

# 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>
- How do I find the date of manufacture for one of your products?
  - For many products, this will be part of a six-digit lot number on the packaging that reads as follows:
    - For the first format (commonly found on Plexus and Devcon products), use lot #901231 as an example:
      - The first digit is the year after 2010, so 9 indicates 2019
      - The second and third digits are the month, so 01 indicated January
      - The fourth and fifth digits are the date, so 23 indicates the 23<sup>rd</sup>
      - The sixth number is the batch number, so 1 indicates batch #1
    - Another format (for some Plexus products) may be SDDMMX, where DD is the date, MM is the month, and X is the batch number.
    - Some Chockfast products may be formatted as follows:
      - 010519-111 → resin side date of manufacture is 05/01/2019
      - XXXXMMYY → XXXX is the part indicator and batch number, (for example, SG11 for Chockfast Red SG batch 11) MM is the month, and YY is the year

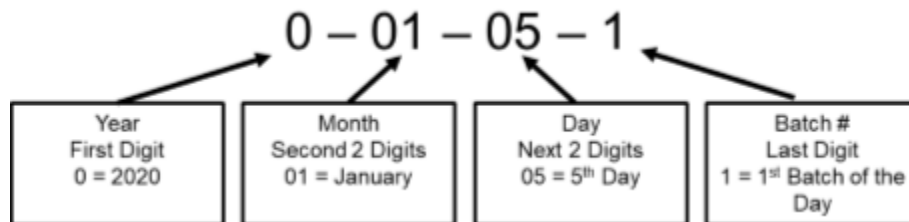
- For most other products, the date of manufacture and expiration will be printed directly on the packaging.
- If you have a product that does not have any of these kinds of markings, please contact Technical Service for information.
- Can your products bond to Polyethylene, Polypropylene, or Delrin?
  - We currently do not have any products that are able to bond these materials.

**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:**

- **Shelf Life** - What is the shelf life for PLEXUS® products?
  - 7 months at 24°C for most 1:1 mix ratio formulations, and up to 13 months for many 10:1 mixed systems. Please refer to each product Technical Data Sheet for specifics <https://itwperformancepolymers.com/data-sheets/technical-data-sheets>
- **Lot Numbers** – How do I read the lot numbers for PLEXUS® products?
  - For many products, this will be part of a six-digit lot number on the packaging that reads as follows:  
For the first format (commonly found on Plexus and Devcon products), use lot #901231 as an example:
    - The first digit is the year after 2020, so 0 indicates 2020
    - The second and third digits are the month, so 01 indicated January
    - The fourth and fifth digits are the date, so 05 indicates the 05<sup>th</sup>
    - The sixth number is the batch number, so 1 indicates batch #1



- **SDS** - Where can I find a Safety Data Sheet for one of your products?
  - <https://itwperformancepolymers.com/data-sheets/safety-data-sheets>
- **Product Details** - 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>

- **Shore Hardness** - 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.
- **Frozen Product** - 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.
- **Storage** - 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>
- **Boiling** - 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.
- **Reduce usage** - 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.
- **Compatible Cleaners** - What are the compatible cleaners for cleaning substrates prior to bonding?
  - PC120 is the recommended cleaner/conditioner, but Acetone, Isopropyl Alcohol, , Toluene, MEK and some Terpene's are all compatible cleaners with PLEXUS®.
- **Reduce Print Through** - I see an indent/warp on my part directly above where the adhesive was applied. What is this, and how can I minimize or eliminate this effect?
  - 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.
- **Usage per Cartridge (or Gallon)** – How many linear feet can I bond, The Table below is an approximate based on a rounded bead size as shown and is only a guide. Amounts for an application should be calculated by volume based on bead size and gap.

		Ft per Unit of Measure			
		Unit of Measure	400ml cartridge	490ml cartridge	Per Gallon
Bead Size	1/8"		331.5	406.1	3136.8
	1/6"		186.5	228.5	1764.8
	1/5"		129.5	158.6	1225.4
	1/4"		82.9	101.6	784.4
	1/3"		46.6	57.1	441.0
	2/5"		32.4	39.7	306.6
	1/2"		20.7	25.4	195.9

**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 or 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/>