | ⊗                            | ⊗                                      | ⊗                    | ⊗                                  | ⊗                     |
| Acetone                             | ⊗                            | ⊗                                      | ⊗                    | ⊗                                  | ⊗                     |
| Methyl ethyl ketone                 | ⊗                            | ⊗                                      | ⊗                    | ⊗                                  | ⊗                     |
| <b>ALKALIS</b>                      | ●                            | ●                                      | ●                    | ⊗                                  | ⊗                     |
| Ammonium hydroxide 20%              | ●                            | ●                                      | ●                    | ⊗                                  | ⊗                     |
| Sodium hydroxide 10%                | ●                            | ●                                      | ●                    | ⊗                                  | ⊗                     |
| <b>HYDROCARBONS</b>                 | ●                            | ●                                      | ●                    | ●                                  | ●                     |
| Gasoline (unleaded)                 | ●                            | ●                                      | ●                    | ●                                  | ●                     |
| Mineral spirits                     | ●                            | ●                                      | ●                    | ●                                  | ●                     |
| <b>CHLORINATED<br/>HYDROCARBONS</b> | ●                            | ●                                      | ○                    | ○                                  | ⊗                     |
| 1-1-1 Trichloroethane               | ●                            | ●                                      | ○                    | ○                                  | ⊗                     |
| <b>SALTS</b>                        | ●                            | ●                                      | ○                    | ●                                  | ○                     |
| Sodium chloride                     | ●                            | ●                                      | ○                    | ●                                  | ○                     |
| Trisodium phosphate                 | ●                            | ●                                      | ○                    | ●                                  | ○                     |

Key: ● Excellent ● Very Good ○ Fair ⊗ Poor



## FLOOR REPAIR/PATCHING COMPOUNDS

100% solids epoxy-based polymers for patching, rebuilding and resurfacing concrete, brick, stucco and block.

### Devcon® Floor Patch™

All-purpose, easy-to-mix and apply concrete patching compound. With a compressive strength of 8,000 psi, Floor Patch™, provides three times the typical strength of concrete.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 13100  | 10 lb | 1              |
| 13120  | 40 lb | 1              |



### Devcon® Floor Patch™ FC (Fast-Cure)

With this fast-curing version of Floor Patch™, repaired areas can be back in service in 3 hours.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 13110  | 10 lb | 1              |



### Devcon® Floor Patch™ Resurfacer

A three-part filled epoxy system for concrete floors where aggregate is exposed. This self-leveling product mixes easily, is ideal for repairing damaged concrete and rebuilding to depths of 1/4" to 1".

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 13130  | 41 lb | 1              |

### Devcon® Deep Pour Grout™

Filled epoxy grout for pouring machinery mounting pads to 6" deep and rebuilding worn concrete. Easy to mix and self-leveling.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 13800  | 50 lb | 1              |

### Devcon® Ultra Quartz™

Heavy-duty, trowelable premium floor patching system with excellent chemical resistance. System includes a primer for superior adhesion to cured concrete or other surfaces.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 13550  | 35 lb | 1              |

## FLOOR COATINGS

Epoxy floor coatings for protecting plant floors, platforms, walkways and ramps against acids, alkalis and solvents.

### Devcon® Epoxy Coat™ 7000 Non-VOC

100% solids self-leveling coating for smooth or mildly spalled concrete. Produces an attractive, durable, chemical-resistant finish. Silica aggregate can be added to rebuild floors by 1/16" or more.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 12710  | 2 gal | 1              |



### Devcon® Epoxy Coat™ 7000 AR (Acid Resistant)

Novolac non-VOC epoxy coating provides superior resistance to concentrated acids (including 98% sulfuric) and chemicals. Excellent adhesion to concrete surfaces. Ideal for use around chemical storage tanks, dike walls and containment areas.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 12750  | 2 gal | 1              |

### Devcon® Epoxy Concrete Sealer

Self-leveling, non-VOC clear epoxy sealer can be used as a primer on damp surfaces. Easily applied by brush, roller or squeegee at temperatures as low as 40°F. Outstanding resistance to chemicals, acids, alkalis and hydrocarbons.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 12560  | 2 gal | 1              |



## ANTI-SKID PROTECTION

Granular additives used with Devcon® floor coatings to produce anti-slip surfaces for worker safety.

### Devcon® Floor Grip™

Heavy-duty epoxy compound with silicone carbide granules produces an exceptional non-skid surface on walkways, ramps, loading docks and stairs. Excellent adhesion to concrete, brick, steel, aluminum and wet surfaces. Can be applied at temperatures as low as 40°F.

| Item # | Size  | Items Per Case |
|--------|-------|----------------|
| 13090  | 2 gal | 1              |

