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## 2 Ton® Epoxy Clear Weld Epoxy Technical Data Sheet

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**PRODUCT DESCRIPTION:** Extremely strong, non-shrinking adhesive compound specially formulated for high clarity, good impact strength and water resistance. Available in tubes, bottles, Dev-Tube, or Flow-Mix® system.

**WORKS BEST ON:** Metal, wood, concrete, glass, ceramics, china, fiberglass, chrome. DO NOT USE ON AREAS THAT WILL COME IN CONTACT WITH FOOD RELATED ITEMS.

**PRODUCT FEATURES:**

Tensile Strength: 2,500 psi

Color: Clear

Waterproof

Working Time: 30 minutes

Set Time: 30 minutes

Can be Handled In: 2 hours

Full Bond: 8-12 hours

Temperature Range: -40°F - 200°F

Chemical Solvent Resistance: saturated salt solution, unleaded gasoline, mineral spirits, oil, anti-freeze.

**Epoxies are generally not recommended for long term exposure to chemicals and solvents.**

Storage: Store in a cool, dry environment.

**SURFACE PREPARATION:** Remove all dirt, oil, grease, and etc. Gently roughen, alcohol wipe, and dry. Prepare both repair surfaces; but only need to apply epoxy to one surface.

**REMOVAL METHODS:** (test inconspicuous area of product to be sure chemicals do not harm surface) Before the epoxy is allowed to dry, remove excess epoxy immediately with a damp cloth. Isopropyl alcohol or mineral spirits can be use.

After cure:

Metal/Ceramic/Glass: heat in excess of 350°F, this will weaken the epoxy. Sand, file or chip where possible. Solvents that can be used: isopropyl alcohol, acetone, methylene chloride or other solvent.

Fabric: Before cure, immediately flush with warm water. Once cured it is impossible to remove from fabric.

Wood: Sand cured epoxy from wood.

**HELPFUL HINTS:** Heat is generated while the epoxy mixture cures. The more epoxy and hardener that is mixed together, the more heat that is generated causing the epoxy mixture to cure faster. Only mix the amount of epoxy and hardener together that can be used within the working time.

Equal portions of the hardener and resin must be thoroughly mixed together in order for this product to cure properly. The most common problem with a two-part epoxy product is not mixing it thoroughly; it will not cure and will remain tacky. It is recommended that these epoxies be mixed on a clean surface (such as a paper cup, in the inside of the blister it is packaged on or etc.); do not mix it directly on the surface to be repaired. Once the product is thoroughly mixed, it can be applied to the repair area(s). *Please note, during the mixing process, be sure to scrape the sides and bottom into the mixture so that you are mixing all of the epoxy resin and hardener together.*

Thinning is possible with denatured alcohol; mix the epoxy and hardener together first then mix in the denatured alcohol. This is good for getting rid of air bubbles. It also makes the product clearer and slightly changes the product making it more flexible. NOTE: this will also change the tensile strength.

Removable tape is good for putting on an area that you don't want any epoxy to get on. Before the epoxy cures, remove the tape.

Can mix colored chalk with epoxy to repair enamel and china that has been nicked. Can also add color pigment concentrate to add color. (Add to mixed epoxy.)

**See MSDS for more complete information, safe handling instructions and first aid.**

Consumer Commodity ORM-D

Part Numbers: 23145, 31345, 33345, 35345, 47609



The technical data contained herein are intended as a reference only