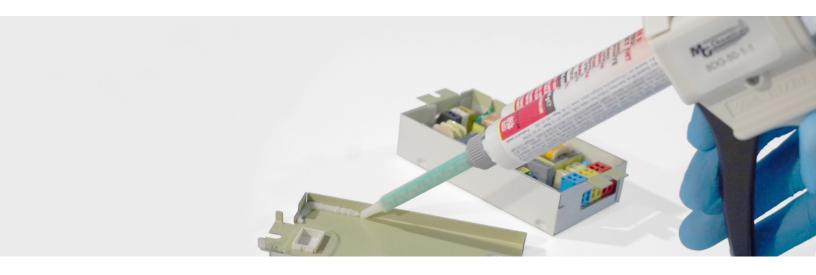
Bonding Adhesives





Bonding Adhesives for Industrial Applications

MG Chemicals bonding adhesives provide significant bond strength to similar and dissimilar substrates. They are used in a wide range of industrial applications where long-lasting load bearing joints are required.

Features & Benefits

- · Strong adhesion to a variety of substrates
- Excellent chemical and moisture resistance
- · Exceptional durability and toughness
- Excellent sealing capacity against unwanted liquids and gases
- Weight and cost reduction through elimination of conventional metal fasteners

Applications

- · Automobile body panels
- · Bonding to vertical surfaces
- Battery assembly (cell-to-cell or cell-to-carrier)
- · Aircraft structural adhesives
- Surface mount technology
- · Gap filling, potting, and sealing
- · Bonding windows

1-Part

9310 • Surface mount adhesive

· Unlimited working time

2-Part

9200 • Structural, standard adhesive

• 30 min working time

8332 • Fast set epoxy, 5 min w.t.

• 5 min working time

Dispensing accessories

Dispensing Gun • 8DG-50-1-1

Mixing Tips • 8MT-50 (standard)

• 8MT-50-FT (fine flow)



Bonding Adhesives



	8332	9200	9310
UNCURED PROPERTIES			
Number of components	2	2	1
Mixed density [g/mL]	1.14	1.25	1.15
Working time	3 to 5 min	30 min	Unlimited
RT cure [h]	5	48	_
Heat cure [min @ °C]	15 @ 65	960 @ 40	30 @ 100
	_	90 @ 65	10 @ 120
	_	60 @ 80	_
	_	15 @ 100	_
CURED PROPERTIES			
Resistivity [Ω·cm]	1.7 x 10 ¹⁴	2.5 x 10 ¹³	9.3 x 10 ¹²
Breakdown voltage [V]	23 200	41 500	41 600
Dielectric strength [V/mil]	250	503	220
Service temperature range [°C]	-40 to 150	-40 to 150	-55 to 140
Glass transition temperature (Tg) [°C]	64	44	113
CTE prior Tg [ppm/°C]	76	95	56
CTE after Tg [ppm/°C]	175	215	185
Color	Light yellow	Grey yellow	Yellow
Hardness	82D	76D	84D
Tensile strength [N/mm²]	34	16	9.4
Compressive strength [N/mm²]	63	64	103
Lap shear (stainless steel) [N/mm²]	4.9	20	8.5
Lap shear (aluminum) [N/mm²]	5.9	22	6.2
AVAILABLE PACKAGING			
Net contents	25 mL (dual-syringe)	25 mL (dual-syringe)	10 mL (syringe)
	46 mL (dual-cartridge)	45 mL (dual-cartridge)	300 mL (cartridge)





