

Devcon[®]

PLEXUS[®]

SprayCore[®]

PRODUCT CATALOG

ITW Polymers Adhesives

www.itwadhesives.com



Quality, Innovation, Performance, Durability, Versatility, Sustainability



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About ITW Polymers Adhesives

ITW Polymers Adhesives

NORTH AMERICA

Our Mission

To be recognized as world leader in offering the most comprehensive adhesive products to the mining, coal-fired power, alternative energy (wind), transportation, marine, composites, engineered construction and general industrial markets. We are committed to quality, innovative products, and customer service.

Our Goal

To provide our customers with innovative adhesive solutions to support future growth and strengthen our global leadership position within the adhesives industry.

About ITW Polymers Adhesives, North America

In 2013, Devcon®, Plexus® and SprayCore® operations merged together to form a new division ITW Polymers Adhesives, North America, headquartered at 30 Endicott Street, Danvers, MA 01923. The formation of this division is part of the overall ITW strategic plan designed to create larger divisions that are highly focused on innovative products and service solutions to targeted markets. We enhance global competitiveness and drive operational efficiencies while retaining the positive attributes of a decentralized operating model, creating a strong focus on markets and customers at the local level, enabling its businesses to respond rapidly to market dynamics.

The company differentiates its business from its competitors based on product innovation, product quality, brand preference, service delivery, and price. Technical capability is also a competitive factor in our division. Developing new and improved products, broadening the application of established products, and continuing efforts to improve and develop new methods, processes and equipment, all contribute to the company's organic growth. For more information, please visit www.itwadhesives.com.

About ITW (Illinois Tool Works Inc.)

ITW is a Fortune 200 global diversified industrial manufacturer of value-added consumables and specialty equipment with related service businesses headquartered in Glenview, IL. The company focuses on profitable growth with strong returns across its world-wide platforms and businesses. These businesses serve local customers and markets around the globe, with a significant presence in developed as well as emerging markets. ITW has operations in 56 countries that employ approximately 51,000 women and men who adhere to the highest ethical standards. These talented individuals, many of whom have specialized engineering or scientific expertise, contribute to our global leadership in innovation. We are proud of our broad portfolio of nearly 10,000 active patents. For more information about ITW, please visit www.itw.com.

Devcon® **PLEXUS®** **SprayCore®**

Product Capabilities

ITW Polymers Adhesives, North America 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.

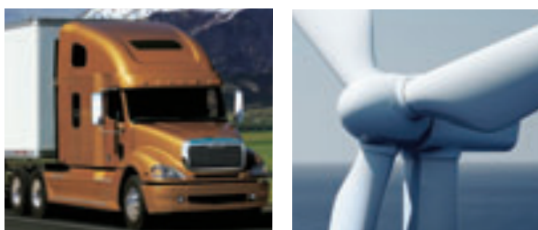
Mining, Coal-Fired Power, Aggregate and Industrial

- 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 Polymers Adhesives, North America 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 Polymers Adhesives, North America branded products and services around the world. The ITW Polymers Adhesives, North America 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

Plexus® MA300 (same product as Devcon® Plastic Welder™)

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.

Item #	Size	Mix Ratio by Vol.	Color
IT410	50 ml Twin Cartridge*	1:1	Black
30500	50 ml Twin Cartridge*	1:1	Off-White/Straw
IT412	400 ml Twin Cartridge	1:1	Black
30000	400 ml Twin Cartridge	1:1	Off-White/Straw
IT405	5 gal Pail Adhesive	1:1	Off-White/Straw
IT406	5 gal Pail Activator	1:1	Off-White/Straw
IT407	50 gal Drum Adhesive	1:1	Off-White/Straw
IT408	50 gal Drum Activator	1:1	Off-White/Straw

Devcon® Plastic Welder™ (same product as Plexus® MA300)

Toughened adhesive for high strength load-bearing bonds to engineered plastics, metals, composites, ceramics and dissimilar substrates. Approved under UL 746C Polymeric Adhesive Systems, Electrical Equipment - Component. SAMS listed.

Item #	Size	Mix Ratio by Vol.	Color
14320	50 ml Twin Cartridge*	1:1	Off-White/Straw

Plexus® MA310 (same product as Devcon® Plastic Welder™ II)

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.

Item #	Size	Mix Ratio by Vol.	Color
31500	50 ml Twin Cartridge*	1:1	Off-White/Straw
31000	400 ml Twin Cartridge	1:1	Off-White/Straw
IT435	5 gal Pail Adhesive	1:1	Off-White/Straw
IT406	5 gal Pail Activator	1:1	Off-White/Straw
IT408	50 gal Drum Activator	1:1	Off-White/Straw
IT437	50 gal Drum Adhesive	1:1	Off-White/Straw

Devcon® Plastic Welder™ II (same product as Plexus® MA310)

Formulated for difficult-to-bond engineered plastics such as nylon-based alloys, epoxy composites and modified polyesters.

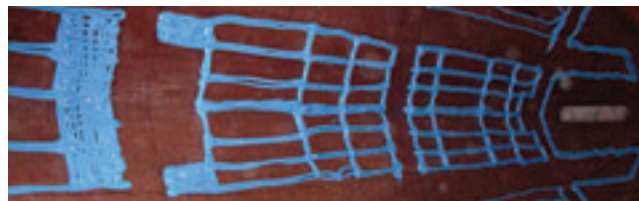
Item #	Size	Mix Ratio by Vol.	Color
14340	50 ml Twin Cartridge*	1:1	Off-White/Straw
14390	400 ml Twin Cartridge	1:1	Off-White/Straw

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.

Item #	Size	Mix Ratio by Vol.	Color
33500	50 ml Twin Cartridge*	1:1	Gray
33000	400 ml Twin Cartridge	1:1	Gray
IT731	5 gal Pail Adhesive	1:1	White
IT732	5 gal Pail Activator	1:1	Black
IT741	50 gal Drum Adhesive	1:1	White
IT742	50 gal Drum Activator	1:1	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.

