



A brand of ITW Polymers Adhesives North America

Food Grade Pot & Seal

Description: Two-component adhesive for bonding aluminum, steel, stainless steel, and alloys of steel cloth. Approved for dry food contact.

Intended Use: Bonding aluminum, stainless steel, and alloys of steel.

Product features: **Excellent chemical, heat and water resistance**
Thermal shock resistance

Limitations: Requires heat curing to attain full physical properties.

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

Dielectric Strength	460 volts/mils
Gap Fill	Excellent
Impact Resistance	5.2 ft.lb./in.(2)
Service Temperature	-40 °F to 275 °F
Shore Hardness	82 Shore D
Solids by Volume	100
Specific Volume	22.00 in.[3]/lb.
Tensile Elongation	1%
Tpeel	2-3 pli

Uncured

Color	White
Heat Cure 10 min. @ 200 °F	1,940 psi
Heat Cure 15 min.@180 °F	1,980 psi
Mix Ratio by Volume	4:1
Mix Ratio by Weight	100;25
Mixed Density	10.5 lbs./gal. : 1.26 gm/cc
Mixed Viscosity	100,000 cps
Working Time	42 min. [28 gm @ 72 °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 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: Apply mixed epoxy directly to one surface in an even film or as a bead. Assemble with the mating part within the recommended pot life. Obtain firm contact between the parts to minimize any gap and ensure good contact of the epoxy with the mating part.

-Surface Preparation-

All surfaces must be clean, dry and oil free before applying adhesive to the surface. Use MEK, or Isoproponal to wipe clean contaminants from the surface.
Metal surfaces should be abraided using an abrasive pad for maximum surface profile. This will increase adhesion to the metal surface.

-Heat Curing Guidelines-

Curing will vary on application and thickness. This product must be heat cured for the adhesive to reach full physical properties. The product must be cured at one of the following conditions:

- 15 minutes @ 180°F Wait to release tension on screen until metal is cooled
- 12 minutes @ 190°F Wait to release tension on screen until metal is cooled
- 10 minutes @ 200°F Wait to release tension on screen until metal is cooled

NOTE: Surface temperature must be maintained at the metal surface to attain the curing speeds stated above.

-Post Cured Guidelines-

After curing the adhesive at the above temperatures, the adhesive must be allowed to cool, for at least 15 minutes before releasing any tension on the screens. This cooling down process is mandatory for the adhesive to attain full strength.

Depress with your fingernail the metal ring to check cure hardness. If an impression is left onto the surface wait longer until material is fully cured with no depression.

Excess heat may cause shrinkage, and discoloration.

Storage:

Store in a cool, dry place.

Compliances:

Complies with 21 CFR 175.300 under proper mixing and use, (dry food only)

Chemical Resistance:

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

Acetic (Dilute) 10%	Very good
Ethanol	Very good
Glycols/Antifreeze	Excellent
Methanol	Fair
Motor Oil	Excellent
Sodium Hydroxide 10%	Excellent
Toluene	Very good
Xylene	Excellent

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:

DA999 400ml cartridge White