

1 Minute® Epoxy

ORDERING INFORMATION

<u>Stock No.</u> 14277	<u>Package Size</u> 50ml Cartridge
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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.
Features	<ul style="list-style-type: none"> • Non-sagging on vertical and overhead surfaces • 100% reactive, no solvents • Part fixturing in less than 1 minute
Recommended applications	<ul style="list-style-type: none"> • 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)	Colour	Translucent		
	Mixed Viscosity, cps	Thixotropic		
	Mixed Ratio by Volume	1:1		
	Working time 28 grams @ 24°C	30 seconds		
	Functional cure @ 28 grams 24°C	4 minutes		
	Coverage (in ² @ 0.01" thickness)	216		
	Specific Volume	853 cm ³ /Kg		
	% solids by volume	100		
Performance characteristics	7 days cured at 24°C			
	Adhesive tensile shear, (steel) ASTM D1002	11 N/mm ²		
	Operating temperature, dry	-40-93°C		
	Cured density, ASTM D792	1.08 gm/cm ³		
	Cured hardness, ASTM D2240	82D		
	Dielectric strength, ASTM D2566	490 volts/mil		
Chemical Resistance	7 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

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.

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APPLICATION INFORMATION

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)