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

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

Item #	Size	Mix Ratio by Vol.	Color
59000	400 ml Twin Cartridge	1:1	Black
IT177	5 gal Pail Adhesive	1:1	White
IT178	5 gal Pail Activator	1:1	Black/White
IT170	50 gal Drum Adhesive	1:1	White
IT175	50 gal Drum Activator	1:1	Black/White

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.

Item #	Size	Mix Ratio by Vol.	Color
IT025	380 ml Co-Axial Cartridge	10:1	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).

Item #	Size	Mix Ratio by Vol.	Color
32000B	380 ml Co-Axial Cartridge	10:1	Black
32000	380 ml Co-Axial Cartridge	10:1	Off-White/Straw
32000W	380 ml Co-Axial Cartridge	10:1	White
32200	5 gal Pail Adhesive	10:1	Off-White/Straw
32400	5 gal Pail Activator	10:1	Off-White/Straw/White
32900	5 gal Pail Activator	10:1	Black
35400	5 gal Pail Activator	10:1	White
32800	50 gal Drum Adhesive	10:1	Off-White/Straw/White

Plexus® A0/MA420

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.

Item #	Size	Mix Ratio by Vol.	Color
IT135	380 ml Co-Axial Cartridge	10:1	Black
IT101B	380 ml Co-Axial Cartridge	10:1	Blue
IT101	380 ml Co-Axial Cartridge	10:1	Off-White/Straw
IT102	5 gal Pail Adhesive	10:1	Off-White/Straw
IT103	5 gal Pail Activator	10:1	Off-White/Straw
IT107	5 gal Pail Activator	10:1	Blue
IT140	5 gal Pail Activator	10:1	Black
IT100	50 gal Drum Adhesive	10:1	Off-White/Straw

Plexus® MA420FS

A two-part methacrylate adhesive designed for structural bonding of thermoplastic, metal, and composite assemblies. Combined at a 10:1 ratio, MA420FS has a working time of 1 to 2 minutes and develops handling strength within 5 to 6 minutes at 74 °F (23 °C). 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.

Item #	Size	Mix Ratio by Vol.	Color
IT800	380 ml Co-Axial Cartridge	10:1	Blue
IT804	380 ml Co-Axial Cartridge	10:1	Black
IT103	5 gal Pail Activator	10:1	Off-White/Straw
IT107	5 gal Pail Activator	10:1	Blue
IT140	5 gal Pail Activator	10:1	Black
IT801	50 gal Drum Adhesive	10:1	Off-White/Straw

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.

Item #	Size	Mix Ratio by Vol.	Color
IT131	380 ml Co-Axial Cartridge	10:1	Blue
IT133	490 ml Co-Axial Cartridge	10:1	Blue
IT132	5 gal Pail Adhesive	10:1	Off-White/Straw
IT153	5 gal Pail Activator	10:1	Blue

*Filled to approx. 47 ml.

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.

Item #	Size	Mix Ratio by Vol.	Color
IT151	380 ml Co-Axial Cartridge	10:1	Blue
IT152	5 gal Pail Adhesive	10:1	Off-White/Straw
IT153	5 gal Pail Activator	10:1	Blue
IT150	50 gal Drum Adhesive	10:1	Off-White/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.

Item #	Size	Mix Ratio by Vol.	Color
35000	380 ml Co-Axial Cartridge	10:1	White
35400	5 gal Pail Activator	10:1	White
35200	5 gal Pail Adhesive	10:1	Off-White/Straw
35800	50 gal Drum Adhesive	10:1	Off-White/Straw

Plexus® MA830 (same product as Devcon® Metal Welder™)

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.

Item #	Size	Mix Ratio by Vol.	Color
IT194	50 ml Cartridge*	10:1	Gray GB
IT186	380 ml Co-Axial Cartridge	10:1	Gray
IT187	380 ml Co-Axial Cartridge	10:1	Gray GB
IT185	5 gal Pail Adhesive	10:1	Off-White/Straw
IT262	5 gal Pail Activator	10:1	Gray
IT284	5 gal Pail Activator	10:1	Gray GB
IT188	50 gal Drum Adhesive	10:1	Off-White/Straw



STRUCTURAL ADHESIVES

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.

Item #	Size	Mix Ratio by Vol.	Color
IT332	380 ml Co-Axial Cartridge	10:1	Gray
IT331	380 ml Co-Axial Cartridge	10:1	Gray GB
IT330	5 gal Pail Adhesive	10:1	Off-White/Straw
IT262	5 gal Pail Activator	10:1	Gray
IT284	5 gal Pail Activator	10:1	Gray GB
IT333	50 gal Drum Adhesive	10:1	Off-White/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.

Item #	Size	Mix Ratio by Vol.	Color
35900	380 ml Co-Axial Cartridge	10:1	Blue
IT103	5 gal Pail Activator	10:1	Off-White/Straw
IT107	5 gal Pail Activator	10:1	Blue
IT140	5 gal Pail Activator	10:1	Black
35910	50 gal Drum Adhesive	10:1	Off-White/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.

Item #	Size	Mix Ratio by Vol.	Color
IT222	380 ml Co-Axial Cartridge	10:1	Blue
IT220	5 gal Pail Adhesive	10:1	Off-White/Straw
IT107	5 gal Pail Activator	10:1	Blue
IT225	50 gal Drum Adhesive	10:1	Off-White/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.

Item #	Size	Mix Ratio by Vol.	Color
IT232	380 ml Co-Axial Cartridge	10:1	Blue
IT236	5 gal Pail Adhesive	10:1	Off-White/Straw
IT237	5 gal Pail Activator	10:1	Blue
IT235	50 gal Drum Adhesive	10:1	Off-White/Straw

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.

Item #	Size	Mix Ratio by Vol.	Color
IT246	5 gal Pail Activator	10:1	Blue
IT030	50 gal Drum Adhesive	10:1	Off-White/Straw



Plexus® MA2045

A two-part methacrylate adhesive designed for MA2045 was uniquely formulated to eliminate problems associated with adhesive sag and slide, even when applied to a vertical surface. In addition, MA2045 does not boil in gaps up to 1.5" thick. As with most other Plexus methacrylate systems, MA2045 requires little-to-no surface preparation.

