



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
- 9201**
- Structural, high tensile strength
 - 50 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)



	8332	9200	9201	9310
UNCURED PROPERTIES				
Number of components	2	2	2	1
Mixed density [g/mL]	1.1	1.3	1.3	1.2
Working time	3 to 5 min	30 min	50 min	Unlimited
RT cure [h]	5	48	48	—
Heat cure [min @ °C]	15 @ 65	960 @ 40	—	30 @ 100
	—	90 @ 65	30 @ 65	10 @ 120
	—	60 @ 80	15 @ 80	—
	—	15 @ 100	10 @ 100	—
CURED PROPERTIES				
Resistivity [Ω -cm]	1.7×10^{14}	2.5×10^{13}	1.4×10^{13}	9.3×10^{12}
Breakdown voltage [V]	23 200	41 500	49 270	41 600
Dielectric strength [V/mil]	250	503	394	220
Service temperature range [°C]	-40 to 150	-40 to 150	-40 to 150	-55 to 140
Glass transition temperature (T _g) [°C]	64	44	42	113
CTE prior T _g [ppm/°C]	76	95	86	56
CTE after T _g [ppm/°C]	175	215	216	185
Color	Light yellow	Grey yellow	Biege	Yellow
Hardness	82D	76D	79D	84D
Tensile strength [N/mm ²]	34	16	23	9.4
Compressive strength [N/mm ²]	63	64	110	103
Lap shear (stainless steel) [N/mm ²]	4.9	20	20	8.5
Lap shear (aluminum) [N/mm ²]	5.9	22	26	6.2
AVAILABLE PACKAGING				
Net contents	25 mL (dual-syringe) 46 mL (dual-cartridge)	25 mL (dual-syringe) 45 mL (dual-cartridge)	25 mL (dual-syringe) 45 mL (dual-cartridge)	10 mL (syringe) 300 mL (cartridge)

