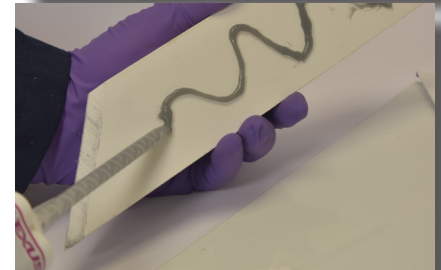


# ADHESIVE SELECTOR GUIDE

● Excellent Choice  
 ◐ Good Choice

	One Minute™ Epoxy Gel	5 Minute® Epoxy	5 Minute® Epoxy Gel	10 Minute® Epoxy	2 Ton® Epoxy	Epoxy Plus™ 25	HP 250	Dev-Thane™ 5,2	Zip Grip® Instant Adhesive	MA8110	MA8120
<b>METALS</b>											
Aluminum 1	●	●	●	●	●	●	●	●	◐	●	●
Brass	●	●	●	●	●	●	●	●	◐	●	●
Cast Iron	●	●	●	●	●	●	●	●	◐	●	●
Copper	◐	●	●	●	●	●	●	●	◐	●	●
Ferrite	◐	◐	◐	◐	◐	●	●	●	◐	◐	◐
Painted Metals	◐	◐	◐	◐	◐	◐	●	●	◐	●	●
Plated Metals				◐	◐	◐	●	●	◐	●	●
Sheet Metal				◐	●	●	●	●	◐	●	●
Stainless Steel 1	●	●	●	●	●	●	●	●	◐	●	●
Cold Rolled Steel	●	●	●	●	●	●	●	●	●	●	●
Galvanized				◐	●	◐	●	●	●	●	●
<b>PLASTICS</b>											
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					◐	●		●	●	●	●
<b>WOOD</b>											
Woods (Hard and Soft)	●	●	●	●	●	●	●	●	◐	●	●
Plywood	●	●	●	●	●	●	●	●	◐	●	●
Particle Board	●	●	●	●	●	●	●	●	◐	●	●
<b>OTHER</b>											
Brick	●	●	●	●	●	●	●	●	●	●	●
Concrete	●	●	●	●	●	●	●	●	●	●	●
Rubber								●	◐	◐	
Honeycomb	◐	◐	◐	◐	◐	●	●	●	●	●	●
Ceramics	◐	◐	◐	◐	●	●	●	●	◐	●	●
Glass	●										

# OEM Substrate Bonding





## ADHESIVE SELECTOR GUIDE

# OEM Adhesives

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

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