

SKPS®

Devcon® Product Catalogue



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METAL REPAIR EPOXIES

Metal-filled epoxy technology that allow for fast economical permanent repairs to power plant and mining equipment. They can be machined, tapped and drilled, and corrosion resistant to harsh chemicals. These products are available in pourable versions that can be used to provide accurate detail reproductions for short run prototype mold patterns, holding fixtures and forming dies.



Devcon® Plastic Steel® Putty (A)

The original metal-filled epoxy putty, it is ideal for repairing areas where welding or brazing would be impractical.

- Can be drilled, tapped and machined.
- Conforms to the requirements of MIL-PRF-24176C, Type I

Item #	Size	Items Per Case
10110	1 lb	6
10120	4 lb	6
10130	25 lb	1



Devcon® Plastic Steel® Liquid (B)

A pourable steel-filled epoxy that provides accurate detail reproduction in making holding fixtures, light gauge forming dies and molds.

- Can be drilled, tapped and machined
- Qualifies under Federal Specification MMM-A-1754, Adhesive/Sealing

Item #	Size	Items Per Case
10210	1 lb	6
10220	4 lb	6
10230	25 lb	1



Devcon® Plastic Steel® 5 Minute® Putty (SF)

Fast-curing, steel-filled epoxy for emergency repairs at temperatures as low as 40° F.

- Repaired parts can be returned to service within one hour
- Mixes, applies, and cures at temperatures as low as 40° F

Item #	Size	Items Per Case
10240	1 lb	6



Devcon® Stainless Steel Putty (ST)

Stainless steel-filled epoxy putty for patching, repairing and rebuilding stainless steel surfaces as well as food processing equipment.

- Bonds to ferrous and non-ferrous metals
- NSF 61 Certified

Item #	Size	Items Per Case
10270	1 lb	6



Devcon® Aluminum Putty

Aluminum-filled epoxy putty for dependable nonrusting repairs to aluminum castings, machinery and equipment.

- Can be machined drilled or tapped using conventional metalworking tools
- Widely used in HVAC applications, it conforms to requirements of MIL-PRF-24176C, Type II

Item #	Size	Items Per Case
10610	1 lb	6
10620	3 lb	6



Devcon® Aluminum Liquid (F-2)

Aluminum-filled pourable epoxy for making molds, patterns and holding fixtures.

- It can be drilled, tapped and machined
- Hardens in just over 1 hour; cures in 16 hours
- Qualifies under Federal Specification MMM-A-1754, Adhesive/Sealing

Item #	Size	Items Per Case
10710	1 lb	6
10720	3 lb	6



Devcon® Underwater Repair Putty (UW)

High-performance technology for repairing, patching, and rebuilding equipment in habitually wet environments, including under water.

- Non-rusting; easy-to-mix and apply
- Eliminates the need for substrate to be thoroughly dry before repair

Item #	Size	Items Per Case
11800	1 lb	6



Physical Properties	Devcon® Plastic Steel Putty (A)	Devcon® Plastic Steel Liquid (B)	Devcon® Plastic Steel 5 Mint Putty (SF)	Devcon® Stainless Steel Putty (ST)	Devcon® Aluminum Putty (F)	Devcon® Aluminum Liquid (F-2)	Devcon® Underwater Repair Putty (UW)
Color	Dark Grey	Dark Grey	Dark Grey	Grey	Aluminum	Aluminum	Grey
Mix ratio by weight/volume (resin:hardener)	9:1 / 2.5:1	9:1 / 3:1	1.7:1 / 1:1	11:1 / 3.75:1	9:1 / 4:1	9:1 / 5:1	1.4:1 / 1:1
Mixed viscosity (cP)	Putty	15 / 25,000	Putty	Putty	Putty	15/25,000	Putty
Functional cure (hours)	16	16	1	16	16	16	24
Pot life (minutes @ 75°F)	45	45	5	58	60	75	45
Specific volume (inches³/pound)	11.9	13.1	12.2	12.4	17.5	17.5	17.0
Coverage per pound (inches²@ 1/4" thickness)	48	52	49	50	70	70	68
Cured hardness (ASTM D2240) (Shore D)	85	85	85	85	85	85	82
Cured shrinkage (ASTM D2566) (inch/inch)	0.0006	0.0006	0.0006	0.0010	0.0008	0.0009	0.0020
Adhesive tensile shear (ASTM D1002) (psi)	2,800	2,800	2,026	2,385	2,600	2,700	2,685
Compressive strength (ASTM D695) (psi)	8,260	10,200	10,400	8,400	8,420	9,820	5,625
Flexural strength (ASTM D790) (psi)	5,600	7,480	7,680	5,280	6,760	7,180	4,990
Modulus of elasticity (ASTM D638) (psi x 10⁵)	8.5	8.5	7.5	8.0	8.0	7.5	7.5
Coefficient of thermal expansion (ASTM D696) [(in)/(in x °F)] x 10⁻⁶	48	38	34	34	29	50	18
Thermal conductivity (ASTM C177) ² [(cal x cm)/(sec x cm x °C)] x 10⁻³	1.37	1.39	2.65	1.23	1.73	1.58	1.41
Dielectric constant (ASTM D150) (1 kHz)	67.5	67.5	35.0	75.0	21.4	8.6	8.6
Dielectric strength (ASTM D149) (volts/mil)	30	30	30	30	100	100	150
Maximum continuous dry service temperature (°F)	250	250	200	250	250	250	250
Maximum continuous wet service temperature (°F)	120	120	N/A	120	120	120	120