Item #	Size	Mix Ratio by Vol.	Color
IT248	380 ml Co-Axial Cartridge	10:1	Blue
IT246	5 gal Pail Activator	10:1	Blue
IT209	50 gal Drum Adhesive	10:1	Off-White/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 pigmented blue.

Item #	Size	Mix Ratio by Vol.	Color
IT195	5 gal Pail Adhesive	10:1	Off-White/Straw
IT246	5 gal Pail Activator	10:1	Blue
IT221	50 gal Drum Adhesive	10:1	Off-White/Straw

Plexus® MA3940

A two-part methacrylate adhesive designed for applications requiring an adhesive to bond substrates sensitive to chemical crazing such as acrylic or polycarbonate. In addition, this product provides a unique combination of excellent fatigue endurance, outstanding impact resistance, and superior toughness.

Item #	Size	Mix Ratio by Vol.	Color
IT900	380 ml Co-Axial Cartridge	10:1	Off-White/Straw
IT504	5 gal Pail Adhesive	10:1	Off-White/Straw
32400	5 gal Pail Activator	10:1	Off-White/Straw
IT510	5 gal Pail Activator	10:1	Blue
IT503	50 gal Drum Adhesive	10:1	Off-White/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

Structural Adhesives

Product	Description	Color	Mix Ratio By Vol.	Viscosity, cP	Working Time (min)	Fixture Time (min)	Tensile Strength (psi)	Tensile Elongation (%)	Shear Strength (psi)
MA300	All Purpose, High Strength	Off-White/ Straw, Black	1:1	A: 40,000-70,000 B: 40,000-70,000	3-6	12-15	3,000-4,000	5-15	3,000-3,800
Plastic™ Welder	All Purpose, High Strength	Off-White/ Straw	1:1	A: 40,000-70,000 B: 40,000-70,000	3-6	12-15	3,000-4,000	5-15	3,000-3,800
MA310	High Strength Use With "Difficult To Bond" Plastics	Off-White/ Straw	1:1	A: 40,000-70,000 B: 40,000-70,000	15-18	45-55	3,500-4,500	5-15	3,000-3,500
Plastic™ Welder II	High Strength Use With "Difficult To Bond" Plastics	Off-White/ Straw	1:1	A: 40,000-70,000 B: 40,000-70,000	15-18	45-55	3,500-4,500	5-15	3,000-3,500
MA330	Pigmented MA310, Use With "Difficult To Bond" Plastics	Gray	1:1	A: 40,000-70,000 B: 40,000-70,000	15-18	30-45	3,500-4,500	5-15	3,000-3,500
MA530	All Purpose, High Strength, High Toughness, Medium Open Time	Gray	1:1	A: 130,000-180,000 B: 160,000-215,000	30-40	90-160	2,500-3,500	90-160	1,600-2,200
MA560-1	All Purpose, High Strength/High Toughness, Long Open Time	Black, White	1:1	A: 145,000-185,000 B: 170,000-205,000	55-70	220-240	2,500-3,000	>130	1,600-2,200
MA590	All Purpose, High Strength/High Toughness, Long Open Time	Black, White	1:1	A: 175,000-220,000 B: 175,000-220,000	90-105	250-380	2,000-2,500	130-160	1,500-2,200
MA205HV	All Purpose, Fast Cure, Toughened	Blue	10:1	A:100,000-130,000 B: 15,000-50,000	3-5	7-9	2,000-2,500	20-50	1,800-2,500
MA320	Excellent Low Temperature, Toughness Properties	Off-White/ Straw, White, Black	10:1	A: 135,000-175,000 B: 30,000-70,000	8-12	25-30	2,000-2,500	100-140	1,500-2,000
A0/MA420	All Purpose, High Toughness	Off-White/ Straw, Blue, Black	10:1	A: 100,000-125,000 B: 35,000-80,000	4-6	15-18	2,700-3,000	30-50	3,000-3,800
MA420FS	Fast Set For Automated Systems	Off-White/ Straw, Blue, Black	10:1	A: 80,000-100,000 B: 50,000-80,000	1-2	3-4	1,250-1,500	5-15	1,300-1,600
MA422	All Purpose, Medium Open Time	Off-White/ Straw, Blue	10:1	A: 100,000-125,000 B: 35,000-70,000	17-24	35-40	2,700-3,000	75-100	1,600-2,300
MA425	All Purpose, Long Open Time	Off-White/ Straw, Blue	10:1	A: 100,000-125,000 B: 35,000-70,000	30-35	80-90	2,000-2,500	120-140	1,600-2,300
MA550	Excellent Marine Adhesive, White, UV Stable	White	10:1	A: 130,000-160,000 B: 35,000-70,000	40-50	70-75	2,000-2,500	35-45	1,200-1,800
MA830	All Purpose, High Strength/High Toughness, No Primer Metal Bonding	Gray, Gray GB	10:1	A: 80,000-120,000 B: 35,000-80,000	4-6	15-25	2,000-2,500	30-60	2,000-2,800
MA832	All Purpose, High Strength/High Toughness, No Primer Metal Bonding	Gray, Gray GB	10:1	A: 80,000-130,000 B: 35,000-80,000	12-16	55-60	2,700-3,000	30-60	2,000-2,800
MA920	Low Odor, All Purpose, High Toughness	Off-White/ Straw, Blue, Gray	10:1	A: 80,000-120,000 B: 40,000-80,000	4-6	15-18	1,700-2,200	80-100	1,500-2,200
MA1020	Low Shrinkage, Low Odor, All Purpose	Blue	10:1	A: 100,000-130,000 B: 40,000-80,000	4-6	15-20	1,750-2,000	90-110	1,250-1,600
MA1025	Low Shrinkage, Low Odor, Bond Lines Up To 1" Thick	Blue	10:1	A: 180,000-220,000 B: 35,000-70,000	20-25	40-45	1,700-2,300	90-110	1,200-2,000
MA2030	Non Sag, High Gap Fill, Medium Work Time	Blue	10:1	A: 180,000-220,000 B: 35,000-70,000	25-35	70-90	3,000-3,400	90-125	1,600-2,100
MA2045	Low Exotherm, Bond Lines Up To 1.5" Thick	Blue	10:1	A: 180,000-220,000 B: 35,000-70,000	40-50	100-130	3,000-3,400	90-125	1,600-2,000
MA2090	Low Exotherm, Bond Lines Up To 1.5" Thick	Blue	10:1	A: 180,000-220,000 B: 35,000-70,000	80-95	190-230	3,000-3,400	90-120	1,600-2,100
MA3940	Use With Craze Sensitive Plastics	Off-White/ Straw, Blue	10:1	A: 135,000-175,000 B: 35,000-70,000	12-15	25-30	2,000-2,500	125-175	1,200-2,000

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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.