# Floor Repair and Surfacing



| Physical Properties                               | Floor Patch™            | Floor Patch™ FC          | Ultra Quartz™           | Floor Patch™ Resurfacer               | Deep Pour Grout™                     | Epoxy Concrete Sealer | Epoxy Coat™ 7000 Non VOC | Epoxy Coat™ 7000 AR |
|---|-------------------------|--------------------------|-------------------------|---------------------------------------|--------------------------------------|-----------------------|--------------------------|---------------------|
| Coverage per unit (feet <sup>2</sup> @ thickness) | 18 @ 0.25" / 40 lb unit | 4.5 @ 0.25" / 10 lb unit | 13 @ 0.25" / 35 lb unit | 568 inches <sup>3</sup> / 41. lb unit | 640 inches <sup>3</sup> / 50 lb unit | 400 @ 8 mils          | 400 @ 8 mils             | 200 @ 16 mils       |
| Mixed viscosity (cP)                              | Putty                   | Putty                    | Putty                   | 5,000                                 | 13,000                               | 2,000                 | 2,000                    | 3,600               |
| Minimum application temperature (°F)              | 60 ~ 90                 | 60 ~ 90                  | 60 ~ 90                 | 50 ~ 90                               | 50 ~ 90                              | 40 ~ 90               | 55 ~ 90                  | 60 ~ 90             |
| Pot life (minutes @ 75°F)                         | 45                      | 15                       | 60                      | 40                                    | 40                                   | 60                    | 55                       | 36                  |
| Functional cure (hours)                           | 16                      | 3                        | 16                      | 24                                    | 16                                   | 24                    | 24                       | 24                  |
| Cured hardness (ASTM D2240) (Shore D)             | 85                      | 85                       | 95                      | 85                                    | 83                                   | 85                    | 85                       | 85                  |
| Maximum continuous service temperature (°F)       | 250                     | 250                      | 250                     | 180                                   | 180                                  | 180                   | 180                      | 200                 |
| % Solids  | 100                     | 100                      | 100                     | 100                                   | 100                                  | 100                   | 100                      | 100                 |

| Chemical Resistance             | Floor Patch™ | Floor Patch™ FC | Ultra Quartz™ | Floor Patch™ Resurfacer | Deep Pour Grout™ | Epoxy Concrete Sealer | Epoxy Coat™ 7000 Non VOC | Epoxy Coat™ 7000 AR |
|---------------------------------|--------------|-----------------|---------------|-------------------------|------------------|-----------------------|--------------------------|---------------------|
| <b>ACIDS</b>                    | ⊗            | ⊗               | ⊗             | ⊗                       | ⊗                | ⊗                     | ⊗                        | ⊗                   |
| Acetic 10%                      | ●            | ●               | ●             | ⊗                       | ●                | ●                     | ●                        | ●                   |
| Hydrochloric 10%                | ●            | ●               | ●             | ⊗                       | ●                | ●                     | ●                        | ●                   |
| Sulfuric 10%                    | ●            | ●               | ●             | ⊗                       | ●                | ●                     | ●                        | ●                   |
| <b>ALCOHOLS</b>                 | ○            | ○               | ●             | ○                       | ○                | ○                     | ○                        | ○                   |
| Methanol                        | ○            | ○               | ○             | ○                       | ○                | ○                     | ○                        | ○                   |
| Isopropanol                     | ○            | ○               | ○             | ○                       | ○                | ○                     | ○                        | ○                   |
| <b>KETONES</b>                  | ○            | ○               | ○             | ○                       | ○                | ○                     | ○                        | ○                   |
| Acetone                         | ○            | ○               | ○             | ○                       | ○                | ○                     | ○                        | ○                   |
| Methyl ethyl ketone             | ○            | ○               | ○             | ○                       | ○                | ○                     | ○                        | ○                   |
| <b>ALKALIS</b>                  | ●            | ●               | ●             | ●                       | ●                | ●                     | ●                        | ●                   |
| Ammonium hydroxide 20%          | ●            | ●               | ●             | ●                       | ●                | ●                     | ●                        | ●                   |
| Sodium hydroxide 10%            | ●            | ●               | ●             | ●                       | ●                | ●                     | ●                        | ●                   |
| <b>HYDROCARBONS</b>             | ●            | ●               | ●             | ○                       | ●                | ●                     | ●                        | ●                   |
| Gasoline (unleaded)             | ●            | ●               | ●             | ○                       | ●                | ●                     | ●                        | ●                   |
| Mineral spirits                 | ●            | ●               | ●             | ●                       | ●                | ●                     | ●                        | ●                   |
| <b>CHLORINATED HYDROCARBONS</b> | ●            | ●               | ●             | ●                       | ●                | ●                     | ●                        | ●                   |
| 1-1-1 Trichloroethane           | ●            | ●               | ●             | ●                       | ●                | ●                     | ●                        | ●                   |
| <b>SALTS</b>                    | ●            | ●               | ●             | ○                       | ○                | ○                     | ○                        | ○                   |
| Sodium chloride                 | ●            | ●               | ●             | ○                       | ○                | ○                     | ○                        | ○                   |
| Trisodium phosphate             | ●            | ●               | ●             | ○                       | ○                | ○                     | ○                        | ○                   |

Key: ● Excellent ○ Very Good ○ Fair ⊗ Poor

## THREADLOCKERS

### Permatex® Medium Strength Threadlocker BLUE

All-purpose, medium strength threadlocker. Ideal for all nut and bolt applications 1/4" to 3/4" (6 mm to 20 mm). Eliminates need for stocking expensive lock nuts and lock washers. Locks and seals while preventing parts from loosening due to vibration. Protects threads from corrosion. Removable with hand tools for easy disassembly. Mil-Spec (S-46163A), Type II, Grade N.



| Item # | Size                 |
|--------|----------------------|
| 24210  | 10 ml Bottle, Carded |
| 24250  | 50 ml Bottle         |
| 24225  | 250 ml Bottle        |

### Permatex® Surface Insensitive Threadlocker BLUE

Medium/High strength threadlocker for general-purpose applications. Especially well-suited for 1/4" to 3/4" (6 mm to 20 mm) fasteners that have a slight oil film. Prevents vibration loosening.

| Item # | Size          |
|--------|---------------|
| 24350  | 50 ml Bottle  |
| 24325  | 250 ml Bottle |