Chemical Resistance	Devcon® Plastic Steel Putty (A)	Devcon® Plastic Steel Liquid (B)	Devcon® Plastic Steel 5 Mint Putty (SF)	Devcon® Stainless Steel Putty (ST)	Devcon® Aluminum Putty (F)	Devcon® Aluminum Liquid (F-2)	Devcon® Underwater Repair Putty (UW)
ACIDS							
Acetic 10%	⊙	⊙	⊙	⊙	⊙	⊙	⊙
Hydrochloric 10%	◐	◐	○	◐	◐	◐	○
Sulfuric 10%	◐	◐	○	◐	◐	◐	○
ALCOHOLS							
Methanol	⊙	⊙	⊙	⊙	○	⊙	⊙
Isopropanol	⊙	⊙	⊙	⊙	⊙	⊙	⊙
KETONES							
Acetone	⊙	⊙	⊙	⊙	⊙	⊙	⊙
Methyl ethyl ketone	⊙	⊙	⊙	⊙	⊙	⊙	⊙
ALKALIS							
Ammonium hydroxide 20%	◐	◐	○	◐	○	○	◐
Sodium hydroxide 10%	◐	◐	○	◐	○	○	◐
HYDROCARBONS							
Gasoline (unleaded)	◐	◐	◐	◐	◐	◐	◐
Mineral spirits	◐	◐	◐	◐	◐	◐	◐
CHLORINATED HYDROCARBONS							
1-1-1 Trichloroethane	◐	◐	○	◐	◐	◐	◐
SALTS							
Sodium chloride	◐	◐	○	◐	◐	◐	◐
Trisodium phosphate	◐	◐	○	◐	◐	◐	◐

Key: ● Excellent ◐ Very Good ○ Fair ⊙ Poor

Devcon DFense Blok™ WEARING COMPOUNDS

Specially formulated wear-resistant epoxy coatings that protect dry materials handling and storage equipment from abrasion, corrosion and wear. The DFense Blok™ product line is truly an advanced epoxy technology with quicker functional cure times and better abrasion resistance.

Devcon® DFense Blok™

A bead-filled epoxy compound formulated to significantly outlast traditional wear and abrasion products while providing superior protection.

- 4X better abrasion resistance than competition
- 7X better drop impact

Item #	Items Per Case	Size
11330	1	30 lb



Devcon® DFense Blok™ Fast Cure (FC)

A bead-filled epoxy compound that allows equipment to be returned to service in 2 hours.

- Non-sagging, good adhesion
- Withstands operating temperature, as high as 300° F

Item #	Items Per Case	Size
11350	1	9 lb

Devcon® DFense Blok™ Quick Patch

The only ceramic bead-filled wear and abrasion resistant epoxy for emergency repair.

- Eliminates down-time with exceptionally fast cure
- Repairs holes, leaks and cracks

Item #	Items Per Case	Size
11320	6	1 lb

Devcon® DFense Blok™ Surface Wetting Agent

A thixotropic epoxy gel system that improves the ease of application and cured adhesion properties of DFense Blok™.

- Zero wait time before applying DFense Blok™
- Orange color for easy visual inspection

Item #	Items Per Case	Size
11340	2	1 lb



Devcon® DFense Blok™ Power Mixer

Recommended for most effective way to thoroughly mix DFense Blok™ Wearing Compound.

- Durable steel paddle with three blades;
- 2X faster than drill-style mixers
- Plugs into standard 120V outlet.

Item #	Items Per Case	Size
11301	1	5 gal Mixer



WEARING COMPOUNDS

Specially formulated wear-resistant epoxy coatings that protect dry materials handling and storage equipment from abrasion, corrosion and wear. These products are trowelable, non-sag putties available in large particulate, high impact, and high temperature formulas.

Devcon® Wear Guard™ Fine Load

High-density, micro-alumina ceramic bead-filled epoxy system for protecting equipment that handles particulate smaller than 1/8".

- Withstands operating temperatures as high as 300 °F
- Outstanding resistance to a wide range of chemicals

Item #	Items Per Case	Size
11470	1	30 lb

Devcon® Wear Guard™ High Load

Alumina ceramic bead-filled epoxy system with outstanding abrasion resistance for severe service conditions with particulate greater than 1/8".

- Trowels onto overhead or vertical surfaces without sagging
- Ideal for repairing scrubbers, ash handling systems, pipe elbows, screens, and chutes

Item #	Items Per Case	Size
11490	1	30 lb

Devcon® Wear Guard™ High Temp

High-density, ceramic bead-filled epoxy system for maximum wear and abrasion resistance in high temperature applications.

- Heat-cured, trowelable system that gives up to 30% improvement over conventional wear compounds
- Withstands continuous service temperatures to 450 °F

Item #	Items Per Case	Size
11480	1	30 lb

Devcon® Tile Adhesive

High-strength, trowelable adhesive that cures at room temperature.

- Bonds ceramic tile to vertical, curved, and overhead surfaces and repairs loose ceramic tiles
- Excellent chemical resistance to acids and alkalis

Item #	Items Per Case	Size
11495	1	20 lb

Devcon® HV Tile Adhesive

High-strength, trowelable adhesive compound for bonding tile, with a 35 minute working time.

- High viscosity, great non-sag adhesive
- Fills gaps and joints in crushers prior to backing compounds

Item #	Items Per Case	Size
11489	1	20 lb

MMA Tile Adhesive

Primeless, high strength, creamy trowelable compound for bonding tile with a 14 minutes working time.

