



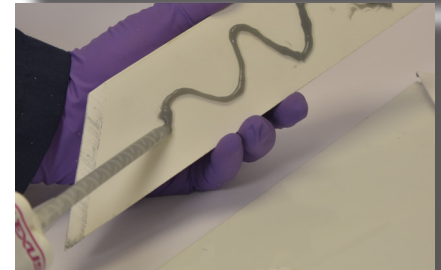
ADHESIVE SELECTOR GUIDE

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- Excellent Choice
- ◐ Good Choice

	One Minute™ Epoxy Gel	5 Minute® Epoxy	5 Minute® Epoxy Gel	10 Minute® Epoxy	2 Tone® Epoxy	Epoxy Plus™ 25	HP 250	Dev-Thane™ 5,2	Zip Grip® Instant Adhesive	MA8110	MA8120
METALS											
Aluminum 1	●	●	●	●	●	●	●	●	◐	●	●
Brass	●	●	●	●	●	●	●	●	◐	●	●
Cast Iron	●	●	●	●	●	●	●	●	◐	●	●
Copper	◐	●	●	●	●	●	●	●	◐	●	●
Ferrite	◐	◐	◐	◐	◐	●	●	●	◐	◐	◐
Painted Metals	◐	◐	◐	◐	◐	◐	●	◐	●	●	●
Plated Metals				◐	◐	◐	●	◐	●	●	●
Sheet Metal				◐	●	●	●	◐	●	●	●
Stainless Steel 1	●	●	●	●	●	●	●	◐	●	●	●
Cold Rolled Steel	●	●	●	●	●	●	●	●	●	●	●
Galvanized				◐	●	◐	●		●	●	●
PLASTICS											
ABS				◐	◐		◐	◐	●	●	●
Acrylics (PMMA)				◐	●	◐	◐	◐	●	●	●
Fiberglass		◐	◐	◐	◐	●	●	◐	●	●	●
Gel Coats					●	●	●		●	●	●
Epoxy	◐			◐	●	●	●		◐	●	●
Polyamides (Nylon) (6, 6/6)					●	◐	◐		◐	●	●
Polyesters (PET, PBT)					●	◐	◐		◐	◐	◐
Polycarbonate	●				◐	◐			◐	●	●
PPO and PPO Blends									◐	●	●
Vinyls (PVC)	◐	◐	◐	◐	◐	◐			●	●	●
RIM Urethanes									●	●	●
SMC's					◐	●			●	●	●
Styrene Resins					◐	●			●	●	●
Polyacrylate					◐	◐			●	●	●
Polyurea									◐		
Cellulosics (CAL, CAB, CAP)									◐		
Polysulfone									◐		
Phenolics					◐	●			◐	◐	◐
Laminates					◐	●			●	●	●
WOOD											
Woods (Hard and Soft)	●	●	●	●	●	●	●	◐	●	●	●
Plywood	●	●	●	●	●	●	●	◐	●	●	●
Particle Board	●	●	●	●	●	●	●	◐	●	●	●
OTHER											
Brick	●	●	●	●	●	●	●		●	●	●
Concrete	●	●	●	●	●	●	●		●	●	●
Rubber									●	◐	◐
Honeycomb	◐	◐	◐	◐	◐	●	●		●	●	●
Ceramics	◐	◐	◐	◐	◐	●	●		◐	●	●
Glass	●										