Devcon® 5 Minute® Epoxy

Rapid-curing, general-purpose adhesive/encapsulant.

Item #	Size	Dispenser	Nozzle
14250	25 ml Dev-Tube™	---	---
14270	50 ml Cartridge	14280 (manual)	14285
14210	2.5 oz	---	---
DA051	400 ml Cartridge	30020 (manual)	30095
14200	15 oz	---	---
14630	9 lb	---	---

Devcon® 5 Minute® Epoxy Gel

Thixotropic, nonmigrating gel adhesive with excellent gap filling properties.

Item #	Size	Dispenser	Nozzle
14240	25 ml Dev-Tube™	---	---
14265	50 ml Cartridge	14280 (manual)	14285
DA052	400 ml Cartridge	30020 (manual)	30095

Devcon® One Minute™ Epoxy Gel

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

Item #	Size	Dispenser	Nozzle
14277	50 ml Cartridge	14280 (manual)	14285

Devcon® 10 Minute™ Epoxy

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

Item #	Size	Dispenser	Nozzle
14251	50 ml Cartridge (Clear)	14280 (manual)	14285
14255	50 ml Cartridge (Black)	14280 (manual)	14285

Devcon® 2 Ton® Epoxy

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

Item #	Size	Dispenser	Nozzle
14310	25 ml Dev-Tube™	---	---
14260	50 ml Cartridge	14280 (manual)	14285
14355	400 ml Cartridge	30020 (manual)	30095
14360	9 lb	---	---

Devcon® Epoxy Plus™ 25

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

Item #	Size	Dispenser	Nozzle
14278	50 ml Cartridge	14280 (manual)	14285
14350	400 ml Cartridge	30020 (manual)	30095

Devcon® HP 250

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

Item #	Size	Dispenser	Nozzle
14315	50 ml Cartridge	14280 (manual)	14285
14415	400 ml Cartridge	30020 (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	Dispenser	Nozzle
DA999	400 ml Cartridge	15043 (manual)	15047

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 ¹ (minutes)	3 ~ 6	4 ~ 7	45 sec	10	10	8 ~ 12	25	65	42 @ 75°F
Fixture time ² (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) ³ (psi)	1,900 ⁴	2,500	1,600 ⁴	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 ²)	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: ¹ The maximum allowable time to mate and position parts after mixing and application of the adhesive. After this interval, parts must not be disturbed.
² The time required for the adhesive to generate sufficient bond strength to allow parts to be handled without deformation of the bond line.
³ All tensile strength data per ASTM D1002 on grit-blasted steel, bond line thickness of 0.010".
⁴ 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
ACIDS	○	○	○	○	○	○	◐	◐
Acetic 10%	○	○	○	○	○	◐	◐	◐
Hydrochloric 10%	○	○	○	○	○	◐	◐	◐
Sulfuric 10%	○	○	○	○	○	◐	◐	◐
ALCOHOLS	○	○	○	◐	●	●	●	●
Glycol	○	○	○	○	○	○	◐	●
Isopropanol	○	○	○	○	○	○	◐	●
Methanol	○	○	○	○	○	○	◐	●
KETONES	○	○	○	○	○	○	◐	○
Acetone	○	○	○	○	○	○	◐	○
Methyl ethyl ketone	○	○	○	○	○	○	◐	○
ALKALIS	○	○	○	○	◐	◐	●	●
Ammonium hydroxide 20%	○	○	○	○	◐	◐	●	●
Sodium hydroxide 10%	○	○	○	○	◐	◐	●	●
HYDROCARBONS	●	●	●	○	●	○	○	●
Gasoline (unleaded)	●	●	●	○	●	○	○	●
Mineral spirits	●	●	●	○	●	○	○	●
Motor oil	●	●	●	○	●	○	○	●
SALTS	○	○	◐	◐	◐	◐	◐	●
Sodium chloride	○	○	◐	◐	◐	◐	◐	●
Trisodium phosphate	○	○	◐	◐	◐	◐	◐	●

Key: ● Excellent ◐ Very Good ○ Fair ○ Poor

SEALANTS

Plexus® 5227

A 100% solids, asbestos-free butyl tape sealant that is a highly rubbery, tacky, reinforced compound designed for sealing joints in the commercial vehicles industry. It is easy to apply and compress during installation. It exhibits excellent application and performance characteristics over a wide temperature range and will not become brittle, crack or flow during service. It is available in various sizes supplied in ready-to-use.

Item #	Size
SM5227-2431	3/4x1/8x30 Roll Tacky Tape

Plexus® 5522

A solvent release acrylic sealant compound. It exhibits good adhesion to many surfaces and remains ductile in the presence of ultraviolet and infrared radiation. SM5522 is a multi-purpose sealant designed for a variety of exterior sealing applications. After cure, it can be painted.

Item #	Size	Color
SM5522-D-G	55 gal Drum	Gray



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	Color
17100	3 oz Tube, Boxed	Clear
17150	10.3 oz Cartridge	Clear
17140	10.3 oz Cartridge	White
17130	10.3 oz Cartridge	Red



Plexus® Sealants

Product	Description	Color	Mix Ratio	Sag (in)	Tack Free Time	Cure Time (days)	Tensile Strength (psi)	Tensile Elongation (%)	Peel Adhesion
5227	Butyl Tape - Permanently Flexible	Gray	Single Component	None	N/A	Instant	20	>500	16-17 piw
5522	Acrylic Sealant, Caulking Grade, Fast Skin Time, Paintable	Clear, Gray, White	Single Component	0.1 Max	30 Min	21	35	>1,000	15 pli

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	Dispenser	Nozzle
14503	50 ml Cartridge	14280 (manual)	14285
14500	400 ml Cartridge	30020 (manual)	30095

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 ¹ (hours)	4
Tensile Elongation (%)	200
Cured hardness (ASTM D2240) (Shore D)	63
Adhesion Tensile Lap Shear (ASTM D1002) (psi)	2,750

NOTES: ¹ Faster cure times can be achieved by heating.