- Non-sag seams tiles to surface in 8 minutes
- Functional cure and back in seam in 1.5 hours

Item #	Items Per Case	Size
11481	1	1 gal Adhesive
11486	1	1 gal Activator



WEARING COMPOUNDS/EPOXIES/URETHANES

Physical Properties	Devcon® DFense Blok™ With Surface Wetting Agent	Devcon® DFense Blok™ Fast Cure (FC)	Devcon® DFense Blok™ Quick Patch	Devcon® DFense Blok™ Surface Wetting Agent
Color	Grey	Grey	Grey	Orange
Mix ratio by weight/volume (resin:hardener)	2:1/100:45	2:1/2:1	1:1/1:1	2:1/100:44
Mixed viscosity (cP)	Putty	Putty	Putty	Thixotropic Gel
Functional cure (hours)	4-5	2-3	30 minutes	4-5
Pot life (minutes @ 75°F)	25	15	4	12-15
Specific volume (inches ³ /pound)	12.6	13.5	14.89	24.7
Coverage per pound (inches ² @ 1/4" thickness)	47	53	60	1,860 @ 12 mils
Cured hardness (ASTM D2240) (Shore D)	77	80	84	71
Cured shrinkage (ASTM D2566) (inch/inch)	0.0005	0.0008	0.0010	N/A
Adhesive tensile shear (ASTM D1002) (psi)	2,616	2,764	2,495	2,616
Compressive strength (ASTM D695) (psi)	7,145	7,178	6,166	5,032
Flexural strength (ASTM D790) (psi)	7,876	7,488	4,880	6,700
Coefficient of thermal expansion (ASTM D696) [(in)/(in x °F)] x 10 ⁶	29	33	31	N/A
Dielectric constant (ASTM D150) (1 kHz)	49	45	51	N/A
Maximum continuous dry service temperature (°F)	300	300	200	300
Maximum continuous wet service temperature (°F)	140	140	N/A	140

Chemical Resistance	Devcon® DFense Blok™ With Surface Wetting Agent	Devcon® DFense Blok™ Fast Cure (FC)	Devcon® DFense Blok™ Quick Patch	Devcon® DFense Blok™ Surface Wetting Agent
ACIDS				
Acetic 10%	⊙	⊙	⊙	⊙
Hydrochloric 10%	●	●	●	●
Sulfuric 10%	●	●	●	●
ALCOHOLS				
Methanol	⊙	⊙	○	⊙
Isopropanol	○	⊙	○	○
KETONES				
Acetone	○	⊙	○	○
Methyl ethyl ketone	⊙	⊙	○	⊙
ALKALIS				
Ammonium hydroxide 20%	●	●	●	●
Sodium hydroxide 10%	●	●	●	●
HYDROCARBONS				
Gasoline (unleaded)	○	○	●	○
Mineral spirits	●	●	●	●
CHLORINATED HYDROCARBONS				
1-1-1 Trichloroethane	●	●	●	●
SALTS				
Sodium chloride	●	●	●	●
Trisodium phosphate	●	●	●	●

Key: ● Excellent ● Very Good ○ Fair ⊙ Poor

Physical Properties	Devcon® Wear Guard™ Fine Load	Devcon® Wear Guard™ High Load	Devcon® Wear Guard™ High Temp	Devcon® Tile Adhesive	Devcon® HV Tile Adhesive	MMA Tile Adhesive
Color	Grey	Grey	Grey	White	Grey	White
Mix ratio by weight/ volume (resin:hardener)	2:1 / 2:1	2:1 / 2:1	13.7:1 / 6:1	1.1:1 / 1:1	1.1:1 / 1:1	1.1:1 / 1:1
Mixed viscosity (cP)	Putty	Putty	Putty	Putty	Putty	Putty
Functional cure (hours)	6-8	6-8	Heat Cured	12	8	1.5
Pot life (minutes @ 75°F)	30	30	120	240	35	14
Specific volume (inches ³ /pound)	12.4	12.9	14.3	19.2	19	27.7
Coverage per pound (inches ² @ 1/4" thickness)	50	50	60	76.8	76	118
Cured hardness (ASTM D2240) (Shore D)	87	87	87	81	81	60
Cured shrinkage (ASTM D2566) (inch/inch)	0.0006	0.0006	0.0010	0.0010	0.0010	0.005
Adhesive tensile shear (ASTM D1002) (psi)	1,375	1,474	2,300	2,890	1,825	2,458
Compressive strength (ASTM D695) (psi)	11,000	11,000	13,200	9,620	11,800	3,254
Flexural strength (ASTM D790) (psi)	7,190	7,140	8,220	5,480	5,400	4,719
Coefficient of thermal expansion (ASTM D696) [(in)/(in x °F)] x 10 ⁻⁶	34	32	27	14	14	18
Dielectric constant (ASTM D150) (1 kHz)	46.0	41.0	38.0	46.0	45.0	43.0
Maximum continuous dry service temperature (°F)	300	300	450	200	200	180
Maximum continuous wet service temperature (°F)	140	140	150	150	N/A	150

NOTE Three-part system, beads separate

Chemical Resistance	Devcon® Wear Guard™ Fine Load	Devcon® Wear Guard™ High Load	Devcon® Wear Guard™ High Temp	Devcon® Tile Adhesive	Devcon® HV Tile Adhesive	MMA Tile Adhesive
ACIDS						
Acetic 10%	○	○	○	○	○	○
Hydrochloric 10%	●	●	●	●	●	●
Sulfuric 10%	●	●	●	●	●	●
ALCOHOLS						
Methanol	○	○	○	○	○	○
Isopropanol	○	○	○	○	○	○
KETONES						
Acetone	○	○	○	○	○	○
Methyl ethyl ketone	○	○	○	●	●	○
ALKALIS						
Ammonium hydroxide 20%	●	●	●	●	●	●
Sodium hydroxide 10%	●	●	●	●	●	●
HYDROCARBONS						
Gasoline (unleaded)	●	●	●	○	○	○
Mineral spirits	●	●	●	●	●	●
CHLORINATED HYDROCARBONS						
1-1-1 Trichloroethane	●	●	●	●	●	●
SALTS						
Sodium chloride	●	●	●	●	●	●
Trisodium phosphate	●	●	●	●	●	●

Key: ● Excellent ○ Very Good ○ Fair ○ Poor

THE NEWEST BELT REPAIR COMPOUND ... Devcon® R-Flex®

Devcon® R-Flex® is a self-leveling urethane kit for repairing holes, tears, gouges, and now metal splice clips, in SBR heavy weight conveyor belts. With greater flexibility, Devcon® R-Flex® can now be used to coat directly over metal clips to extend the life of previous repairs made. The kit includes: resin, curing agent, surface conditioner, metal clip primer, mix bucket (4 lb size only), scrub pad, gloves, paper towels, and plastic spatula. The coverage for 15550 4 lb kit is 440 sq inches at 1/4" thickness and for 15565 1.5 lb kit is 110 sq. inches at 1/4" thickness. Devcon® Surface Conditioner is a 2-part system that enhances the adhesion of Devcon® R-Flex® to SBR rubber. The fluorescence in surface conditioner allows for visual inspection to ensure greatest adhesion to the belt. It's easy to see in dark locations or bright sun light where the surface conditioner has been applied.

