

Structural Adhesives — 2 Part Epoxy



Creates long lasting load bearing joints

Features and Benefits:

- Toughened, smooth, thixotropic paste
- 1:1 Mix Ratio
- Sag resistant, can be used on vertical surfaces
- Very strong adhesion
- Resists vibration
- Resistant to temperature cycling
- Excellent chemical resistance
- Low shrinkage

Applications:

- Creating load bearing joints
- Bonding dissimilar materials
- Gap filling
- Bonding to sheet molding compound (SMC)
- Bonding to Glass-reinforced plastics (GRP)

We offer a choice of two Structural Adhesives:

9200 Structural Epoxy Adhesive

- Offers superior tensile, compressive, and lap shear strength
- Choose when a toughened adhesive with maximum mechanical properties is required.

9200FR Flame Retardant Structural Epoxy Adhesive

- Meets UL 94 V-0
- Use when a self extinguishing toughened adhesive is required.



Structural Epoxy Adhesives Comparison Chart

	9200	9200FR
UNCURED PROPERTIES		
Mix ratio by volume	1:1	1:1
Mixed density	1.25 g/mL	1.25 g/mL
CURED PROPERTIES		
Application Parameters		
Working life	30 min	30 min
Full cure @22 °C (72 °F)	48 h	48 h
Full cure @40 °C (104 °F)	16 h	16 h
Full cure @65 °C (149 °F)	1.5 h	3 h
Electrical Properties		
Breakdown voltage @3.175 mm	51 000 V [51 kV]	50 000 V [50 kV]
Dielectric strength @3.175 mm	408 V/mil [16.1 kV/mm]	400 V/mil [15.7 kV/mm]
Volume resistivity	2.5 x 10 ¹³ Ω·cm	1.1 x 10 ¹³ Ω·cm
Thermal Properties		
Constant service temperature	-40 to 150 °C [-40 to 302 °F]	-40 to 150 °C [-40 to 302 °F]
Glass transition temperature (T _g)	44 °C [100 °F]	59 °C [138 °F]
CTE prior T _g	95 ppm/°C [203 ppm/°F]	79 ppm/°C [174 ppm/°F]
CTE after T _g	215 ppm/°C [419 ppm/°F]	126 ppm/°C [259 ppm/°F]
Thermal conductivity @25 °C (75 °F)	0.3 W/(m·K)	0.4 W/(m·K)
Thermal diffusivity @25 °C (75 °F)	0.2 mm ² /s	0.2 mm ² /s
Specific heat capacity @25 °C (75 °F)	1.4 J/(g·K)	1.5 J/(g·K)
Physical Properties		
Color	Yellowish grey	Light yellow
Hardness	76D	78D
Tensile strength	16 N/mm ² [2 400 lb/in ²]	13 N/mm ² [1 800 lb/in ²]
Compressive strength	64 N/mm ² [9 300 lb/in ²]	46 N/mm ² [6 700 lb/in ²]
Lap shear (stainless steel)	20 N/mm ² [2 900 lb/in ²]	14 N/mm ² [1 900 lb/in ²]
Lap shear (aluminum)	22 N/mm ² [3 200 lb/in ²]	10 N/mm ² [1 500 lb/in ²]

Refer to TDS for more information. N/A=Not Available.

Available Packaging



Dual Syringes
9200-25ML
9200FR-25ML



Dual Cartridges
9200-50ML
9200FR-50ML



Dispensing guns and additional mixing tips sold separately.