

# EBW Part #11372-01

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## Epoxy Sealant Application Instructions

This epoxy product is suitable for joining or sealing iron, steel, aluminum, bronze, copper, and thermoset phenolic and epoxy plastics. It has good impact and peel strength along with excellent chemical resistance provided that the following application instructions are followed. This product is suitable for use with unleaded gasoline with additives to 20%, diesel fuel and motor oils.

**Warning**  **This product is not to be used with ethanol blends exceeding 20%.**

Color – Black

Mix Ratio – 1/1 (use self mixing dispenser tubes)

Working Time – 10 minutes @ 75 F – Less in higher temperatures

Functional Cure Time – 90 minutes @ 75 F – More in colder temperatures

This sealant is utilized during the assembly of numerous EBW components. Follow the detailed installation instructions received with the component to be assembled to identify the joints, fasteners, etc. that require sealant.

### **Application Steps**

1. Pre-assemble all components to assure proper fit prior to applying epoxy sealant. Sealant has only a 10 minute working time.
2. Clean (vapor phase degreasers or hot aqueous solution) application surfaces of all grease, oils and heavy contaminants.
3. Abrading or roughening application surfaces with file, steel wool or sanding paper will increase the microscopic bond significantly.
4. Dispense a bead on application surface and spread with a clean stick or other flat tool. Mixing tube will properly mix both components, no additional mixing is necessary.
5. After assembly of parts, sealant must be allowed to reach it's functional cure time in free air prior to placing components into service. Normally, at 75 F, this time is 90 minutes. In colder climates, either move assemblies inside or allow to cure for up to three hours prior to use.
6. If it is necessary, heavy build up of sealant may be sanded or filed after the functional cure time and prior to installing into service.

**Note:** M.S.D.S. information may be obtained from [www.devcon.com](http://www.devcon.com) or calling 978-777-1100. Reference Devcon "10 Minute Epoxy, part #0046".



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