### Permatex® Permanent Strength Threadlocker RED

A permanent, high strength threadlocker that is applied to fasteners 3/8" to 1" (10 mm to 25 mm) in size before assembly. Designed for securing parts that must withstand heavy shock, vibration or extreme chemical or environmental conditions. Localized heat and hand tools are required to separate parts. Mil-Spec (S-46163A), Type II, Grade O.

| Item # | Size                 |
|--------|----------------------|
| 26210  | 10 ml Bottle, Carded |
| 26250  | 50 ml Bottle         |
| 26225  | 250 ml Bottle        |



### Permatex® High Strength Threadlocker RED

High strength threadlocker for heavy-duty applications 3/8" to 1" (10 mm to 25 mm). Especially well suited for permanently locking studs. Locks against vibration loosening. Removable with heat and hand tools. Mil-Spec (S-46163A), Type I, Grade K.

| Item # | Size                 |
|--------|----------------------|
| 27110  | 10 ml Bottle, Carded |
| 27150  | 50 ml Bottle         |
| 27125  | 250 ml Bottle        |



### Permatex® High Temperature Threadlocker RED

Hi-temp/hi-strength threadlocker for heavy-duty applications. Prevents bolts 3/8" to 1 1/2" (10 mm to 38 mm) from loosening due to shock, severe vibration and heat stress. Suited for temperatures up to 450°F (232°C). Removable with heat and hand tools.

| Item # | Size         |
|--------|--------------|
| 27250  | 50 ml Bottle |



### Permatex® Large Diameter Threadlocker RED

A high strength adhesive for locking and sealing large bolts and studs 1" (25 mm+) or larger in diameter. Heat may be required to weaken bond before parts can be disassembled. Mil-Spec (S-46163A), Type I, Grade L.

| Item # | Size          |
|--------|---------------|
| 27725  | 250 ml Bottle |

### Permatex® Penetrating Grade Threadlocker GREEN

A low viscosity threadlocking liquid that wicks along the threads of pre-assembled fasteners to secure them in place. Since it is applied after assembly, preventive maintenance procedures are simplified. Ideal for fasteners ranging from #2 to 1/2" (2.2 to 12 mm) in size. Localized heating and hand tools are needed for disassembly. Mil-Spec (S-46163A), Type III, Grade R.

| Item # | Size         |
|--------|--------------|
| 29050  | 50 ml Bottle |

### Permatex® GEL TWIST™

Permatex® Threadlocker Gels are the true innovation in threadlocking! Available in Medium Strength BLUE Gel and High Strength RED Gel, the unique Permatex® GEL TWIST™ applicators leave the threadlocker where you want it...on the part! No more liquid drips or solid stick globs to deal with. No more mess to clean or costly waste to worry about. Permatex® Threadlocker Gels eliminate these hassles while still providing "liquid quality" application reliability.

### Permatex® Medium Strength Threadlocker BLUE Gel

An all-purpose, medium strength blue threadlocker gel that reliably secures all nut and bolt applications 1/4" to 1" (6 mm to 25 mm). Locks and seals while preventing parts from loosening due to vibration. Protects threads from corrosion. Removable with hand tools for easy disassembly.

| Item # | Size                               |
|--------|------------------------------------|
| 24010  | 10 g GEL TWIST™ Applicator, Carded |



### Permatex® High Strength Threadlocker RED Gel

A high strength threadlocker red gel for heavy-duty applications. Ideal for reliably securing all permanent nut and bolt applications 3/8" to 1" (10 mm to 25 mm) and greater. Locks and seals while preventing parts from loosening due to vibration. Protects threads from corrosion. Requires heat or special tools for removal.

| Item # | Size                               |
|--------|------------------------------------|
| 27010  | 10 g GEL TWIST™ Applicator, Carded |

## THREAD SEALANTS

Permatex® Thread Sealants seal and secure metal pipes and fittings. By filling the space between threaded metal parts, Thread Sealants prevent leakage caused by vibration loosening, tape shredding, solvent evaporation, damaged threads and temperature cycling. Designed for low- and high-pressure applications, Thread Sealants seal instantly for online low-pressure testing.



### Permatex® High Performance Thread Sealant

Formulated specifically for metal, tapered pipe thread fittings. High Performance Thread Sealant replaces tapes and pipe dopes. Cures rapidly to withstand 10,000 psi. Prevents galling and protects mated threaded areas from rust and corrosion. Contains PTFE.

| Item # | Size               |
|--------|--------------------|
| 56521  | 50 ml Tube, Carded |
| 56525  | 250 ml Tube        |



### Permatex® High Temperature Thread Sealant

Locks and seals threaded fittings. Resists leakage, vibration loosening, moisture, hydraulic fluids and diesel fuels. Lubricates threads for easy assembly and disassembly. Parts may be repositioned up to 4 hours after application. Contains PTFE. Temperature range from -65°F to 400°F (-54°C to 204°C).

| Item # | Size               |
|--------|--------------------|
| 59235  | 50 ml Tube, Carded |
| 59225  | 250 ml Tube        |



### Permatex® Maximum Temperature Thread Sealant

A high performance, solvent resistant sealant that locks and seals metal tapered pipe threads and fittings. Specifically formulated for aluminum, stainless steel, galvanized metal and other inert metals. Temperature range -65°F to 400°F (-54°C to 204°C). Contains PTFE.

| Item # | Size               |
|--------|--------------------|
| 56750  | 50 ml Tube, Carded |
| 56725  | 250 ml Tube        |

