



Dev-Thane™ 2

Description:	A two-part, fast-setting, primerless high performance urethane adhesive that is high viscosity and can be used on a vertical surface with sagging up to 3/8".
Intended Use:	For Industrial Use: Bonds steel, aluminum, stainless steel, galvanized steel, concrete, wood, glass, ABS, and urethanes with no primers.
Features:	Room Temperature Cure
Limitations:	Suitability of product is determined by the end user for their application and process. When dispensing through a pneumatic gun we recommend only 30-35 psi of pressure for good mixing. (0.2 Mpa) Use Devcon's #14291 or #3333 mix nozzles with our pneumatic gun, and #14293 with our manual gun for efficient mixing Shelf Life: 1 Year

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 (24°C)

Adhesive Tensile Lap Shear [ABS]	630 psi, 4 MPa (Subst. Fail.)
Adhesive Tensile Lap Shear [AL]	1,270 psi (8.8 MPa)
Adhesive Tensile Lap Shear [concrete]	1,200 psi (8.2 MPa)
Adhesive Tensile Lap Shear [GBS]	2,750 psi (19 MPa)
Adhesive Tensile Lap Shear [Glass]	Substrate Failure
Adhesive Tensile Lap Shear [SMC]	895 psi (6 MPa)
Adhesive Tensile Lap Shear [SS]	1,840 psi (12.7 MPa)
Adhesive Tensile Shear [galv. mtl]	1,575 psi (10.9 MPa)
Cure Shrinkage	0.0014 in/in (cm/cm)
Dielectric Strength	350
Gap Fill	good
Hardness	63 Shore D
Service Temperature	-40°F to 200°F (-40 to 93°C)
Solids by Volume	100
Tear Resistance	400 pli
Tensile Elongation	200%
Tensile Strength	2,100 psi (14.5 MPa)
T Peel	65-75 pli (11-13 N/mm)

Typical Values

Standard Tests

Adhesive Tensile Shear ASTM D 1002
Dielectric Strength, volts/mil ASTM D 149
Tear Resistance ASTM D 624
Tensile Strength (Epoxies) ASTM D 638
Cured Hardness Shore D ASTM D 2240
Maximum Elongation ASTM D 412
Cure Shrinkage ASTM D 2566
T-Peel Strength ASTM D 1876

Uncured

Color Mixed	Grey
Coverage (10 mil / 0.254 mm)	6 in ² /mL (38.7 cm ² /mL)
Fixture Time	20 minutes
Full Cure	24 hours
Functional Cure	1.5 hours
Mix Ratio by Volume	1:01
Mix Ratio by Weight	1:01
Mixed Density	11.75 lb/gal (1.41 g/cm ³)
Mixed Viscosity	100,000 cps
Specific Volume	19.6 in ³ /lb (0.71 cm ³ /g)
Viscosity	Resin: 45,000 cps: Curing Agent: 140,000 cps
Working Time	2 min. @ 75°F (24°C)

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 increase 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.

50 ML/400ML/490 ML CARTRIDGES

1. Attach cartridge to Mark V™ [50ml] 400ml manual or pneumatic dispensing systems.
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. Mount cartridge onto manual gun or pneumatic gun
 2. Attach mix nozzle
 3. Clip mix nozzle back to desired orifice size.
 4. Squeeze cartridge allowing first THREE inches of material to discharge until unified mixture is extruding from nozzle.
 5. Apply to surface and attach other substrate quickly, as you have 5 minutes of working time to use the product.
- Substrates can be clamped with a bond line thickness as small as 0.007" (0.01 cm).

Storage: Store in a cool, dry place.

Compliances: RoHS

**Chemical
Resistance:**

Chemical resistance is calculated with a 7-day, room temp. cure (30 days immersion) @ 75°F (24°C)

Cutting Oil	Excellent
Gasoline (Unleaded)	Fair
Hydrochloric 10%	Excellent
Isopropanol	Fair
Methyl Ethyl Ketone	Poor
Motor Oil	Excellent
Sodium Chloride Brine	Excellent
Sodium Hydroxide 10%	Excellent

Precautions: **FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate Safety Data Sheet prior to using this product.

Warranty: ITW Performance Polymers 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.

**Order
Information:**

<u>Item No.</u>	<u>Package Size</u>
14500	400 ml cartridge
14503	50 ml cartridge

Contacts:

www.itwpp.com

ITW Performance Polymers (EMEA)
Bay 150, Shannon Industrial Estate
Shannon, County Clare, Ireland V14 DF82
TEL: +353 61 771 500
FAX: +353 61 471 285
Email: customerservice.shannon@itwpp.com

ITW Performance Polymers (US)
30 Endicott Street
Danvers, MA 01923 USA
TEL: 855 489 7262
FAX: 978 774 0516
Email: info@itwpp.com

Disclaimer:

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