Key Product Features:

- Self-leveling liquid while applying then becomes a non-sag gel in 4 minutes
- Rapid initial adhesion
- Back in service in 90 minutes
- Easy to mix and pour
- Available in two kit sizes for large and small repairs

Devcon® R-Flex®

The newest belt repair product in the market place. A self-leveling urethane kit for repairing holes and tears in conveyor belts. Also used to cover and protect clips/pins from scrapers.

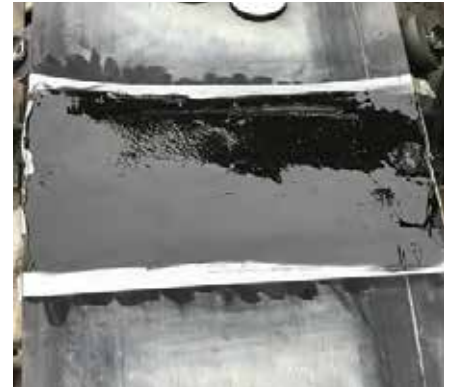


- Functional cure in 90 minutes
- High adhesion with surface pull of the SBR rubber
- Kit includes surface conditioner

Item #	Items Per Case	Size
15550	1	4 lb
15565	4	1.5 lb



Before Metal Clips Splice Repair



After Metal Clips Splice Repair



Before Repair: Large tear in belt due to rocks getting caught under the scraper blade.



After Repair: Belt flap cut down, Devcon Surface Conditioner and R-Flex applied to belt.

Physical Properties	Devcon® R-Flex	Devcon® Flexane 80 Putty	Devcon® Flexane Brushable	Flexane High Performance Putty	Flexane High Fast Cure Putty	Flexane High Fast Cure Liquid	Flexane 80 Liquid	Flexane 94 Liquid
Color	Black	Black	Black	Black	Black	Grey	Black	Black
Mix ratio by weight (resin:hardener)	88:12	72:28	80:20	94:6	80:20	80:20	77:23	69:31
Mixed viscosity (cP)	Putty	Putty	40,000	Putty	Putty	5,800	10,000	6,000
Pot life (minutes @ 75°F)	4	20	45	10	8	8	30	10
Specific volume (inches³/pound)	27.4	23.5	26.0	23.5	23.5	26.5	26.5	26.5
Coverage per pound (inches²@ 1/4" thickness)	440/110	94	104	94	94	106	106	106
Functional cure (hours)	1 1/2	12	18	16	3	2	16	16
Demolding time (hours)	N/A	N/A	N/A	N/A	N/A	N/A	10	5
Cured hardness (ASTM D2240) (Shore A)	92	87	86	78	88	94	87	97
Cured shrinkage (ASTM D2566) (inch/inch)	NA	0.0014	0.232	0.12 ²	0.0014	0.0018	0.0018	0.0014
Tensile strength (ASTM D412) (psi)	1,462	1,700	3,500	4,500	2,400	3,300	2,100	2,800
Tear resistance (ASTM D624) (pli)	270	300	400	400	275	430	350	415
Abrasion resistance weight loss¹ (mg)	270	280	90	140	220	330	285	330
Maximum elongation (ASTM D412) (%)	421	300	600	600	500	450	650	500
Dielectric strength (ASTM D149) (volts/mil)	350	350	340	350	350	350	350	350
Maximum continuous wet service temperature (°F)	120	120	120	120	120	120	120	120
Maximum continuous dry service temperature (°F)	180	180	180	180	180	180	180	180
Maximum continuous wet service temperature (°F)	120	120	N/A	120	120	120	120	120

NOTES: Taber H-18 wheel (mg/1,000 revolutions @ 1,000 gram load)² Due to solvent loss

Chemical Resistance	Devcon® R-Flex	Devcon® Flexane 80 Putty	Devcon® Flexane Brushable	Flexane High Performance Putty	Flexane High Fast Cure Putty	Flexane High Fast Cure Liquid	Flexane 80 Liquid	Flexane 94 Liquid
ACIDS	○	○	○	○	○	○	○	○
Acetic 10%	○	●	○	○	●	●	●	●
Hydrochloric 10%	○	●	○	○	●	●	●	●
Sulfuric 10%	○	●	○	○	●	●	●	●
Sulfuric 50%	○	●	○	○	●	●	●	●
Phosphoric 10%	○	●	○	○	●	●	●	●
ALCOHOLS								
Methanol	○	○	○	○	○	○	○	○
Isopropanol	○	○	○	○	○	○	○	○
KETONES								
Acetone	○	○	○	○	○	○	○	○
Methyl ethyl ketone	○	○	○	○	○	○	○	○
ALKALIS								
Ammonium hydroxide 20%	●	●	●	●	●	●	●	●
Sodium hydroxide 10%	●	●	●	●	●	●	●	●
HYDROCARBONS								
Gasoline (unleaded)	○	○	○	○	○	○	○	○
Mineral spirits	○	○	○	○	○	○	○	○
SALTS								
Sodium chloride	●	●	●	●	●	●	●	●
Trisodium phosphate	●	●	●	●	●	●	●	●
Aluminum sulfate 10%	●	●	●	●	●	●	●	●
Sodium carbonate 10%	●	●	●	●	●	●	●	●

Key: ● Excellent ○ Very Good ○ Fair ○ Poor

BELTING & RUBBER REPAIR

Flexible urethane technologies for repairing worn or damaged SBR conveyor belts, rubber lined equipment such as pipes and tanks in mines, quarries, and coal-fired power plants. These products are in a non-sag putty for patching and repairing linings along with self-leveling thixotropic versions that create a smooth surface for repairing conveyor belts.