OEM Substrate Bonding





ADHESIVE SELECTOR GUIDE

OEM Adhesives

Product	Description	Color	Mixed Viscosity ¹ (cps)	Working time ² (minutes)	Fixture time ³ (minutes)	Functional Cure (hrs)	Operating Temp. (DRY) RANGE (°F)	Tensile Shear ⁴ (psi)	Peel Strength ⁵ (pli)	Impact Resistance (ft-lb/inch ²)
DEVCON EPOXIES										
One Minute™ Epoxy Gel	<ul style="list-style-type: none"> Thixotropic, high strength epoxy adhesive Fast fixturing 	Clear	70,000	0:45	1	1/2 - 3/4	-40 - 200	1,600	2 - 3	4.5
5 Minute® Epoxy	<ul style="list-style-type: none"> Rapid curing General purpose Clear rigid bond or coating in minutes Bonds metals, fabrics, ceramics, wood and concrete 	Clear	10,000	3 - 6	10 - 15	3/4 - 1	-40 - 200	1,900	2 - 3	5.5
5 Minute® Epoxy Gel	<ul style="list-style-type: none"> Non-migrating creamy gel Fast curing Fills gaps Bonds metals and rigid substrates 	Opaque	Gel	4 - 7	10 - 15	3/4 - 1	-40 - 200	2,500	2 - 3	6.5
10 Minute™ Epoxy	<ul style="list-style-type: none"> Flexible High peel strength Ideal for aluminum, steel, brass, galvanized steel, plastics, epoxy and FRP composites 	Black/ Clear	90,000 80,000	10 10	20 20	1 1/2 1 1/2	-67 - 200 -67 - 200	2,400 2,400	20 - 25 20 - 25	10 10
2 Ton® Epoxy	<ul style="list-style-type: none"> Adhesive/potting compound High strength Non-shrinking High clarity, good impact strength and water resistance Weather and solvent resistant Wide temperature range 	Clear	8,000	8 - 12	30 - 35	2	-40 - 200	2,250	2 - 3	6.5
Epoxy Plus™ 25	<ul style="list-style-type: none"> Rubber toughened, non-corrosive structural adhesive Bonds metals, ceramics, composites and many thermoset plastics 25 minute working time 	Grey	70,000	25	210	24	-40 - 200	2,750	20 - 25	10
HP 250	<ul style="list-style-type: none"> High performance structural adhesive for assembly applications High shear strength and impact toughness High chemical, fatigue and stress resistance Bonds dissimilar substrates 	Straw	105,000	65	300	24	-67 - 250	3,200	35 - 40	12
PLEXUS METHACRYLATES										
MA8110	<ul style="list-style-type: none"> Multi-material bonder for plastics, composites & metals High strength & excellent strength retention Minimum-to-no surface preparation 	Gray	Adhesive: 40,000 - 80,000 Activator: 40,000 - 80,000	8 - 12	35 - 50	0:35	-40 - 180	3,100 - 3,600	43	112
MA8120	<ul style="list-style-type: none"> Multi-material bonder for plastics, composites & metals High strength & excellent strength retention Minimum-to-no surface preparation 	Gray	Adhesive: 40,000 - 80,000 Activator: 40,000 - 120,000	18 - 22	75 - 90	1	-65 - 280	2,500 - 3,000	43	80
PERMATEX CYANOACRYLATES										
ZipGrip® TE 1000	<ul style="list-style-type: none"> Medium viscosity Gap filling Rough toughened 	Clear	1,000	20 - 40 sec	-	24	-65 - 280	3,700	10	5
ZipGrip® TE 2400	<ul style="list-style-type: none"> Medium viscosity Gap filling High temp. Rough toughened 	Clear	2,400	20 - 40 sec	-	24	-65 - 280	3,700	10	8
ZipGrip® GPE 3	<ul style="list-style-type: none"> Fixtures in seconds Permanent Easy to apply Highly resistant to aging and weathering 	Clear	3	5 - 10 sec	-	24	-65 - 200	3,200	-	-
ZipGrip® GPE 15	<ul style="list-style-type: none"> Easy to apply Fixtures in seconds Permanent Enhanced toughness to peel and shock loads Highly resistant to aging and weathering Rubber Bonder 	Clear	15	5 - 10 sec	-	24	-65 - 200	3,200	-	-
ZipGrip® GPE 30	<ul style="list-style-type: none"> Easy to apply Fixtures in seconds Permanent Bonds to inactive surfaces All purpose [low viscosity] 	Clear	30	5 - 12 sec	-	24	-65 - 200	3,200	-	-
ZipGrip® GPE 100	<ul style="list-style-type: none"> Easy to apply Fixtures in seconds Permanent All purpose [medium viscosity] 	Clear	100	10 - 20 sec	-	24	-65 - 200	3,200	-	-

1. Viscosity: The flow properties of the material as measured by Brookfield Viscometer @ 10 RPM @ 77°F (25°C).
2. Working Time: The recommended allowable time after mixing for application of the adhesive to mate and position parts. This is to insure good surface wetting prior to the start of curing. After the working time, parts must not be disturbed.
3. Fixture Time: The time required for the parts to generate sufficient bond strength so as to be handled without deformation of the bond line.
4. All tensile shear data as per ASTM D1002 on grit-blasted cold-rolled steel @ a bond line thickness of 0.010".
5. T-peel data for epoxies tested @ 7 days cure @ 75°F per ASTM D1876 on 1" wide 0.020" abraded steel @ 20" per minute separation rate.

Devcon, ZipGrip, 2 Ton Epoxy, 5 Minute Epoxy, 10 Minute Epoxy, Epoxy Plus, One Minute Epoxy and Dev-Thane are registered trademarks of Illinois Tool Works © May, 2020 ITW Performance Polymers.

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