### Permatex® Thread Sealant with PTFE

Economical general-purpose fitting sealant. Outperforms tapes and pipe dopes. Seals and resists pressure in air, oil, diesel fuel and hydraulic systems. Remains pliable at high and low temperatures. Temperature range -65°F to 300°F (-54°C to 149°C); resists common shop fluids.

| Item # | Size       | Part # |
|--------|------------|--------|
| 80632  | 4 oz Can   | 14H    |
| 80633  | 1.6 oz Can | 14D    |

### Permatex® Pneumatic/Hydraulic Sealant

Designed for locking and sealing high pressure hydraulic and pneumatic systems. Contains no fillers or particles which could contaminate system fluids, foul valves or clog fine filters and screens. Reliably cures on "as received" fasteners and controlled locking strength affords easy disassembly.

| Item # | Size         |
|--------|--------------|
| 54550  | 50 ml Bottle |

## PIPE JOINT COMPOUND

### Permatex® Pipe Joint Compound

Lubricates and seals threaded joints on water, oil and fuel lines. Temperature range -65°F to 400°F (-54°C to 204°C); resists common shop fluids.

| Item # | Size          | Part # |
|--------|---------------|--------|
| 80045  | 1.6 oz Bottle | 51D    |



## GASKET MAKERS

### Permatex® the Right Stuff® Gasket Maker

Heavy-bodied, black, elastomeric rubber provides instant seal. Superior flexibility and adhesion accommodates joint movement. Excellent oil resistance. Noncorrosive. Low odor. Low volatility. Temperature range of -75°F to 450°F (-59°C to 232°C) continuous, 500°F (260°C) intermittent. Not recommended for use on parts that will be in contact with gasoline.

| Item # | Size                  |
|--------|-----------------------|
| 25224  | 7 oz Automatic Tube*  |
| 85224  | 7.5 oz PowerBead™ Can |
| 33694  | 10.1 fl oz Cartridge  |



### Permatex® Ultra Black® Gasket Maker

Fast-curing formula. Sensor-safe, low odor, non-corrosive. Fills gaps of up to 0.25" when fully cured. Meets performance specs of OE silicone gaskets. Retains high flexibility, oil resistant properties through use of a patented adhesion system. Temperature range -65°F to 400°F (-54°C to 204°C) continuous, 500°F (250°C) intermittent. Resists common fluids and excessive vibration.

| Item # | Size                    |
|--------|-------------------------|
| 82180  | 3.35 oz Tube, Carded    |
| 82080  | 8.75 oz Automatic Tube* |
| 85080  | 9.5 oz PowerBead™ Can   |
| 24105  | 13 oz Cartridge         |



### Permatex® Ultra Grey® Gasket Maker

Designed for high torque applications requiring a unique RTV gasket. Fills gaps of up to 0.25" when fully cured. Low odor, non-corrosive. Outstanding oil and coolant resistance. Temperature range -65°F to 450°F (-54°C to 232°C) continuous, 500°F (250°C) intermittent. Resists common fluids and excessive vibration.

| Item # | Size                |
|--------|---------------------|
| 82194  | 3.5 oz Tube, Carded |
| 82195  | 13 oz Cartridge     |

### Permatex® Ultra Blue® RTV Silicone Gasket Maker

Fills gaps up to 0.25" when fully cured. Sensor-safe, low odor, non-corrosive. Outstanding oil resistance and joint movement values. Eight times more flexible than cork/composite gaskets; three times more oil resistant than conventional silicones. Temperature range -65°F to 400°F (-54°C to 204°C) continuous, 500°F (250°C) intermittent. Resists common fluids and excessive vibration.

| Item # | Size                  | Part # |
|--------|-----------------------|--------|
| 81724  | 3.35 oz Tube, Carded  | 77BR   |
| 85519  | 9.5 oz PowerBead™ Can |        |
| 81725  | 13 oz Cartridge       | 77C    |



### Permatex® Sensor-Safe Blue RTV Silicone Gasket Maker

The original Permatex® blue makes reliable "formed-in-place" gaskets that resist shrinking, cracking and migrating. Product cures to a strong, flexible rubber that seals flanges against leakage and resists oil and other shop fluids. Coat pre-cut gaskets to increase reliability. Temperature range -65°F to 400°F (-54°C to 204°C) continuous, 500°F (250°C) intermittent. Low volatility. Fills gaps to 0.25" when fully cured.

| Item # | Size                    | Part # |
|--------|-------------------------|--------|
| 80022  | 3 oz Tube, Carded       | 6BR    |
| 81860  | 7.25 oz Automatic Tube* | 6MA    |
| 80628  | 12.9 oz Cartridge       | 6C     |



### Permatex® High-Temp Red RTV Silicone Gasket Maker

Formulated for high-temp applications. It replaces almost any cut gasket by making reliable "formed-in-place" gaskets that resist cracking, shrinking and migrating caused by thermal cycling. Coat pre-cut gaskets to increase reliability. Temperature range -65°F to 600°F (-54°C to 316°C) continuous, 650°F (343°C) intermittent. Fills gaps to 0.25" when fully cured. MIL-A-46106 B, Type 1.

| Item # | Size                    | Part # |
|--------|-------------------------|--------|
| 81160  | 3 oz Tube, Carded       | 26BR   |
| 81915  | 7.25 oz Automatic Tube* |        |
| 85915  | 7.25 oz PowerBead™ Can  |        |
| 81409  | 11 oz Cartridge         | 26C    |