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

Key: ● Excellent ◐ Very Good ○ Fair ○ Poor



CORING/BULK PRINT BLOCKER

SC 2000-0S LS

A sprayable syntactic coring material 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. MEKP catalyst is not included.

Item #	Description
103994	2000 OS-LS Drum Unlined
103927	2000-OS Drum Lined
103998	2000 OS-LS Drum Lined
103827	2000-OS Drum Unlined

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
103202	SHLD-2045 LS Drum Lined
103211	SHLD-2045 LS Drum Unlined
103412	MR-100 Blowing Agnt

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
103979	4000 HDT Drum Unlined

SC 6000

A unique micro balloon filled syntactic resin 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
103108	PDR 6000-SLOW Drum Lined
103201	CORE-6000 Drum Lined

SC 7315

A unique micro balloon filled syntactic resin 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
103206	CORE-7315 Drum Lined
103216	CORE-7315 Drum Unlined
103412	MR-100 Blowing Agnt

BARRIER COAT

SC 1500 LS

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

Item #	Description
103993	1500 LS Drum Unlined

SC 1800 LS

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

Item #	Description
103975	1800-LS Black Drum Unlined
103995	1800-LS Light Gray Drum Unlined



RADIUS COMPOUND PLUG BUILDING

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
103350	900 Drum Unlined

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
103212	1050-LS Gray Drum Unlined

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
103305	1060 5 gal Pail

ADHESIVE PUTTIES

SC PDR 6000

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

Item #	Description
103108	PDR 6000 Slow Drum Lined
103201	6000 Drum Lined

SC PDR 9000

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

Item #	Description
103100	PDR 9000 Ultra Fast Drum Lined
103104	PDR 9000 Slow Drum Lined
103109	PDR 9000 Fast 5 gal Pail
103121	PDR 9000 Slow 5 gal Pail
103130	PDR 9000 Slow Drum Unlined

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
100009	ALPHA FILL 5 gal Pail

SC 2000-HS

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

Item #	Description
103837	2000-HS Drum Unlined

SC 4500

AQ CNC machined syntactic vinylester blend used for plug building. Catalyst is not included.

Item #	Description
103840	4500 Drum Unlined

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
103409	VELR-4000 VE Resin Drum Unlined
103979	4000 HDT Drum Unlined

SC 2000-OS LS

A sprayable syntactic coring material 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. MEKP catalyst is not included.

Item #	Description
103994	2000-OS-LS Drum Unlined
103927	2000-OS Drum Lined
103998	2000-OS-LS Drum Lined
103827	2000-OS Drum Unlined

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
103404	VE-TOL - 4055 Drum Molding Shld Lined

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
103846	4600 HTT Drum Unlined PIS



SPRAYABLE FILLER

SC ALPHACOAT 1700

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
100065	ALPHACOAT® 1700 Drum Unlined
100066	ALPHACOAT® 1710 Drum Unlined

SPECIALTY PRODUCTS

SC 2000-CM

A sprayable syntactic polyester 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
103981	2000 CM Drum Unlined

Product	Description	Mix Ratio (%)	Preferred Red-Dye Catalyst	Styrene (%)	Approx. Gel Time (min)	Approx. Gel to Peak Range (min)	Density Range (lbs/gal)	Viscosity (lbs/gal)	Peak Exotherm (°)
BARRIER COAT									
SC 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°F
SC 1800-LS	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°F
CORING/BULK PRINT BLOCKER									
SC 2045*	Ceramic compounded resin with a very fast gel and cure cycles; Adjustable high and low densities	1.50 MEKP 2.00 MEKP/ 1.50 MR-100	HP-90 HP-90	30	4-8 0.5-1.5	5-8 4-8	10.00-10.50 (~8.70- 9.14)	3,000-5,000 (RVF #4 @ 20rpm)	250-325°F 325-375°F
SC 2000-0S 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 DHD-90 MEKP 900	27	2.5-3.5	6-9	5.60-6.00	13,000-15,000 (HB #4 @ 20rpm)	285-345°F
SC 6000	Economical solution for a variety of applications	1.50 MEKP	HP-90 DHD-9 MEKP 900	31	5-10	15-25	5.80-6.30	13,000-15,000 (RVF #5 @ 20rpm)	200-250°F
SC 7315*	Unique micro balloon ceramic resin with adjustable low and high densities	1.50 MEKP 2.00 MEKP/ 1.50 MR-100	HP-90 HP-90	32	4-8 0.5-1.5	6-10 4-8	5.80-6.30 (~4.29-4.67)	10,000-14,000 (RVF #5 @ 20rpm)	300-350°F
RADIUS COMPOUND									
SC 900	Longer gel time allows good working time with rollers	1.50 MEKP	HP-90 DHD-9 MEKP 900	25	17-22	17-22	10.80-11.30	20,000-25,000 (RVF #6 @ 20rpm)	250-300°F
SC 1050	Can be sprayed and chopped while wet	1.50 MEKP	HP-90 DHD-9 MEKP 900	27	25-35	10-17	10.80-11.30	15,000-20,000 (RVF #6 @ 20rpm)	250-300°F
SC 1060	Can be brushed and chopped while wet	1.50 MEKP	HP-90 DHD-9 MEKP 900	30	20-30	10-17	10.80-11.30	25,000-35,000 (RVF #6 @ 20rpm)	250-300°F
ADHESIVE PUTTIES									
PDR 6000	Formulated for slow gel time	1.50 MEKP	DDM-9 MEKP-9 DDM-30	25	75-105	15-30	8.70-9.50	600,000-700,000 (RVF T-E @ 5rpm)	200-250°F
PDR 9000	Formulated for 3 different gel times	1.50 MEKP	DDM-9 MEKP-9 DDM-30	20	10-20 40-50 80-105	5-15 10-25 25-50	8.70-9.50	750,000-850,000 (RVF T-E @ 5rpm)	180-250°F 180-225°F 150-225°F
AlphaFill Lightweight	Excellent adhesion and featheredge	2.00 MEKP	BPO	15-20	3-5	N/A	9.70	102,000-120,000 (SSA W/T-E Bar @ 5rpm)	N/A
PLUG BUILDING									
SC 2000-HS	Developed for easy routing with CNC equipment	1.75-2.25 MEKP	HP-90 DHD-9 MEKP 900	33	2.5-3.5	7-9	4.80-5.20	16,000-18,000 (HB #4 @ 20rpm)	290-325°F
SC 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°F
MOLD BUILDING									
SC 4000 HDT	Coring material w/ high heat tolerance when used with MR-100 Blowing Agent****	1.50-2.20 MEKP	HP-9 DHD-9 MEKP 925	29	3-4	5-8	5.25-5.75	12,000-14,000 (HB #4 @ 20rpm)	300-350°F
4055***	Can be applied at 20-30 mils directly onto the gelcoat	1.50 MEKP 2.00 MEKP 1.50 MR-100	HP-9 DHD-9 MEKP 925	26	7-13 .5-1.5	7-13 5-10	9.70-10.70	8,000-11,000 (RVF #5 @ 20rpm)	270-305°F 325-375°F
SC VELR 4000	Rapidly wets out and cures uniformly with a low exotherm	1.50 MEKP	HP-9 DHD-9 MEKP 925	32	15-25	4-10	8.80-9.20	450-650 (RVF #2 @ 20rpm)	325-375°F
SPRAYABLE FILLER									
AlphaCoat 1700	Extremely fast cure time and high built	2.00 MEKP	MEKP 9H DDM-9	20	3-6	60-90	9.20-9.70	1,200-1,400 (LVT #3 @ 30rpm)	N/A
SPECIALTY PRODUCTS									
SC 2000-CM	Developed specifically for compression molding. Makes parts stronger, lighter. Improves impact resistance and reduces manufacturing cost. Has consistent and void free application with reliable thickness control. Makes a product stiffer without adding more fiberglass laminates. Greatly reduces the transfer of the fiberglass pattern of the laminates behind the shield onto the gel coat surface.	1.75-2.25 MEKP	DHD-9 DDM-9 MEKP 900 HP-90	28	20-30	20-30	4.80-5.20	18,000-22,000 (HB #4 @ 20rpm)	>220°F

