Technical Data Sheet
Version 3. 04/2023

Food Grade Pot & Seal

Description: Two-component adhesive for bonding aluminum, steel, stainless steel, and alloys of steel cloth. Approved for dry food contact.

Intended Use: Industrial Use: Bonding aluminum, stainless steel, and alloys of steel.

Features:
Excellent chemical, heat and water resistance
Thermal shock resistance

Limitations: Suitability of product is determined by the end user for their application and process.
Requires heat curing to attain full physical properties.

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 (24°C)	Typical Values	Standard Tests
Dielectric Strength	460 volts/mil (18 kV/mm)	
Gap Fill	Excellent	
Impact Resistance	5.2 ft-lb/in2 (10.9 kJ/m2)	
Service Temperature	-40°F to 275°F (-40°C to 135°C)	
Shore Hardness	82 Shore D	
Solids by Volume	100	
Specific Vol	22 in3/lb (0.795 cm3/g)	
Tensile Elongation	1%	
Tpeel	2-3 pli (0.35-0.53 N/mm)	

Uncured	
Color	White
Heat Cure 10 min. @ 200°F	1,940 psi (13.38 MPa)
Heat Cure 15 min.@180°F	1,980 psi (13.65 MPa)
Mix Ratio by Volume	4:1
Mix Ratio by Weight	4:1
Mixed Density	10.5 lb/Gal (1.26 g/cm3)
Mixed Viscosity	100,000 cP
Working Time	42 min. [28 g @ 72°F/22°C]

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. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength.

Homogenous mixing of resin and hardener is essential for the curing and development of stated strengths.

Mixing Instructions:

25 ML DEV-TUBE
1. Squeeze material into a small container the size of an ashtray.
2. Using mixing stick included on Dev-tube handle, vigorously mix components for one (1) minute.
3. Immediately apply to substrate.

50 ML/400ML/490 ML CARTRIDGES
1. Attach cartridge to Mark V ™ [50ml] 400ml manual or pneumatic dispensing systems.
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to substrate.

Application Instructions:
1. Apply mixed epoxy directly to one surface in an even film or as a bead.
2. Assemble with mating part within recommended pot life.
4. Obtain firm contact between the parts to minimize any gap and ensure good contact of the epoxy with the mating part.

-Surface Preparation-

All surfaces must be clean, dry and oil free before applying adhesive to the surface. Use MEK, or Isopropanol to wipe clean contaminants from the surface
Metal surfaces should be abraded using an abrasive pad for maximum surface profile. This will increase adhesion to the metal surface.

-Heat Curing Guidelines -
Curing will vary on application and thickness. This product must be heat cured for the adhesive to reach full physical properties. The product must be cured at one of the following conditions:

15 minutes @ 180°F Wait to release tension on screen until metal is cooled
12 minutes @ 190°F Wait to release tension on screen until metal is cooled
10 minutes @ 200°F Wait to release tension on screen until metal is cooled

NOTE: Surface temperature must be maintained at the metal surface to attain the curing speeds stated above.

-Post Cured Guidelines-
After curing the adhesive at the above temperatures, the adhesive must be allowed to cool, for at least 15 minutes before releasing any tension on the screens. This cooling down process is mandatory for the adhesive to attain full strength.

Depress with your fingernail the metal ring to check cure hardness. If an impression is left onto the surface wait longer until material is fully cured with no depression.

NOTE: Excess heat may cause shrinkage, and discoloration.

Storage: Store in a cool, dry place.

Compliances: None

Chemical Resistance: Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F (24°C)

Acetic (Dilute) 10%	Very good
Ethanol	Very good
Glycols/Antifreeze	Excellent
Methanol	Fair
Motor Oil	Excellent
Sodium Hydroxide 10%	Excellent
Toluene	Very good
Xylene	Excellent

Precautions: **FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate **S**afety **D**ata **S**heet prior to using this product.

Warranty: ITW Performance Polymers 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.

Order Information:

Item No.	**Package Size**
DA999	400ml cartridge White

Contacts:

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