### Permatex® Ultra Copper® RTV Silicone Gasket Maker

Premium silicone designed to provide reliable, tough, flexible formed-in-place gaskets for mechanical assemblies. Temperature range -65°F to 600°F (-54°C to 316°C) continuous, 700°F (371°C) intermittent.

| Item # | Size              | Part # |
|--------|-------------------|--------|
| 81878  | 3 oz Tube, Carded | 101BR  |
| 82751  | 300 ml Cartridge  | 101C   |

### Permatex® Anaerobic Gasket Maker

Ideal for on-the-spot and emergency repairs, or when a conventional gasket is out of stock. This single component, thixotropic gasket maker cures rapidly for a medium strength, solvent resistant seal that resists temperatures up to 300°F (149°C) and fills gaps to 0.050" (primed). Can be used on a variety of metal surfaces including aluminum. Parts disassemble easily even after extended service.

| Item # | Size               |
|--------|--------------------|
| 51813  | 50 ml Tube, Carded |
| 51845  | 300 ml Cartridge   |

### Permatex® Anaerobic Flange Sealant

Flexible gasketing material ideal for use on rigid, machined flanges. Withstands temperatures to 300°F (149°C). Fills gap of 0.050" (primed) and eliminates the need for preformed gaskets. Ideal for flanges that move in service.

| Item # | Size             |
|--------|------------------|
| 51531  | 50 ml Tube       |
| 51580  | 300 ml Cartridge |



## ANTI-SEIZE & GASKET SEALANTS

### Permatex® Form-A-Gasket® No. 1 Sealant

Reliable paste-like gasket sealant/dressing/coating. Form-A-Gasket® No. 1 sets quickly. Recommended for rigid, permanent assemblies. Use to 400°F (204°C). Resistant to gasoline and other solvents. Conforms to MIL-S-45180 D, Type I.

| Item # | Size              | Part # |
|--------|-------------------|--------|
| 80003  | 11 oz Tube, Boxed | 1C     |

### Permatex® Form-A-Gasket® No. 2 Sealant

Reliable paste-like gasket sealant/dressing/coating. Form-A-Gasket® No. 2 sets more slowly to a pliable film best suited for non-rigid, vibrating assemblies. Use to 400°F (204°C). Resistant to gasoline and other solvents. Conforms to MIL-S-45180 D, Type II.

| Item # | Size                | Part # |
|--------|---------------------|--------|
| 80015  | 1.5 oz tube, Carded | 2AR    |
| 80016  | 3 oz tube, Carded   | 2BR    |
| 80011  | 11 oz tube, Boxed   | 2C     |

### Permatex® Aviation Form-A-Gasket® No. 3 Sealant

Non-hardening liquid gasket sealant/dressing/coating is a thin, brushable dressing or sealer for close-fitting parts. Suitable for continuous temperatures to 400°F (204°C). Resistant to antifreeze, aviation fuels, high-detergent oils and lubricants. Conforms to MIL-S-45180 D, Type III.

| Item # | Size            | Part # |
|--------|-----------------|--------|
| 80017  | 16 fl oz Bottle | 3D     |

## RETAINING COMPOUNDS

### Permatex® Bearing Mount for Close Fits

A low viscosity, rapid-curing anaerobic adhesive that augments the strength of press fit assemblies. Prevents fretting and corrosion. Up to 3,000 psi holding power. Mil-Spec (R-46082B), Type I.

| Item # | Size         |
|--------|--------------|
| 60950  | 50 ml Bottle |



### Permatex® Bearing Mount for Relaxed Fits

High strength, medium viscosity anaerobic adhesive for slip fit assemblies. Provides 3,500 psi shear strength on steel. Prevents fretting and corrosion. Fixture time is 10 minutes at room temperature.

| Item # | Size         |
|--------|--------------|
| 68050  | 50 ml Bottle |





## ANTI-SEIZE LUBRICANTS

### Permatex® Anti-Seize Lubricant

A heavy-duty blend of aluminum, copper and graphite lubricants in a petroleum base. Use during assembly to prevent galling, corrosion and seizing and to assure easier disassembly. An inert formulation, it will not evaporate or harden in extreme temperatures. Salt-, corrosion- and moisture-resistant. Temperature range -60°F to 1,600°F (-51°C to 871°C). Non-aerosol version meets Mil-Spec A-907. Δ NFPA Fire Code 30B: Level 3 (aerosol).

| Item # | Size                   | Part # |
|--------|------------------------|--------|
| 80071  | 4 oz Brush-Top Bottle  |        |
| 80078  | 8 oz Brush-Top Bottle  | 133K   |
| 80208  | 16 oz Brush-Top Bottle | 767    |

### Permatex® Copper Anti-Seize Lubricant

A premium quality copper anti-seize and thread lubricant that may be used to prevent seizing, corrosion and galling where high temperature conditions exist. Temperature range -30°F to 1,800°F (-34°C to 982°C). Provides good electrical conductivity. Meets Mil-Spec A-907.

| Item # | Size             | Part # |
|--------|------------------|--------|
| 09128  | Brush-Top Bottle |        |
| 31163  | Brush-Top Bottle |        |



### Permatex® Nickel Anti-Seize Lubricant

Copper-free anti-seize lubricant that protects metal parts from seizing and galling at temperatures up to 2,400°F (1,316°C). Ideal for use under conditions of extreme pressure and temperature and with stainless steel, titanium and nickel alloys.

| Item # | Size             | Part # |
|--------|------------------|--------|
| 77124  | Brush-Top Bottle | 771    |
| 77164  | Brush-Top Bottle | 771    |

## HAND CLEANERS

You need a waterless hand cleaner that really cleans – without turning your hands into sandpaper. You need the strength to remove grease, grime, paint, adhesives and all other soils your working hands get into – plus conditioners to prevent your hands from cracking and drying out. Permatex® hand cleaners are the choice of working hands. For over 50 years, Permatex® has offered high-quality hand cleaners and has maintained a leadership position through innovation and a concern for users' needs. Wherever hands are getting dirty, there's a place for Permatex® hand cleaners. To meet your growing needs, Permatex® offers a broad selection of product formulations and sizes.

