



Plastic Welder™

Description: Toughened structural adhesive, after curing, produces superior strength to load-bearing bonds to engineered plastics.

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:
 Minimal surface preparation
 Room temperature cure
 1:1 mix ratio
 Rapid fixture in thin set
 Non-sagging formula

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 | 35-40 pli |
| Impact Resistance | 22 ft.lb./in.[2] |
| Tensile Elongation | 15-25% |
| Shore Hardness | 78 Shore D |
| Gap-Fill | 0.125 in. |
| % Solids by Volume | 100 |
| Adhesive Tensile Lap Shear[ABS] | 1,300 psi |
| Adhesive Tensile Lap Shear[GBS] | 3,500 psi |
| Adhesive Tensile Lap Shear[Polycarb] | 1,400 psi |
| Specific Volume | 28.1 in[3]/lb. |

TESTS CONDUCTED

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

Uncured

| | |
|---------------------|--|
| Color | Straw |
| Viscosity | Adhesive: 55,000 cps; Activator: 50,000 cps |
| Weight | Adhesive: 8.4 lbs./gal.; Activator: 8.00 lbs./gal. |
| Mixed Viscosity | 50,000 cps |
| Mix Ratio by Volume | 1:1 |
| Mix Ratio by Weight | 1:1 |
| Mixed Density | 8.20lbs./gal. / .98gm/cc |
| Flashpoint | 51°F |
| Working Time | 4-6 min. @ 72°F, |
| Fixture Time | 10-15 min. @ 72°F, 22°C |
| Functional Cure | 3/4 - 1 hr. |
| 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 [1.5:1 caulk gun], or 400ml dispensing systems [manual or pneumatic].
 2. Open tip.



Application Instructions:

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.

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. Metal Prep 90 is fast drying at ambient temperatures. Plastic Welder 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:

Meets UL 746C Polymeric Adhesive Systems, Electrical Equipment-Component

Chemical Resistance:

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

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

- 14320 47 ml Dev-Pak
- 14385 400 ml cartridge
- 14300 25 ml DevTube
- 14330 2 liter kit