



Plastic Welder™ II

Description: A 100% reactive, toughened structural acrylic adhesive formulated for bonding difficult-to-bond substrates such as nylon-based alloys, epoxy composites, and modified polyesters.

Intended Use: Bond: PVC, fiberglass, ABS, FRT, PBT, PPO, PCBB, Metton®, Lomod®, Valox®, Noryl®, GTX, Minlon®, epoxy, RIM urethane, galvanized metal, wood, poorly prepared surfaces, and where outdoor weathering or solvent exposure is anticipated.

Product features:
Room temperature cure
Bonds dissimilar substrates
Excellent environmental resistance
Minimal surface preparation
Non-sagging formula
Excellent chemical resistance
Excellent impact, peel, and shear resistance

Limitations:

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

Cured 7 days @ 75° F

T-peel	15-20 pli
Impact Resistance	17 ft.lb./in.[2]
Tensile Elongation	5-15%
Shore Hardness	75 Shore D
Gap-Fill	0.125 in.
% Solids by Volume	100
Adhesive Tensile Lap Shear(ABS)	1,300 psi
Adhesive Tensile Lap Shear(Nylon 6.6)	1,420 psi
Adhesive Tensile Lap Shear{GBS}	3,000 psi
Specific Volume	27.73 in[3]/lb.

TESTS CONDUCTED

T-Peel Strength ASTM D 1876
Adhesive Tensile Shear ASTM D 1002
Impact Resistance ASTM D 950
Cured Hardness Shore D ASTM D 2240

Uncured

Color	Straw/Black/White
Viscosity	Adhesive: 70,400 cps; Activator: 45,000 cps
Weight	Adhesive: 8.56 lbs./gal.; Activator:8.10 lbs./gal.
Mixed Viscosity	56,000 cps
Mix Ratio by Volume	1:1
Mix Ratio by Weight	1:1
Mixed Density	8.33 lbs./gal.
Flashpoint	51°F
Working Time	15-20 min. @ 72°F, 22°C
Fixture Time	30-35 min. @ 72°F, 22°C
Functional Cure	2-4 hrs.
Full Cure	24 hrs.
Service Temperature	-67°F to 250°F

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

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

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

35ML/50 ML/250 ML/380 ML/400 ML CARTRIDGES

1. Attach cartridge to Mark V™ [50ml], 380ml, 250ml [15:1 caulk gun], or 400ml dispensing systems [manual or pneumatic].
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to substrate.

Application Instructions:

1. Apply mixed product directly to one surface in an even film or as a bead.
2. Assemble with mating part within recommended working time.
3. Apply firm pressure between mating parts to minimize any gap and ensure good contact (a small fillet of product should flow out the edges to display adequate gap fill.)
4. Bond line thickness of mixed adhesive should be @ .015"-.030" for optimum adhesion.

For very large gaps:

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

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

ADDITIONAL PRODUCT INFORMATION:

- Can withstand processing forces
- Do not drop, shock load, or heavily load
- Intermittent exposure to temperatures above 250°F do not reduce performance characteristics

STAINLESS STEEL AND ALUMINUM APPLICATIONS:

Apply Devcon Metal Prep 90 to prime and condition aluminum and stainless steel surfaces prior to using Plastic Welder II. Metal Prep 90 is fast drying at ambient temperatures. Plastic Welder II can be applied within minutes of its use. Overlap shear strength will improve 30-40% if Metal Prep 90 is used.

Storage:

Store between 55°F and 75°F. Continuous storage above 75°F reduces the shelf life of the materials. Prolonged exposure above 100°F quickly diminishes the product's reactivity, and should be avoided. Shelf life can be extended by refrigeration between 45°F and 55°F. **DO NOT FREEZE.**

Compliances:

None

Chemical Resistance:

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

Acetic (Dilute) 10%	Very good
Ammonia	Fair
Cutting Oil	Excellent
Glycols/Antifreeze	Excellent
Hydrochloric 10%	Very good
Motor Oil	Excellent
Sodium Hydroxide 10%	Excellent
Sulfuric 10%	Very good

Precautions:

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

For technical assistance, please call 1-800-933-8266

FOR INDUSTRIAL USE ONLY

Warranty:

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

Disclaimer:

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

Order Information:

14340 47 ml Dev-Pak
14335 25 ml DevTube
14390 400 ml cartridge