*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.

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:
1-855-489-7262

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 #	Size
11330	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 #	Size
11350	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 #	Size
11320	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 #	Size
11340	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 #	Size
11301	5 gal Mixer

DFENSE BLOK™



Watch our
Impact Test!



Physical Properties	Devcon® DFense Blok™ With Surface Wetting Agent	Devcon® DFense Blok™ Fast Cure (FC)	Devcon® DFense Blok™ Quick Patch	Devcon® DFense Blok™ 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	13.8	14.89	24.7
Coverage per pound (inches² @ 14" 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 10⁶	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

NOTES: ¹ Coverage in inches² / 20.4 pound unit, ² Three-part system, beads separate

Chemical Resistance	Devcon® DFense Blok™ With Surface Wetting Agent	Devcon® DFense Blok™ Fast Cure (FC)	Devcon® DFense Blok™ Quick Patch	Devcon® DFense Blok™ Surface Wetting Agent
ACIDS				
Acetic 10%	○	○	○	○
Hydrochloric 10%	●	●	●	●
Sulfuric 10%	●	●	●	●
ALCOHOLS				
Methanol	○	○	○	○
Isopropanol	○	○	○	○
KETONES				
Acetone	○	○	○	○
Methyl ethyl ketone	○	○	○	○
ALKALIS				
Ammonium hydroxide 20%	●	●	●	●
Sodium hydroxide 10%	●	●	●	●
HYDROCARBONS				
Gasoline (unleaded)	○	○	●	○
Mineral spirits	●	●	●	●
CHLORINATED HYDROCARBONS				
1-1-1 Trichloroethane	●	●	●	●
SALTS				
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 #	Size
11470	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 #	Size
11490	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 #	Size
11480	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 #	Size
11495	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 #	Size
11489	20 lb



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

NOTES: ² Three-part system, beads separate

Chemical Resistance	Devcon® Wear Guard™ Fine Load	Devcon® Wear Guard™ High Load	Devcon® Wear Guard™ High Temp	Devcon® Tile Adhesive	Devcon® HV Tile Adhesive
ACIDS	⊗	⊗	⊗	⊗	⊗
Acetic 10%	◐	◐	●	◐	◐
Hydrochloric 10%	◐	◐	●	◐	◐
Sulfuric 10%	◐	◐	●	◐	◐
ALCOHOLS	⊗	⊗	⊗	⊗	⊗
Methanol	⊗	⊗	⊗	○	○
Isopropanol	⊗	⊗	⊗	○	○
KETONES	⊗	⊗	⊗	⊗	⊗
Acetone	⊗	⊗	⊗	◐	◐
Methyl ethyl ketone	⊗	⊗	⊗	◐	◐
ALKALIS	●	●	●	●	●
Ammonium hydroxide 20%	●	●	●	●	●
Sodium hydroxide 10%	●	●	●	●	●
HYDROCARBONS	●	●	●	◐	◐
Gasoline (unleaded)	●	●	●	●	●
Mineral spirits	●	●	●	●	●
CHLORINATED HYDROCARBONS	◐	◐	●	◐	◐
1-1-1 Trichloroethane	◐	◐	●	◐	◐
SALTS	◐	◐	●	◐	◐
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 and gouges in SBR heavy weight conveyor belts. The kit includes: resin, curing agent, surface conditioner, 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®

NEW! 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 #	Size
15550	4 lb
15565	1.5 lb



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
15820	1 lb
15850	4 lb

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
15350	1 lb



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
15330	1 lb

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
15049	400 ml Cartridge

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
15800	1 lb
15810	10 lb

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
15050	400 ml Cartridge

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
15250	1 lb
15260	10 lb

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
15940	8 oz

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
19600	1 pt

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. FL-40 Primer for rubber. Ensures ultimate peel strength (greater than 80 psi).