### Permatex® Fast Orange® Pumice and Smooth Lotion Hand Cleaners

Industrial grade, biodegradable, waterless, petroleum solvent-free hand cleaner. It contains no harsh chemicals, mineral oils or ammonia that can sting cuts and abrasions. Pure, fresh-smelling natural citrus power does the cleaning while aloe, lanolin, glycerin and jojoba condition and protect skin. Fast Orange® gently deep cleans the toughest dirt and grease.



#### Pumice Lotion

| Item # | Size                   |
|--------|------------------------|
| 25219  | 1 gallon bottle w/pump |

#### Smooth Lotion

| Item # | Size                   |
|--------|------------------------|
| 23218  | 1 gallon bottle w/pump |

## SILICONE SEALANTS

### Permatex® Clear RTV Silicone Adhesive Sealant

General-purpose, clear RTV sealant. Seals, bonds, repairs, mends and secures glass, metal, plastics, fabric, vinyl, weather stripping and vinyl tops. May be applied to horizontal or vertical surfaces. Waterproof and flexible. Temperature range -75°F to 400°F (-59°C to 204°C); resists oil, water, weather, vibration, grease and more. Non-paintable. Mil-A-46106B, Type I.

| Item # | Size                    |
|--------|-------------------------|
| 80050  | 3 oz Tube, Carded       |
| 81913  | 7.25 oz Automatic Tube® |
| 85913  | 7.25 oz PowerBead™ Can  |
| 80855  | 11 oz Cartridge         |

### Permatex® Black Silicone Adhesive Sealant

General-purpose, black RTV sealant. Seals, bonds, repairs, mends and secures glass, metal, plastics, fabric, vinyl, weather stripping and vinyl tops. May be applied to horizontal or vertical surfaces. Waterproof and flexible. Temperature range -75°F to 450°F (-59°C to 232°C); resists oil, water, weather, vibration, grease and more. Non-paintable. Mil-A-46106B, Type I.



| Item # | Size              | Part # |
|--------|-------------------|--------|
| 81173  | 12.9 oz Cartridge | 16C    |

# AGENCY APPROVALS AND REFERENCES

## Devcon® Mil-Spec, UL and Other Government Specifications

| Product Category                   | Specification | Product                     | Part # | Size              |
|------------------------------------|---------------|-----------------------------|--------|-------------------|
| Devcon® Silicone Adhesive Sealants | A-46106A      | Sillite® Silicone RTV-Clear | 17100  | 3 oz Cartridge    |
|                                    |               |                             | 17150  | 10.3 oz Cartridge |
|                                    |               | Sillite® Silicone RTV-White | 17140  | 10.3 oz Cartridge |
|                                    |               |                             | 17130  | 10.3 oz Cartridge |

| Product Category               | Specification           | Product                   | Part #                | Size  |      |
|--------------------------------|-------------------------|---------------------------|-----------------------|-------|------|
| Devcon® Metal Repair Compounds | MIL-PRF-24176C, Type I  | Plastic Steel® Putty (A)  | 10110                 | 1 lb  |      |
|                                |                         |                           | 10120                 | 4 lb  |      |
|                                |                         |                           | 10130                 | 25 lb |      |
|                                |                         | Titanium Putty            | 10760                 | 1 lb  |      |
|                                |                         |                           | 10770                 | 2 lb  |      |
|                                |                         | Ceramic Repair Putty      | 11700                 | 3 lb  |      |
|                                |                         |                           | 10610                 | 1 lb  |      |
|                                | MIL-PRF-24176C, Type II | Aluminum Putty (F)        | 10620                 | 3 lb  |      |
|                                |                         |                           | 10210                 | 1 lb  |      |
|                                |                         |                           | 10220                 | 4 lb  |      |
|                                |                         | Plastic Steel® Liquid (B) | 10230                 | 25 lb |      |
|                                |                         |                           | 10710                 | 1 lb  |      |
|                                |                         |                           | Aluminum Liquid (F-2) | 10720 | 3 lb |

