

ITW Performance Polymers Frequently Asked Questions

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General Questions

- If you have a question about a Devcon Home, Versachem, or ITW Consumer product, please visit the ITW Consumer website at <http://www.itwconsumer.com/> for more information.
- Where can I find a Safety Data Sheet for one of your products?
 - <https://itwperformancepolymers.com/data-sheets/safety-data-sheets>
- Do you have more detailed product information available, such as mix ratio, operating temperatures, and application instructions?
 - These can be found in our Technical Data Sheets, which are available at <https://itwperformancepolymers.com/data-sheets/technical-data-sheets>
- Where can I get pricing information or purchase one of your products?
 - Please contact one of our distributors, which can be found at <https://itwperformancepolymers.com/distributors>

Devcon:

- Can you powder coat any of the metal filled epoxies (Plastic Steel Putty, metal putties, Plastic Steel Liquid)?
 - Although nonconductive, there have been many experiences reported where the Titanium Putty has been successfully powder coated when used for small repairs such as filling unwanted holes or making good weld seams.

Plexus:

- What is the shelf life for Plexus products?
 - 7 months at 24°C for most one to one formulations, and up to 13 months for many ten to one systems. Please refer to each product Technical Data Sheet for specifics <https://itwperformancepolymers.com/data-sheets/technical-data-sheets>
- What is the typical Shore hardness of Plexus products?
 - 65 to 78 Shore D. The majority of Plexus products tend to be approximately 72 Shore D.
- What happens if I Freeze Plexus? Can I still use it?
 - If frozen, Plexus products will become very rigid, but still pliable. If you allow frozen product to heat back up to room temperature, nearly all Plexus materials will return to their original form and perform as expected. As a result, they may be used. If a product does not look smooth after recovering, it is not recommended to be used without first testing to ensure a proper cure.
- Can I store Plexus products above 24°C (75°F)?
 - Yes, for a short period of time. The product's catalyst, which is a peroxide, degrades with time and temperature. So, the warmer you store it, the shorter it will last. Please see the specific product's Technical Data Sheet for recommended storage conditions <https://itwperformancepolymers.com/data-sheets/technical-data-sheets>
- Why is my Plexus product creating vapors when applied?
 - You are likely using the product within a joint larger than it was designed for, or you have a large amount of squeeze-out exceeding the gap capability of the particular Plexus product. Please see the product's Technical Data Sheet for recommended gap sizes.
- How do I reduce my usage of Plexus product?
 - Try to minimize your bond line gap. A narrower bond line will not only help save on adhesive and cost but will lower your product's weight and produce a higher quality final part.
- I see an indent/warpage on my part directly above where the adhesive was applied. What is this, and how can I minimize or eliminate this effect?

- This effect is called “print-through” or “read-through”. This can occur when the adhesive has reacted to the softening temperature of a substrate, or when upon curing the adhesive has shrunk, pulling the part down at the application site. To reduce or eliminate this phenomenon, try reducing your bond line gap. This will create a lower reaction temperature, leave less product to shrink, and lower your overall part cost. If this does not reduce or eliminate this effect, please see our product selection for a lower shrink product or contact our Technical Services department for assistance.

Chockfast:

- What is the minimum required hardness for:
 - Chockfast Orange Barcol Hardness: min. 35
- What are the limits in chock heights, lengths, and widths?
 - Chockfast Orange 12 mm – 100 mm (½” – 4”), depending on temperature and mass of steel
 - Chockfast Gray 12 mm – 50 mm (½” – 2”)
 - For exceptions, please contact ITW Performance Polymers Technical Services
- Could you support us to calculate the required quantity of Chockfast?
 - We recommend the following for calculations:
 - For Chockfast #692g and basic chocking procedure, please visit <https://itwperformancepolymers.com/products/chockfast>

Korrobond:

- The Resin has settled / separated in the pail, what do I do?
 - Some settling is normal with this product. Use of a Jiffy mixer or suitable alternative to homogenize the resin before the addition of the hardener is important to ensure best results with the cured material.
- How quickly can I return my crusher to service after pouring the backing?
 - This will depend on temperature. Further information can be found in the Korrobond 65 Application Guideline.

Irathane Futura:

- Which Primer do I need for my coating?
 - Please get in touch to discuss your specific application in more detail and we can recommend the most suitable primer for your substrate and chosen system.
- What equipment do I need to apply Protec II, Styrothane, or 155HS?
 - Detailed information on the application equipment requirements can be found in the relevant TDS and Method Statements. If there is still any uncertainty, please contact Technical Service.
- Can I pigment the 155HS?

- What can be achieved is dependent on the required colour. You can pigment 155HS black or darker grey, but other colours are not possible. Pigment paste suitable for a PU can be used and may be added to the mixed P and C components up to 3%.

Epocast:

- What is the minimum required hardness for:
 - EPOCAST 36®: Barcol Hardness: min. 40
 - EPOCAST 36-P: Barcol Hardness: min. 30
 - TG7B Paste: Barcol hardness: 30-34 Barcol
 - TG7B Liquid: Barcol hardness: 40-50 Barcol
- What are the limits in chock heights, lengths, and widths?
 - See TDS/TBS/Handbook:
 - EPOCAST 36®: 12 mm – 100 mm
 - For exceptions please consult Technical Service
- Could you support us to calculate the required quantity of Epocast?
 - We recommend the following for calculations:
 - EPOCAST MARINE Handbook
- What are the required accessories and where can we purchase these?
 - Chocking products:
 - Barcol Tester 934-1 / Barcol Test shims 43-48
 - Release Agent: <https://www.gebr-barth.de/>
 - Foam Rubber <https://www.gebr-barth.de/> or
 - Global Alignment <http://www.globalalignment.de/>
 - CELLOFLEX-M:
 - Primer S <https://www.gebr-barth.de/> or Euroteam <https://www.euroteam-bauchemie.de/>
 - Cleaner from <https://www.gebr-barth.de/>
 - 100 m Glass silk tape Rowing 10 cm / wide <https://www.gebr-barth.de/>