1 Minute® Epoxy

ORDERING INFORMATION

Stock No. Package Size 14277 50ml Cartridge

Description

A super-fast general purpose thixotropic epoxy adhesive for applications requiring fast fixing. This quick curing formula is excellent for bonding metals, fiberglass, and ceramics.

Translucent

Features

- · Non-sagging on vertical and overhead surfaces
- 100% reactive, no solvents
- Part fixturing in less than 1 minute

Recommended applications

- Ideal for repairing or assembling furniture, jewellery, china, appliances and model
- Fast cure metal-to-metal bonding and repairs
- Suitable for bonding metals, glass, fibreglass, fabrics and ceramics

PRODUCT DATA

Physical

Properties (Uncured)	Mixed Viscosity, cps Mixed Ratio by Volume Working time 28 grams @ 24°C Functional cure @ 28 grams 24°C Coverage (in² @ 0.01" thickness) Specific Volume % solids by volume	Thixotropic 1:1 30 seconds 4 minutes 216 853 cm ³ /Kg 100
Performance characteristics	7 days cured at 24°C Adhesive tensile shear, (steel) ASTM D1002 Operating temperature, dry Cured density, ASTM D792 Cured hardness, ASTM D2240 Dielectric strength, ASTM D2566	11 N/mm ² -40-93°C 1.08 gm/cm ³ 82D 490 volts/mil

Chemical Resistance

Deutschland/Germany

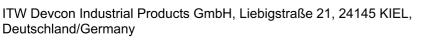
t days room temperature cure (30 days immersion)				
Kerosene	Very good	Methanol	Fair	
Hydrochloric acid	Very good	Toluene	Very good	
Chlorinated solvent	Fair	Ammonia	Very good	
10% Sulphuric acid	Very good	10% Sodium hydroxide	Very good	

Please consult ITW Devcon for other chemicals

Colour

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

Unit 3, Shipton Way, Express Business Park, Northampton Road, Rushden, NN10 6GL, UK





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General Surface Preparation 1 Minute Epoxy works best on clean surfaces. If surface is oily or greasy, use Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 to degrease the surface. Surfaces should be free of heavy deposits of grease, oil, dirt or other contaminants, or cleaned with industrial cleaning equipment such as vapour phase degreasers or hot aqueous baths. Abrading or roughing the surfaces of metals will increase the microscopic bond area significantly and optimize the bond strength.

Mixing

This product is available in cartridge form only.

The cartridge should be used with a Manual Applicator Gun and a Static Mixer Nozzle. The Static Mixer Nozzle enables the epoxy to be dispensed, metered and directly applied to the surfaces to be bonded.

Please note: Once the product cures in the nozzle it has to be thrown away and a new nozzle used.

Application

Apply mixed epoxy directly to one surface in an even film or as a bead. Assemble with the mating part within the recommended working time. Obtain firm contact between the parts to minimize any gap and ensure good contact of the epoxy with the mating part. A small fillet of epoxy should flow out the edges to show there is adequate gap filling. For very large gaps, apply epoxy to both surfaces and spread to cover the entire area, or make a bead pattern, which will allow flow throughout the joint.

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

Cure

Full bond strength is reached in 1 hour.

Storage Shelf Life Devcon Epoxy Adhesives should be stored in a cool, dry place when not used for a long period of time. A shelf life of 1 year from date of manufacture can be expected when stored at room temperature (22°C) in their original containers.

Precaution

For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.

Warranty

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

Disclaimer

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

For product information visit www.devconeurope.com alternatively for technical assistance please call +44 (0) 870 458 7388 (UK) or +49 431 718830 (Germany)

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