## Devcon® ABS Type Approved Products

| Product Category                               | ABS   | Product                             | Part # | Size  |
|--|-------|-------------------------------------|--------|-------|
| Devcon® Urethane Repair Compounds              | ABS   | Flexane Brushable                   | 15350  | 1 lb  |
| Devcon® Metal Repair Putties                   | ABS   | Plastic Steel® Putty (A)            | 10110  | 1 lb  |
|  |       |                                     | 10120  | 4 lb  |
|  |       |                                     | 10130  | 25 lb |
|  |       | Plastic Steel® 5 Minute® Putty (SF) | 10240  | 1 lb  |
|  |       | Aluminum Putty (F)                  | 10610  | 1 lb  |
|  |       |                                     | 10620  | 3 lb  |
|  |       | Titanium Putty                      | 10760  | 1 lb  |
|  |       |                                     | 10770  | 2 lb  |
|  |       | Stainless Steel Putty (ST)          | 10270  | 1 lb  |
|  |       | Bronze Putty (BR)                   | 10260  | 1 lb  |
| Ceramic Repair Putty                           | 11700 | 3 lb                                |        |       |
| Devcon® Metal Repair Liquids/Wearing Compounds | ABS   | Plastic Steel® Liquid (B)           | 10210  | 1 lb  |
|  |       |                                     | 10220  | 4 lb  |
|  |       |                                     | 10230  | 25 lb |
|  |       | Aluminum Liquid (F2)                | 10710  | 1 lb  |
|  |       |                                     | 10720  | 3 lb  |
|  |       | Brushable Ceramic Red               | 11760  | 2 lb  |
|  |       |                                     | 11762  | 12 lb |
|  |       | Brushable Ceramic Blue              | 11765  | 2 lb  |
|  |       |                                     | 11767  | 12 lb |
|  |       | Brushable Ceramic White             | 11770  | 2 lb  |

## Shore Hardness

| Sample Material       | Shore Hardness | Scale |
|-----------------------|----------------|-------|
| Bicycle Gel Seat      | 15-30          | 00    |
| Chewing Gum           | 20             | 00    |
| Rubber Band           | 20-25          | A     |
| Pencil Eraser         | 40             | A     |
| Door Seal             | 55             | A     |
| Car Tire Tread        | 60-70          | A     |
| Running Shoe Sole     | 70             | A     |
| Soft Skateboard Wheel | 78             | A     |
| Leather Belt          | 80             | A     |
| Hydraulic O-Ring      | 70-90          | A     |
| Hard Skateboard Wheel | 98             | A     |
| Shopping Cart Wheel   | 100            | A     |
| Ebonite Rubber        | 100            | A     |
| Solid Truck Tires     | 50             | D     |
| Hard Hat              | 75             | D     |

## Devcon® NSF Registered Products

| Product Category                   | NSF Approval | Product                     | Part #                             | Size         |
|------------------------------------|--------------|-----------------------------|------------------------------------|--------------|
| Devcon® Silicone Adhesive Sealants | NSF/ANSI 51  | Sillite® Silicone RTV-Clear | 17100                              | 3 oz Tube    |
|                                    |              |                             | 17150                              | 10.3 oz Tube |
|                                    |              | Sillite® Silicone RTV-White | 17140                              | 10.3 oz Tube |
|                                    |              |                             | Sillite® Silicone RTV (High Temp.) | 17130        |
| Devcon® Metal Repair Compounds     | NSF/ANSI 61  | Stainless Steel Putty       | 10270                              | 1 lb         |
|                                    |              | Brushable Ceramic (White)   | 11770                              | 2 lb         |
| Devcon® Flooring Repair            | R2           | Floor Patch™                | 13100                              | 10 lb.       |
|                                    |              |                             | 13120                              | 40 lb        |
|                                    |              | Floor Patch™ FC             | 13110                              | 10 lb        |
|                                    |              |                             | Epoxy Coat™ 7000 Non VOC           | 12710        |

## Viscosity (cP)

Viscosity is a measure of a fluid's resistance to flow as compared to water. Viscosity is measured in Centipoise (cP).

| Material           | Centipoise (cP) @ 70°F <sup>1</sup> |
|--------------------|-------------------------------------|
| Water              | 1-3                                 |
| Blood              | 10                                  |
| Ethylene Glycol    | 15                                  |
| Motor Oil (SAE 10) | 50                                  |
| Corn Oil           | 65                                  |
| Maple Syrup        | 150                                 |
| Motor Oil (SAE 40) | 250                                 |
| Motor Oil (SAE 60) | 1,000                               |
| Honey              | 2,000                               |
| Molasses           | 5,000                               |
| Chocolate Syrup    | 10,000                              |
| Ketchup            | 50,000                              |
| Peanut Butter      | 150,000                             |
| Lard               | 1,000,000                           |

NOTES: <sup>1</sup> Viscosities shown are measured at room temperature (70°F) and are approximate. Values will increase at lower temperatures and decrease at warmer temperatures.

## Bead Length<sup>2</sup> (inches)

| Bead Diameter | 50 ml | 300 ml | 380 ml | 400 ml | 1 lb  | 1 gal <sup>3</sup> |
|---------------|-------|--------|--------|--------|-------|--------------------|
| 1/4"          | 124   | 740    | 945    | 992    | 1,073 | 9,450              |
| 3/8"          | 56    | 335    | 420    | 448    | 477   | 4,200              |
| 1/2"          | 30    | 180    | 230    | 240    | 265   | 2,360              |
| 5/8"          | 20    | 120    | 151    | 160    | 172   | 1,510              |

NOTES: <sup>2</sup> For methacrylates, epoxies, and silicones. <sup>3</sup> 1 gallon = 3,791.76 ml (128.1 oz.)