Item #	Primer	Size
15980	FL-10	4 oz
15985	FL-20	4 oz
15984	FL-40	4 oz

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 ³ /pound)	27.4	23.5	26.0	23.5	23.5	26.5	26.5	26.5
Coverage per pound (inches ² @ 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 ²	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 ¹ (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

NOTES: ¹ Taber H-18 wheel (mg/1,000 revolutions @ 1,000 gram load) ² 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
ACIDS								
Acetic 10%	○	●	○	○	○	○	○	○
Hydrochloric 10%	○	●	○	○	○	○	○	○
Sulfuric 10%	○	●	○	○	○	○	○	○
Sulfuric 50%	○	●	○	○	○	○	○	○
Phosphoric 10%	○	●	○	○	○	○	○	○
ALCOHOLS								
Methanol	○	○	○	○	○	○	○	○
Isopropanol	○	○	○	○	○	○	○	○
KETONES								
Acetone	○	○	○	○	○	○	○	○
Methyl ethyl ketone	○	○	○	○	○	○	○	○
ALKALIS								
Ammonium hydroxide 20%	●	●	●	●	●	●	●	●
Sodium hydroxide 10%	●	●	●	●	●	●	●	●
HYDROCARBONS								
Gasoline (unleaded)	○	○	○	○	○	○	○	○
Mineral spirits	○	○	○	○	○	○	○	○
SALTS								
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
10760	1 lb
10770	2 lb



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
11760	2 lb (Red)
11762	12 lb (Red)
11765	2 lb (Blue)
11767	12 lb (Blue)
11770	2 lb (White)



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
11700	3 lb



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
11730	32 lb

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 ³ /pound)	11.7	17.5	16.5	16.4	17.9
Coverage per pound (inches ² @ 1/4" thickness)	47	7.6 ¹	7.6 ¹	66	72
Cured hardness (ASTM D2240) (Shore D)	87	90	87	90	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	15,200	15,200	12,700	10,240
Flexural strength (ASTM D790) (psi)	7,700	3,800	3,800	6,475	5,870
Modulus of elasticity (ASTM D638) (psi x 10 ⁵)	9.5	8,000	8,000	9.0	8.1
Coefficient of thermal expansion (ASTM D696) [(in)/(in x °F)] x 10 ⁻⁶	22	9.0	9.0	17	20
Thermal conductivity (ASTM C177) [(cal x cm)/(sec x cm ² x °C)] x 10 ⁻³	1.95	19	19	1.88	1.72
Dielectric constant (ASTM D150) (1 kHz)	44.8	1.92	1.92	41.0	38.0
Dielectric strength (ASTM D149) (volts/mil)	56	382	382	370	350
Maximum continuous dry service temperature (°F)	350	350	350	350	350

NOTES: ¹ Coverage (feet² @ 15 mils)

Chemical Resistance	Devcon® Titanium Putty	Devcon® Brushable Ceramic Red, Blue	Devcon® Brushable Ceramic White	Devcon® Ceramic Repair Putty	Devcon® Ceramic Repair Compound
ACIDS					
Acetic 10%	●	●	●	●	●
Hydrochloric 10%	●	●	●	●	●
Sulfuric 10%	◐	◐	◐	◐	◐
ALCOHOLS					
Methanol	●	●	●	●	●
Isopropanol	●	●	●	●	●
KETONES					
Acetone	◐	◐	◐	◐	◐
Methyl ethyl ketone	◐	◐	◐	◐	◐
ALKALIS					
Ammonium hydroxide 20%	●	●	●	●	●
Sodium hydroxide 10%	●	●	●	●	●
HYDROCARBONS					
Gasoline (unleaded)	●	◐	◐	●	●
Mineral spirits	●	●	●	●	●
CHLORINATED HYDROCARBONS					
1-1-1 Trichloroethane	●	●	●	●	●
SALTS					
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
10110	1 lb
10120	4 lb
10130	25 lb



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
10210	1 lb
10220	4 lb
10230	25 lb



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
10240	1 lb



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
10270	1 lb



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	v
10610	1 lb	
10620	3 lb	



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
10710	1 lb
10720	3 lb



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
11800	1 lb



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 ³ /pound)	11.9	13.1	12.2	12.4	17.5	17.5	17.0
Coverage per pound (inches ² @ 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 ⁵)	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 ⁻⁶	48	38	34	34	29	50	18
Thermal conductivity (ASTM C177) [(cal x cm)/(sec x cm ² x °C)] x 10 ⁻³	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

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)
ACIDS							
Acetic 10%	⊗	⊗	⊗	⊗	⊗	⊗	⊗
Hydrochloric 10%	◐	◐	◐	◐	◐	◐	◐
Sulfuric 10%	◐	◐	◐	◐	◐	◐	◐
ALCOHOLS							
Methanol	⊗	⊗	⊗	⊗	⊗	⊗	⊗
Isopropanol	⊗	⊗	⊗	⊗	⊗	⊗	⊗
KETONES							
Acetone	⊗	⊗	⊗	⊗	⊗	⊗	⊗
Methyl ethyl ketone	⊗	⊗	⊗	⊗	⊗	⊗	⊗
ALKALIS							
Ammonium hydroxide 20%	◐	◐	◐	◐	◐	◐	◐
Sodium hydroxide 10%	◐	◐	◐	◐	◐	◐	◐
HYDROCARBONS							
Gasoline (unleaded)	◐	◐	◐	◐	◐	◐	◐
Mineral spirits	◐	◐	◐	◐	◐	◐	◐
CHLORINATED HYDROCARBONS							
1-1-1 Trichloroethane	◐	◐	◐	◐	◐	◐	◐
SALTS							
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
10260	1 lb

