

General Adhesive Comparison Chart

	8332	9200	9200FR
UNCURED PROPERTIES			
Mix ratio by volume	1:1	1:1	1:1
Mixed density	1.14 g/mL	1.25 g/mL	1.25 g/mL
CURED PROPERTIES			
Application Parameters			
Working life	3–5 min	30 min	30 min
Set time	8–10 min	N/A	N/A
Functional cure @22 °C (72 °F)	3 h	N/A	N/A
Full cure @22 °C (72 °F)	5 h	48 h	48 h
Full cure @40 °C (104 °F)	N/A	16 h	16 h
Full cure @65 °C (149 °F)	15 min	1.5 h	3 h
Electrical Properties			
Breakdown voltage @3.175 mm	27 100 V [27.1 kV]	51 000 V [51 kV]	50 000 V [50 kV]
Dielectric strength @3.175 mm	217 V/mil [14.6 kV/mm]	408 V/mil [16.1 kV/mm]	400 V/mil [15.7 kV/mm]
Volume resistivity	$1.7 \times 10^{14} \Omega \cdot \text{cm}$	$2.5 \times 10^{13} \Omega \cdot \text{cm}$	$1.1 \times 10^{13} \Omega \cdot \text{cm}$
Thermal Properties			
Constant service temperature	-40 to 150 °C [-40 to 302 °F]	-40 to 150 °C [-40 to 302 °F]	-40 to 150 °C [-40 to 302 °F]
Glass transition temperature (T_g)	64 °C [147 °F]	44 °C [100 °F]	59 °C [138 °F]
CTE prior T_g	76 ppm/°C [169 ppm/°F]	95 ppm/°C [203 ppm/°F]	79 ppm/°C [174 ppm/°F]
CTE after T_g	175 ppm/°C [347 ppm/°F]	215 ppm/°C [419 ppm/°F]	126 ppm/°C [259 ppm/°F]
Thermal conductivity @25 °C (75 °F)	N/A	0.3 W/(m·K)	0.4 W/(m·K)
Thermal diffusivity @25 °C (75 °F)	N/A	0.2 mm ² /s	0.2 mm ² /s
Specific heat capacity @25 °C (75 °F)	N/A	1.4 J/(g·K)	1.5 J/(g·K)
Physical Properties			
Color	Clear	Yellowish grey	Light yellow
Hardness	82D	76D	78D
Tensile strength	34 N/mm ² [5 000 lb/in ²]	16 N/mm ² [2 400 lb/in ²]	13 N/mm ² [1 800 lb/in ²]
Compressive strength	63 N/mm ² [9 100 lb/in ²]	64 N/mm ² [9 300 lb/in ²]	46 N/mm ² [6 700 lb/in ²]
Lap shear (stainless steel)	4.9 N/mm ² [710 lb/in ²]	20 N/mm ² [2 900 lb/in ²]	14 N/mm ² [1 900 lb/in ²]
Lap shear (aluminum)	5.9 N/mm ² [860 lb/in ²]	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