**Permatex® Mil-Spec, UL and Other Government Specifications**

| Product Category                      | Specification                        | Product                              | Part #                              | Size                    |                         |
|---------------------------------------|--------------------------------------|--------------------------------------|-------------------------------------|-------------------------|-------------------------|
| Permatex® ZIP GRIP® Instant Adhesives | A-A-3097, Type II, Class 1           | GPE 3 Wicking                        | 70144                               | 14 g bottle             |                         |
|                                       |                                      |                                      | 70145                               | 2 g tube                |                         |
|                                       |                                      | GPE 15 Rubber Bonder                 | 70213                               | 1/3 oz bottle           |                         |
|                                       |                                      |                                      | GPE 30 All Purpose                  | 70350                   | 1 oz bottle             |
|                                       | A-A-3097, Type II, Class 2           | GPE 100 All Purpose-Medium Viscosity | 70450                               | 1 oz bottle             |                         |
|                                       |                                      | A-A-3097, Type II, Class 3           | TE 1000 Gap Filling                 | 72161                   | 1 lb bottle             |
|                                       | TE 2400 Gap Filling-Hi Temp          |                                      | 72250                               | 1 oz bottle             |                         |
|                                       | 72261                                |                                      | 1 lb bottle                         |                         |                         |
| Permatex® Threadlockers Liquids       | S-46163A, Type II, Grade N           | Medium Strength Threadlocker BLUE    | 24210                               | 10 ml bottle            |                         |
|                                       |                                      |                                      | 24250                               | 50 ml bottle            |                         |
|                                       |                                      |                                      | 24225                               | 250 ml bottle           |                         |
|                                       | S-46163A, Type II, Grade O           | Permanent Strength Threadlocker RED  | 26210                               | 10 ml bottle            |                         |
|                                       |                                      |                                      | 26250                               | 50 ml bottle            |                         |
|                                       |                                      |                                      | 26225                               | 250 ml bottle           |                         |
|                                       | S-46163A, Type I, Grade K            | High Strength Threadlocker RED       | 27110                               | 10 ml bottle            |                         |
|                                       |                                      |                                      | 27150                               | 50 ml bottle            |                         |
|                                       |                                      |                                      | 27125                               | 250 ml bottle           |                         |
|                                       | S-46163A, Type I, Grade L            | Large Diameter Threadlocker RED      | 27725                               | 250 ml bottle           |                         |
|                                       | S-46163A, Type III, Grade R          | Penetrating Grade Threadlocker GREEN | 29050                               | 50 ml bottle            |                         |
|                                       |                                      |                                      | 29025                               | 250 ml bottle           |                         |
|                                       | Permatex® Retaining Compounds        | R-46082B, Type I                     | Bearing Mount for Close Fits        | 60950                   | 50 ml bottle            |
|                                       | Permatex® Silicone Adhesive Sealants | A-46106B, Type I                     | Clear RTV Silicone Adhesive Sealant | 80050                   | 3 oz tube               |
|                                       |                                      |                                      |                                     | 81913                   | 7.25 oz Automatic Tube* |
| 85913                                 |                                      |                                      |                                     | 7.25 oz PowerBead™ can  |                         |
| 80855                                 |                                      |                                      |                                     | 11 oz cartridge         |                         |
| High Temp Red RTV Silicone Gasket     |                                      |                                      | 81160                               | 3 oz tube               |                         |
|                                       |                                      |                                      | 81915                               | 7.25 oz Automatic Tube* |                         |
|                                       |                                      |                                      | 85915                               | 7.25 oz PowerBead™ can  |                         |
|                                       |                                      |                                      | 81409                               | 11 oz cartridge         |                         |
| Black Silicone Adhesive Sealant       |                                      |                                      | 81158                               | 3 oz tube               |                         |
|                                       |                                      |                                      | 81173                               | 12.9 oz cartridge       |                         |

**Permatex® NSF Registered Products**

| Product Category               | NSF® Approval | Product                               | Part # | Size                   |
|--------------------------------|---------------|---------------------------------------|--------|------------------------|
| Permatex® Liquid Threadlockers | P1            | Medium Strength Threadlocker BLUE     | 24210  | 10 ml Bottle           |
|                                |               |                                       | 24250  | 50 ml Bottle           |
|                                |               |                                       | 24225  | 250 ml Bottle          |
|                                |               | Permanent Strength Threadlocker RED   | 26210  | 10 ml Bottle           |
|                                |               |                                       | 26250  | 50 ml Bottle           |
|                                |               |                                       | 26225  | 250 ml Bottle          |
|                                |               | Penetrating Grade Threadlocker GREEN  | 29050  | 50 ml Bottle           |
| Permatex® Gel Threadlockers    | P1            | Medium Strength Threadlocker BLUE     | 24010  | 10 g Gel Twist™ Carded |
|                                |               | High Strength Threadlocker RED        | 27010  | 10 g Gel Twist™ Carded |
| Permatex® Thread Sealants      | P1            | High Performance Thread Sealant       | 56521  | 50 ml tube, Carded     |
|                                |               |                                       | 56525  | 250 ml Tube            |
| Permatex® Retaining Compounds  | P1            | Bearing Mount for Relaxed Fits        | 68050  | 50 ml Bottle           |
| Permatex® Gasket Makers        | P1            | ULTRA BLUE® RTV Silicone Gasket Maker | 81724  | 3.35 oz tube, Carded   |
|                                |               |                                       | 85519  | 9.5 oz PowerBead™ Can  |
|                                |               |                                       | 81725  | 13 oz Cartridge        |
|                                |               | The Right Stuff® Gasket Maker         | 25224  | 7 oz Automatic Tube    |
|                                |               |                                       | 29208  | 5 oz Cartridge         |
|                                |               |                                       | 85224  | 9.5 oz PowerBead™ Can  |
|                                |               |                                       | 33694  | 10.1 fl oz Cartridge   |
|                                |               | Anaerobic Gasket Maker                | 51813  | 50 ml tube, Carded     |
|                                |               |                                       | 51845  | 300 ml Cartridge       |



Plexus® branded products are GREENGUARD Children & Schools Certified



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