



## 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)



	8332	9200	9310
<b>UNCURED PROPERTIES</b>			
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 90 @ 65 60 @ 80 15 @ 100	30 @ 100 10 @ 120 — —
<b>CURED PROPERTIES</b>			
Resistivity [ $\Omega$ -cm]	$1.7 \times 10^{14}$	$2.5 \times 10^{13}$	$9.3 \times 10^{12}$
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 ( $T_g$ ) [°C]	64	44	113
CTE prior $T_g$ [ppm/°C]	76	95	56
CTE after $T_g$ [ppm/°C]	175	215	185
Color	Light yellow	Grey yellow	Yellow
Hardness	82D	76D	84D
Tensile strength [N/mm <sup>2</sup> ]	34	16	9.4
Compressive strength [N/mm <sup>2</sup> ]	63	64	103
Lap shear (stainless steel) [N/mm <sup>2</sup> ]	4.9	20	8.5
Lap shear (aluminum) [N/mm <sup>2</sup> ]	5.9	22	6.2
<b>AVAILABLE PACKAGING</b>			
Net contents	25 mL (dual-syringe) 46 mL (dual-cartridge)	25 mL (dual-syringe) 45 mL (dual-cartridge)	10 mL (syringe) 300 mL (cartridge)