Devcon® Flexane® 80 Putty

Trowelable urethane for repairing and lining process equipment exposed to wear, abrasion, vibration or expansion/contraction.

- Service temperatures to 180°F in dry environments and 120°F in wet environments
- Bonds to metal, concrete, rubber, wood, and fiberglass surfaces

Item #	Size	Items Per Case
15820	1 lb	6
15850	4 lb	1

Devcon® Flexane® Brushable

High-performance brushable urethane for protection against abrasion and impact.

- Excellent for repairing/coating rubber-lined pumps, tanks and valves
- Applies in thicknesses of 50 mils in one application

Item #	Size	Items Per Case
15350	1 lb	6



Devcon® Flexane® High Performance Putty

Trowelable lining for maximum protection against abrasion, gouging and impact.

- Cures to a tough (tear strength 400 pli), resilient rubber compound (Hardness 78 Shore A)
- Bonds to metal, rubber, wood, fiberglass, and concrete

Item #	Size	Items Per Case
15330	1 lb	6

Devcon® Flexane® Fast Cure Putty

Black Flexane® Fast Cure thickens to a putty in seconds providing superior flexibility, elongation and adhesion to rubber.

- Light service duty in 3 hours
- Thixotropic, creamy formula which thickens in time
- Dispenser #15043 (manual) Nozzle #15047

Item #	Size	Items Per Case
15049	400 ml Cartridge	4

Devcon® Flexane® 80 Liquid

Medium-viscosity (10,000 cP) urethane fills voids completely and faithfully reproduces mold detail.

- Cures to semi-rigid rubber (Shore A 87)
- Cures at room temperature to a semi-rigid rubber material

Item #	Size	Items Per Case
15800	1 lb	6
15810	10 lb	1

Devcon® Flexane® FC Liquid

A convenient, time-saving method of filling expansion joints and repairing rubber.

- 8-minute working time
- No-mess dispensing with fast, easy, 400 ml reusable cartridges
- Dispenser #15043 (manual) Nozzle #15047

Item #	Size	Items Per Case
15050	400 ml Cartridge	4

Devcon® Flexane® 94 Liquid

Low-viscosity (6,000 cP) urethane fills voids completely and faithfully reproduces mold detail.

- Similar to Flexane® 80 Liquid, but cures to (Shore A 97)
- Requires only a five hour demolding time

Item #	Size	Items Per Case
15250	1 lb	6
15260	10 lb	1

Devcon® Flex-Add™

Used with Flexane® 80 Liquid to produce a more flexible urethane.

- Creates a lower durometer castable urethane
- Can match existing hardness of rubber

Item #	Size	Items Per Case
15940	8 oz	6

Devcon® Liquid Release Agent

Silicone release agent prevents Devcon's epoxy and urethane compounds from sticking to patterns or mold surfaces.

- Produces a high gloss finish
- Facilitates the accurate duplication of intricate details

Item #	Size	Items Per Case
19600	1 pt	6

Devcon® Flexane® Primer

Required for maximum adhesion of Flexane® products. FL-10 Primer for all metals. FL-20 Primer for rubber, wood, fiberglass and concrete. Ensures ultimate peel strength (greater than 80 psi).

Item #	Primer	Size	Items Per Case
15980	FL-10	4 oz	6
15985	FL-20	4 oz	6

FLOOR REPAIR/PATCHING COMPOUNDS

100% solids epoxy-based polymers for patching, rebuilding and resurfacing concrete, brick, stucco and block.

Devcon® Floor Patch™

All-purpose, easy-to-mix and apply concrete patching compound. With a compressive strength of 8,000 psi, Floor Patch™, provides three times the typical strength of concrete.

Item #	Size	Items Per Case
13100	10 lb	1
13120	40 lb	1



Devcon® Ultra Quartz™

Heavy-duty, trowelable premium floor patching system with excellent chemical resistance. System includes a primer for superior adhesion to cured concrete or other surfaces.

Item #	Size	Items Per Case
13550	35 lb	1



FLOOR COATINGS

Epoxy floor coatings for protecting plant floors, platforms, walkways and ramps against acids, alkalis and solvents.

Devcon® Epoxy Coat™ 7000 AR (Acid Resistant)

Novolac non-VOC epoxy coating provides superior resistance to concentrated acids (including 98% sulfuric) and chemicals. Excellent adhesion to concrete surfaces. Ideal for use around chemical storage tanks, dike walls and containment areas.

Item #	Size	Items Per Case
12750	2 gal	1

Devcon® Epoxy Concrete Sealer

Self-leveling, non-VOC clear epoxy sealer can be used as a primer on damp surfaces. Easily applied by brush, roller or squeegee at temperatures as low as 40°F. Outstanding resistance to chemicals, acids, alkalis and hydrocarbons.

Item #	Size	Items Per Case
12560	2 gal	1



ANTI-SKID PROTECTION

Granular additives used with Devcon® floor coatings to produce anti-slip surfaces for worker safety.

Devcon® Floor Grip™

Heavy-duty epoxy compound with silicone carbide granules produces an exceptional non-skid surface on walkways, ramps, loading docks and stairs. Excellent adhesion to concrete, brick, steel, aluminum and wet surfaces. Can be applied at temperatures as low as 40°F.

