Devcon®

Technical Data Sheet

5/21/2008

Permatex® Zip Grip® TE 2400

Description: A high-viscosity, rubber-toughened instant adhesive with exceptional flexibility and extended temperature resistance

Intended Use:

Product features:
Bonds dissimilar substrates
Exceptional thermal shock performance
Temperature-resistant to 280°F
Permanent
Toughened Ethyl High Viscosity [Clear]
High impact resistance
Fills large gaps
Enhanced toughness to peel and shock loads
Humidity and water resistant

Limitations: Not recommended for use on glass due to substrate weakness

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	
Adhesive Tensile Shear	3,700 psi
Coefficient of Thermal Expansion	.00012 in./in./°F
Dielectric Constant	5.4 @ 1KHz
Dielectric Strength	295 volts/mil @ 1KHz
Flashpoint	185°F
Impact Resistance	8 ft.lb./in.(2)
Melting Point	329°F
Peel Strength	10 pli
Refractive Index	1.49
Service Temperature Range	-65°F to 280°F
Solubility	Nitromethane, Acetone
Volume Resistivity	5.3E-14 ohm/cm

TESTS CONDUCTED
Adhesive Tensile Shear ASTM D 1002
Dielectric Constant ASTM D 150
Volume Resistivity , ohm/cm ASTM D 149
Coef. of Thermal Expansion ASTM D 696
Dielectric Strength, volts/mil ASTM D 149

Uncured	
Base	Ethyl cyanoacrylate
Color	Colorless liquid
Cure Speed	40-70 sec.(Steel); 25-50sec. (Plastics); 25-50sec.
Full Cure	24 hrs.
Gap Filling	0.009"
Military Specification	Mil-A-46050C Type II, Class 3
Shelf Life	1 year
Specific Gravity	1.06 g/cc
Viscosity	2,400 cps

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.

---- CLEANING METHODS ----

STEEL:
Vapor degrease or cold-solvent clean (Sand blasting or other preparation is not typically required).

ALUMINUM:
Abrade with Scotch-Brite™ abrasive pads or steel wool, then clean with solvent.

RUBBER:
Wipe clean with isopropyl alcohol or solvent.

PLASTICS:
Lightly abrade shiny, smooth surfaces, then solvent-wipe with suitable solvent such as 1,1,1-trichloroethane, acetone, or VM&P naptha. Non-shiny surfaces need only be solvent-wiped.

Mixing Instructions:

Mixing is not applicable to this product.

Application Instructions:

1. Apply adhesive directly from bottle [approx .006 gms per sq. in is sufficient]
2. Press surfaces together
3. Hold tightly for a few seconds

ADDITIONAL PRODUCT INFORMATION
- Cyanoacrylates fixture in a few seconds on most smooth, close fitting substrates
-They cure best at room temperature [72°F]
-Heat does NOT accelerate the cure of cyanaoacrylates
-The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed.
-Activators can be appied to improve set speed but may also impair overall performance.

Storage:

Store in a cool, dry place.

Compliances:

CID A-A-3097, Type II, Class 3

Chemical Resistance:

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

1,1,1-Trichloroethane	Excellent
Gasoline (Unleaded)	Excellent
Hydrochloric 10%	Poor
Motor Oil	Excellent
Sodium Hydroxide 10%	Poor

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:

72261 1 lb.
72250 1 oz.