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
11410	1 lb
11420	3 lb

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
10780	.75 lb

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
19770	1 lb

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
11500	4" x 9" Patch



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
19600	1 pt

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
19510	1 pt

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

Chemical Resistance	Devcon® Bronze Putty (BR)	Devcon® Wear Resistant Putty (WR-2)	Devcon® FasMetal™	Devcon® HVAC Repair (Special F)	Devcon® Zip Patch™
ACIDS					
Acetic 10%	●	●	●	●	●
Hydrochloric 10%	●	●	●	●	●
Sulfuric 10%	●	●	●	●	●
ALCOHOLS					
Methanol	○	○	○	○	○
Isopropanol	○	○	○	○	○
KETONES					
Acetone	○	○	○	○	○
Methyl ethyl ketone	○	○	○	○	○
ALKALIS					
Ammonium hydroxide 20%	●	●	●	○	○
Sodium hydroxide 10%	●	●	●	○	○
HYDROCARBONS					
Gasoline (unleaded)	●	●	●	●	●
Mineral spirits	●	●	●	●	○
CHLORINATED HYDROCARBONS					
1-1-1 Trichloroethane	●	●	○	○	○
SALTS					
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
13100	10 lb
13120	40 lb



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
13110	10 lb



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
13130	41 lb

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
13800	50 lb

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
13550	35 lb

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
13090	2 gal

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
12710	2 gal



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
12750	2 gal

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
12560	2 gal



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 ² @ thickness)	18 @ 0.25" / 40 lb unit	4.5 @ 0.25" / 10 lb unit	13 @ 0.25" / 35 lb unit	568 inches ³ / 41 lb unit	640 inches ³ / 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
ACIDS	○	○	○	○	○	○	○	○
Acetic 10%	●	●	●	○	●	●	●	●
Hydrochloric 10%	●	●	●	○	●	●	●	●
Sulfuric 10%	●	●	●	○	●	●	●	●
ALCOHOLS	○	○	●	○	○	○	○	○
Methanol	○	○	○	○	○	○	○	○
Isopropanol	○	○	○	○	○	○	○	○
KETONES	○	○	○	○	○	○	○	○
Acetone	○	○	○	○	○	○	○	○
Methyl ethyl ketone	○	○	○	○	○	○	○	○
ALKALIS	●	●	●	●	●	●	●	●
Ammonium hydroxide 20%	●	●	●	●	●	●	●	●
Sodium hydroxide 10%	●	●	●	●	●	●	●	●
HYDROCARBONS	●	●	●	○	●	●	●	●
Gasoline (unleaded)	●	●	●	○	●	●	●	●
Mineral spirits	●	●	●	●	●	●	●	●
CHLORINATED HYDROCARBONS	●	●	●	●	●	●	●	●
1-1-1 Trichloroethane	●	●	●	●	●	●	●	●
SALTS	●	●	●	○	●	●	●	●
Sodium chloride	●	●	●	○	●	●	●	●
Trisodium phosphate	●	●	●	○	●	●	●	●

Key: ● Excellent ○ Very Good ○ Fair ○ Poor

DISPENSING EQUIPMENT

GUNS

Item # Description

- 14280 Mark V™ Gun Manual Dispensing Gun**
50/35 ml 1:1, 2:1, and 10:1 Ratio Applicator
- 30045 Manual Cartridge Dispensing Gun**
380 ml 10:1 Ratio Applicator
- 15043 Manual Cartridge Dispensing Gun**
400 ml 4:1 Ratio Applicator
- 30020 Manual Cartridge Dispensing Gun**
400 ml 1:1 Ratio Applicator
- 14405 Manual Cartridge Dispensing Gun**
490 ml 1:1 Ratio Applicator
- 30010 Pneumatic Cartridge Dispensing Gun**
400 ml 1:1 Ratio Applicator
- 30011 Pneumatic Cartridge Dispensing Gun**
380 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**
380 ml 10:1 Mix Nozzle
- 15047 Mix Nozzle**
4:1 Mix Nozzle
- 30095 Static Mix Nozzle**
400 ml 1:1 Mix Nozzle
- 30076 Static Mix Nozzle**
490 ml 10:1 Mix Nozzle



Approved Equipment Manufacturers

For more information, please contact:

GS Manufacturing
985 W. 18th Street
Costa Mesa, CA 92627
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www.mvpind.com

AGENCY APPROVALS AND REFERENCES

Devcon® Mil-Spec, UL and Other Government Specifications

Product Category	Specification	Product	Part #	Size
Devcon® Silicone Adhesive Sealants	A-46106A	Silite® Silicone RTV-Clear	17100	3 oz Cartridge
			17150	10.3 oz Cartridge
		Silite® 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
	MMM-A-1754	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	Silite® Silicone RTV-Clear	17100	3 oz Tube
			17150	10.3 oz Tube
		Silite® Silicone RTV-White	17140	10.3 oz Tube
			17130	10.3 oz Tube
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 ¹
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: ¹ Viscosities shown are measured at room temperature (70°F) and are approximate. Values will increase at lower temperatures and decrease at warmer temperatures.

Bead Length² (inches)

Bead Diameter	50 ml	300 ml	380 ml	400 ml	1 lb	1 gal ³
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: ² For methacrylates, epoxies, and silicones. ³ 1 gallon = 3,791.76 ml (128.1 oz.)



tool. incorporated



**Plexus® branded
products are
GREENGUARD certified**



SDS/TDS: Access SDSs and TDSs from our website: www.itwadhesives.com. Select the product brand to search.

Note: This product catalog represents the core line of products at ITW Polymers Adhesives, North America. Others are available that may suit your needs. Please consult an ITW Polymers Adhesives, North America Sales or Technical Service Representative for further assistance at 1-855-489-7262.

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Visit www.itwadhesives.com for our terms of sale, detailed warranties and exclusions, questions on agency approvals, certifications and SDS/TDS.

ITW Polymers

ITW Polymers, one of eight large business segments forming Illinois Tool Works, Inc. (ITW), a Fortune 150 Company.

ITW Polymers is a worldwide manufacturer of adhesives, sealants, coatings, lubrication and cutting fluids for industrial, construction and consumer purposes; chemical fluids which clean or add lubrication to machines; epoxy and resin-based coating products for industrial applications, and hand wipes and cleaners for industrial applications.

Below is a map of the individual divisions comprising the global Polymers group.



Global Operations

ITW Polymers Adhesives has global locations and is represented by a global distribution network in North America, Latin America, Europe, Australia, Asia and The Far East.

ITW Polymers Adhesives – North America

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www.itwsealants.com

ITW Engineered Polymers – North America

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ITW Chemin – Polymers India

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