Item #	Size	Items Per Case
13090	2 gal	1



Physical Properties	Floor Patch	Ultra Quartz	Epoxy Concrete Sealer	Epoxy Coat 7000 AR
Coverage per unit (feet ² @ thickness)	18@0.25" / 40 lb unit	13@0.25" / 35 lb unit	400 @ 8 mils	200 @ 16 mils
Mixed viscosity (cP)	Putty	Putty	2,000	3,600
Minimum application temperature (°F)	60 ~ 90	60 ~ 90	40 ~ 90	60 ~ 90
Pot life (minutes @ 75°F)	45	60	60	36
Functional cure (hours)	16	16	24	24
Cured hardness (ASTM D2240) (Shore D)	85	95	85	85
Maximum continuous service temperature (°F)	250	250	180	200
% Solids	100	100	100	100

Chemical Resistance	Floor Patch	Ultra Quartz	Epoxy Concrete Sealer	Epoxy Coat 7000 AR
ACIDS	⊗	⊗	⊗	⊗
Acetic 10%	◐	●	◐	●
Hydrochloric 10%	◐	●	◐	●
Sulfuric 10%	◐	●	◐	●
ALCOHOLS	○	●	⊗	⊗
Methanol	⊗	○	⊗	⊗
Isopropanol	⊗	○	⊗	⊗
KETONES	⊗	⊗	⊗	⊗
Acetone	⊗	⊗	⊗	⊗
Methyl ethyl ketone	⊗	⊗	⊗	⊗
ALKALIS	◐	●	◐	◐
Ammonium hydroxide 20%	◐	●	●	●
Sodium hydroxide 10%	◐	●	●	●
HYDROCARBONS	◐	●	◐	●
Gasoline (unleaded)	◐	●	◐	●
Mineral spirits	◐	●	◐	●
CHLORINATED HYDROCARBONS	●	●	●	●
1-1-1 Trichloroethane	●	●	●	●
SALTS	●	●	◐	●
Sodium chloride	●	●	◐	●
Trisodium phosphate	●	●	◐	●

Key: ● Excellent ◐ Very Good ○ Fair ⊗ Poor

Methacrylate Structural Adhesives

STRUCTURAL ADHESIVES

DEWELD 531 PACKAGE SIZE: 50ml Cartridge

DESCRIPTION

Devweld 531 is a two-part 1:1 ratio methacrylate adhesive designed for structural bonding of thermoplastic, metal and composite assemblies. Devweld 531 is particularly well suited for bonding thermoplastic materials and combines high strength and stiffness with the ability to adhere difficult-to-bond materials.

FEATURES

- Excellent shear, peel and impact strength
- Non-sagging
- Will fill gaps of up to 4mm
- Excellent load bearing qualities
- Resistant to weathering and humidity
- Specifically designed for difficult-to-bond substrates

PRODUCT DATA

	PART A	PART B
PHYSICAL PROPERTIES UNCURED @ 23⁰ C	COLOUR	Off White
	VISCOSITY CPS	40,000-60,000
	MIXED RATIO BY VOLUME AND WEIGHT	1
	DENSITY G/CC	1.03
	MIXED DENSITY G/CC	1.00
	WORKING TIME ²@ 23'C	15 - 18 mins
	FIXTURE TIME ³ @ 23'C	30 - 35 mins
	FULL CURE	24 hours
	FLASH POINT ⁰C	9
	GAP FILL, MM	1-4 ¹
MECHANICAL PROPERTIES CURED @23⁰ C	TENSILE STRENGTH MPA	27 - 31
	MODULUS, MPA	1034 - 1206
	LAP SHEAR STRENGTH MPA (GBS)	20 - 24
	ELONGATION (%)	5-15
	OPERATIONAL TEMPERATURE RANGE,⁰ C	-55 - 121

DEWELD 530 PACKAGE SIZE: 50ml Cartridge DESCRIPTION

Devweld 530 is a two-part 1:1 methacrylate adhesive designed for structural bonding of thermoplastic, metal and composite assemblies. Devweld 530 offers a combination of high strength and stiffness as well as the ability to bond a wide range of materials.

FEATURES

- Room temperature cure
- Non-sagging
- Will fill gaps of up to 4mm
- Excellent load bearing qualities
- Resistant to weathering and humidity
- Excellent shear, peel and impact strength

PRODUCT DATA

	PART A	PART B
PHYSICAL PROPERTIES UNCURED @ 23⁰ C	COLOUR	Off White
	VISCOSITY CPS	40,000-60,000
	MIXED RATIO BY VOLUME AND WEIGHT	1
	DENSITY G/CC	1.01
	MIXED DENSITY G/CC	0.98
	WORKING TIME ² @ 23'C	4 - 6 mins
	FIXTURE TIME ³ @ 23'C	12 - 15 mins
	FULL CURE	24 hours
	FLASH POINT ⁰C	9
	GAP FILL, MM	1-4 ¹
MECHANICAL PROPERTIES CURED @23⁰ C	TENSILE STRENGTH MPA	20 - 24
	MODULUS, MPA	931 - 1137
	LAP SHEAR STRENGTH MPA (GBS)	20 - 24
	ELONGATION (%)	15-25%
	OPERATIONAL TEMPERATURE RANGE,⁰ C	-55 - 120

EPOXY ADHESIVES

Devcon® advanced epoxy adhesives are used for structural bonding, potting and encapsulating, and come in a variety of cure times and package sizes.

Devcon® 5 Minute® Epoxy

Rapid curing, general-purpose adhesive/encapsulant which easily dispenses and mixes in seconds, dries in 15 minutes and reaches functional strength in 1 hour.

Item #	Size	Items Per Case	Dispenser	Nozzle
14250	25 ml Dev-Tube™	24	---	---
14270	50 ml Cartridge	12	14280 (manual)	14285
14210	2.5 oz	24	---	---
DA051	400 ml Cartridge	12	14410 (manual)	3333
14200	15 oz	6	---	---
14630	9 lb	1	---	---

Devcon® One Minute™ Epoxy Gel

Lightning fast curing gel adhesive for filling gaps, cracks and holes.

