

Devcon Plastic Welder™ II

Epoxy; Epoxide

Devcon

Message:

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, PPO, PCBB, Metton®, Lomod®, Valox®, Noryl®, GTX, Minlon®, Nylon, epoxy, RIM urethane, wood, poorly prepared surfaces, and where outdoor weathering or solvent exposure is anticipated.

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

General Information			
Features	Solvent resistance		
	Impact resistance, good		
	Adhesiveness		
	Good chemical resistance		
	Good weather resistance		
Uses	Bonding		
	Adhesive		
Physical	Nominal Value	Unit	Test Method
Specific Volume	1.00	cm ³ /g	
Solid content-by Volume	100	%	
Impact Resistance	35.7	kJ/m ²	
Service Temperature	-55 - 121	°C	
Work Time (22°C)	15.0 - 20.0	min	
Tensile Shear Adhesion			ASTM D1002
ABS	8.96	MPa	ASTM D1002
GBS	20.7	MPa	ASTM D1002
Density ¹	0.998	g/cm ³	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	75		ASTM D2240
Mechanical	Nominal Value	Unit	
Tensile Elongation (Break)	5.0 - 15	%	
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			

Mixing ratio by weight: 1.0

Component a

Mixing ratio by capacity: 1.0

Mixing ratio by weight: 1.0

Component B

Mixing ratio by capacity: 1.0

Thermoset Mix Viscosity	56000	cP
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Additional Information	Nominal Value	Unit	Test Method
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Cured 7 days @ 75°F

Uncured Properties	Nominal Value	Unit	Test Method
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Curing Time	24	hr
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NOTE

1. Mixed

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