



2 Ton® Epoxy

Description: Extremely strong, medium-cure, water-resistant clear adhesive that will self-level after application.

Intended Use: Bonding parts in a structural environment or potting electronic components and assemblies

Product features: Cures without shrinking
Cures at room temperature
Good impact resistance
Produces strong, rigid bond on metal, ceramics, wood, concrete, glass, or combinations

Limitations: Store between 55° and 75° F for optimum results. Keep from freezing.

Typical Physical Properties: *Technical data should be considered representative or typical only and should not be used for specification purposes.*

Cured 7 days @ 75° F

Adhesive Tensile Lap Shear[GBS]	2,250 psi @ 0.010" bondline
Color (Mixed)	Clear
Compression Strength	11,000 psi
Dielectric Strength	600 volts/mil
Gap Fill	Good
Impact Resistance	6.5 ft.-lb./in.(2)
Service Temperature	Dry, -40°F to 200°F
Shore Hardness	83 Shore D
Solids by Volume	100
Specific Volume	25.2 in.(3)/lb.
Tensile Elongation	1%
Tpeel	2-3 pli

TESTS CONDUCTED

Thermal Conductivity ASTM C 177
Dielectric Strength, volts/mil ASTM D 149
Compressive Strength ASTM D 695
Cured Hardness Shore D ASTM D 2240
Adhesive Tensile Shear ASTM D 1002

Uncured

Fixture Time	30-35 min. @ 72°F
Full Cure	16 hrs.
Functional Cure	2 hrs. @ 72°F
Mix Ratio by Volume	1:1 Resin/Hardener
Mix Ratio by Weight	1.2:1 Resin/Hardener
Mixed Density	9.17 lbs/gal.: 1.10 gm/cc
Mixed Viscosity	8,000 cps
Working Time	8-12 min. (28 gm @ 72°F)

Surface Preparation: Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength.

Mixing Instructions: ---- Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. ----

25 ML DEV-TUBE

1. Squeeze material into a small container the size of an ashtray.
2. Using mixing stick included on Dev-tube handle, vigorously mix components for one (1) minute.
3. Immediately apply to substrate.

50 ML/400ML/490 ML CARTRIDGES

1. Attach cartridge to Mark V™ [50ml] 400ml manual or pneumatic dispensing systems.
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to substrate.

Application Instructions:

1. Apply mixed epoxy directly to one surface in an even film or as a bead.
2. Assemble with mating part within recommended working time.
3. Apply firm pressure between mating parts to ensure good adhesive contact, a small fillet of epoxy should flow out the edges to display adequate gap fill. The minimum recommended gap thickness is 0.005".

For very large gaps:

1. Apply epoxy to both surfaces
2. Spread to cover entire area OR make a bead pattern to allow flow throughout the joint

Let bonded assemblies stand for recommended functional cure time prior to handling.

CAPABILITIES:

Can withstand processing forces
Do not drop, shock load, or heavily load

Full bond strength is reached in 16 hours.

Storage:

Store in a cool, dry place.

Compliances:

None

Chemical Resistance:

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F

Acetic (Dilute) 10%	Poor	Hydrochloric 10%	Poor
Acetone	Fair	Isopropanol	Poor
Ammonia	Very good	Kerosene	Excellent
Corn Oil	Excellent	Methyl Ethyl Ketone	Poor
Cutting Oil	Excellent	Mineral Spirits	Excellent
Ethanol	Poor	Motor Oil	Excellent
Gasoline (Unleaded)	Poor	Sodium Hydroxide 10%	Very good
Glycols/Antifreeze	Excellent	Sulfuric 10%	Poor

Precautions:

Please refer to the appropriate safety data sheet (SDS) prior to using this product.

For technical assistance, please call 1-855-489-7262

FOR INDUSTRIAL USE ONLY

Warranty:

ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer:

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Performance Polymers makes no representations or warranties of any kind concerning this data.

Order Information:

- 14355 400 ml cartridge
- 14310 25 ml Dev-Tube™
- 14360 9 lb.
- 14260 50 ml cartridge