Item #	Size	Items Per Case	Dispenser	Nozzle
14277	50 ml Cartridge	12	14280 (manual)	14285

Devcon® 5 Minute® Epoxy Gel

Thixotropic, non-migrating gel adhesive with excellent gap filling properties

Item #	Size	Items Per Case	Dispenser	Nozzle
14240	25 ml Dev-Tube™	24	---	---
14265	50 ml Cartridge	12	14280 (manual)	14285
DA052	400 ml Cartridge	12	14410 (manual)	30095

Devcon® 2 Ton® Epoxy

Extremely strong, medium-cure, water-resistant adhesive.

Item #	Size	Items Per Case	Dispenser	Nozzle
14310	25 ml Dev-Tube™	24	---	---
14260	50 ml Cartridge	12	14280 (manual)	14285
14355	400 ml Cartridge	12	14410 (manual)	3333
14360	9 lb	1	---	---

OEM Adhesive Selector Guide

	OEM Material	1 Minute™	5 Minute™	2 Ton®
		Epoxy Gel	Epoxy Gel	Clear Epoxy
METAL	Aluminum	●	●	●
	Brass	●	●	●
	Cast Iron	●	●	●
	Copper	○	●	●
	Ferrite	○	○	○
	Painted metals	○	○	○
	Plated metals			
	Sheet metal			
	Stainless steel	●	●	●
	Cold rolled steel	●	●	●
PLASTIC	Galvanized			
	ABS			
	Acrylics (PMMA)			
	Fiberglass			○
	Gel coats			
	Epoxy	○	○	○
	Polyamides (Nylon) (6,6/6)			
	Polyesters (PET/PBA blends)			
	Polycarbonate	●		
	PPO and PPO blends			
	Vinyls (PVC)	○	○	○
	RIM urethanes			
	SMCs			
	Styrene resins			
	Polyacrylate			
	Polyurea			
	Cellulosics (CAL, CAB, CAP)			
Polysulfone				
Phenolics				
Laminates				
WOOD	Wood (hard and soft)	●	●	●
	Plywood	●	●	●
	Particle board	●	●	●
OTHER	Brick	●	●	●
	Concrete	●	●	●
	Rubber			
	Honeycomb	○	○	○
	Ceramics	○	○	○
Glass				

Physical Properties	5 Minute Epoxy	5 Minute Epoxy Gel	1 Minute Epoxy Gel	2 Ton Epoxy
Color	Clear	Opaque	Clear	Clear
Mix ratio (resin:hardener)	1:1	1:1	1:1	1:1
Mixed viscosity (cP)	10,000	Gel	70,000	
Working time ¹ (minutes)	3 ~ 6	4 ~ 7	45 sec	8 ~ 12
Fixture time ² (minutes)	10 ~ 15	10 ~ 15	1	30 ~ 35
Functional cure (minutes)	90	45 ~ 60	30 ~ 45	120
Adhesive tensile lap shear (ASTM (ASTM D1002) ³) (psi)	1,900 ⁴	2,500	1,600 ⁴	
Tensile elongation(%)	5	1	1	1
Peel strength (pli)	2 ~ 3	2 ~ 3	2 ~ 3	
Impact resistance (ft-lb/in ²)	5.5	6.5	4.5	6.5
Maximum dry service temperature (°F)	40 ~ 200	-40 ~ 200	-40 ~ 200	

NOTES: 1The maximum allowable time to mate and position parts after mixing and application of the adhesive. After this interval, parts must not be disturbed. 2The time required for the adhesive to generate sufficient bond strength to allow parts to be handled without deformation of the bond line. 3All tensile strength data per ASTM D1002 on grit-blasted steel, bond line thickness of 0.010". 4Bond line thickness of 0.005".

Chemical Resistance	5 Minute Epoxy	5 Minute Epoxy Gel	1 Minute Epoxy Gel	2 Ton Epoxy
ACIDS				
Acetic 10%	○	○	○	○
Hydrochloric 10%	○	○	○	○
Sulfuric 10%	○	○	○	○
ALCOHOLS				
Glycol	○	○	○	●
Isopropanol	○	○	○	○
Methanol	○	○	○	○
KETONES				
Acetone	○	○	○	○
Methyl ethyl ketone	○	○	○	○
ALKALIS				
Ammonium hydroxide	○	○	○	○
20% Sodium hydroxide	○	○	○	○
10% Sodium hydroxide	○	○	○	○
HYDROCARBONS				
Gasoline (unleaded)	●	●	●	●
Mineral spirits	●	●	●	●
Motor oil	●	●	●	●
SALTS				
Sodium chloride	○	○	○	○
Trisodium phosphate	○	○	○	○

Key: ● Excellent Choice ○ Good Choice ○ Requires Metal Prep 90™

Blank - Not Recommended

Key: ● Excellent ○ Very Good ○ Fair ○ Poor

ADHESIVES/SEALANTS

SEALANTS

SILITE SEALANT-WHITE & CLEAR

PRODUCT INFORMATION

STOCK NO.: 17150 Clear, PACKAGE SIZE: 310ml Cartridge

STOCK NO.: 17140 White, PACKAGE SIZE: 310ml Cartridge

FEATURES

- Weatherproofs electrical boxes
- Caulks plumbing fixtures
- Ideal sealant for use in building construction
- Use to make form-in-place gaskets particularly in HVAC
- Seals ductwork
- Insulates exposed wiring

DESCRIPTION

Silicone resin based adhesive/sealant for sealing, jointing, caulking and bonding.

PRODUCT DATA

TYPICAL PHYSICAL PROPERTIES	
COLOUR	White and Clear
MIX RATIO BY VOLUME	N/A
MIX RATIO BY WEIGHT	N/A
% SOLIDS BY VOLUME	100
POT LIFE AT 21°C / MINS	N/A
SPECIFIC VOLUME CC/KG	952
CURED SHRINKAGE CM/CM	N/A
SPECIFIC GRAVITY	1.05
TEMPERATURE RESISTANCE /°C	-50 to 230°C
COVERAGE	Dependent on bead size
CURED HARDNESS / SHORE A	30
DIELECTRIC STRENGTH KV/MM	14.7
ADHESIVE TENSILE SHEAR / MPA	2.6
COMPRESSIVE STRENGTH MPA	N/A
COEFFICIENT OF THERMAL EXPANSION X10 ⁻⁶ CM/CM/°C	N/A
THICKNESS PER COAT / MM	No limit, Non-sag up to 2 cm
FUNCTIONAL CURE TIME / HOURS	24
RECOAT TIME / HOURS	Anytime
MIXED VISCOSITY / CPS (WHERE APPLICABLE)	N/A

CHEMICAL RESISTANCE - 7 DAYS ROOM TEMPERATURE CURE (30 DAYS)

- TESTING CARRIED OUT 30 DAYS IMMERSION AT 21° C

	POOR	FAIR	VERY GOOD	EXCELLENT
AMMONIA		•		
CUTTING OIL			•	
ISOPROPYL ALCOHOL				•
GASOLINE (UNLEADED)	•			
HYDROCHLORIC ACID 10%	•			
METHYL ETHYL KETONE (MEK)	•			
METHYLENE CHLORIDE	•			
SODIUM HYPOCHLORITE 5% (BLEACH)			•	
SODIUM HYDROXIDE 10%				•
SULPHURIC ACID 10%			•	
XYLENE	•			

Excellent = +/- 1% weight change, Very Good = +/- 1-10% weight change, Fair = +/- 10-20% weight change, Poor = > 20% weight change

DISPENSING EQUIPMENT

GUNS

Item # Description

20015 Manual Applicator Gun
50 ml Applicator

14281 Manual Applicator Gun
200 ml 250 ml Applicator

20020 Manual Applicator Gun
400 ml Applicator



NOZZLES

Item # Description

3574 STATIC MIXER FOR 1:1 (MA 6.3-21)
50 ml Nozzle

3577 STATIC MIXER FOR 1:1 (MA 6.3-12S)
50 ml Nozzle



ANCILLARY PRODUCTS

LIQUID RELEASE AGENT

PACKAGE SIZE: 470ml

DESCRIPTION

A liquid silicone agent that prevents Devcon epoxies and urethanes from sticking to patterns and mould surfaces, ensuring easy release. Flashpoint 46°C

RECOMMENDED APPLICATIONS

- Any metal surfaces, alloys, plaster castings
- Rubber surfaces, plastics, wood and concrete

APPLICATION

Pour a generous amount of Release Agent onto a clean lint-free cloth. Lightly rub onto the part or piece of equipment gently, leaving a thin, shiny coat. The area should then be allowed to dry for 3 -5 minutes until agent is semi - dry to the surface prior to application of epoxy or urethane products. A brush can be used for intricate mould surfaces, to ensure Release Agent gets into every part. Approximate coverage is 20m² / L however this is dependant on the porosity of the surface. Use only on solid or sealed surfaces. If the master is plaster, wood or other porous material, seal with a suitable coating before applying Devcon Release Agent.

PRIMERS

FL-10 PRIMER

FL-12 PRIMER

DESCRIPTION

Flexane Primers provide maximum adhesion of all Flexane products to the substrate.

RECOMMENDED APPLICATIONS

Apply to metals, concrete, rubber, wood, fibreglass and previously applied Flexane.

SURFACE PREPARATION

CLEANING RUBBER

If the rubber surface is oily or greasy, use Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 with an abrasive pad to cleanse the surface. After the recommended method of degreasing, coarse sanding (16 or 24 grit) of the rubber surface is done to produce a good 'surface profile'. Oils and contaminants that are imbedded into the rubber surface are usually released at this time.

CLEANING METAL

If the metal surface is oily or greasy, use Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 to cleanse the surface. After this recommended method of cleaning, abrasive blasting is done to the surface to produce a good 'surface profile'. Oils and contaminants usually get embedded into the surface, and do not wash away with degreasing. Use a 24 - 40 grit or coarser abrasive for this process.

CLEANING CONCRETE

Concrete being a very porous substrate requires multiple cleaning. Degrease the area with Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 and rinse the area. A power washer or steam cleaner is useful for quicker and efficient cleaning. Let the floor dry thoroughly before applying Primer and Flexane.

APPLICATION

Many field applications using Devcon's Flexane technology are unsuccessful because the technician fails to use the proper primers to adhere the Flexane to the substrate. There are two different priming systems to use when applying Flexane.

They are as follows:

METAL SURFACES: Use 2 coats Devcon's FL-10 Primer to coat all metal substrates; this includes Stainless Steel and Aluminum.

RUBBER SURFACES: Use Devcon's FL-20 Primer to coat all gum rubbers, neoprene and cured urethanes.

IMMERSION SUBSTRATES: Use both Primers FL-10 and FL-20 to coat any metal substrate that will be immersed in any aqueous solution. First apply the FL-10 Primer and let it dry for 60 minutes. Next coat with the FL-20 Primer. Let it dry for 30 minutes before applying the Flexane material.

CONCRETE: Use Devcon's FL-20 Primer to coat this substrate. Concrete being a very 'porous' substrate may need multiple coats of FL-20 Primer for proper adhesion. Let the Primer dry for 30 minutes between coats.

WOOD & FIBREGLASS: Use Devcon's FL-20 Primer for all wood products. The softwoods will need 2 coats of Primer because of their absorption characteristics. It should be noted that applying two coats of FL-10 Primer to metal substrates will improve the adhesion over a one coat priming system. Each container of Flexane Primer covers approximately 1sq. meter. For all other substrates please consult Devcon for information on their range of Primers and correct application procedures.

A black and white photograph of a hand holding a pen over a document with a large dollar sign watermark. The hand is positioned as if about to sign the document. The background is a light, neutral color.

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