

## 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 UL94V-0. Use when a self extinguishing toughened adhesive is required.*



## Structural Epoxy Adhesives Comparison Chart

Cat. Number	9200	9200FR
<b>Uncured Working Properties</b>		
Mix Ratio by Volume (A:B)	1:1	1:1
Viscosity @25 °C [77 °F]	Thixotropic paste	Thixotropic paste
Working Time	30 min	30 min
Full Cure @ 22 °C [72 °F]	24 h	24 h
Full Cure @ 65 °C [149 °F]	3 h	3 h
<b>Cured Properties</b>		
Color	Yellowish grey	Light yellow
Density @25 °C [77 °F]	1.23 g/mL	1.29 g/mL
Hardness	76D	78D
<b>Mechanical Properties</b>		
Tensile Strength	16 N/mm <sup>2</sup>	13 N/mm <sup>2</sup>
Compressive Strength	64 N/mm <sup>2</sup>	46 N/mm <sup>2</sup>
Lap Shear Strength (Stainless Steel)	20 N/mm <sup>2</sup>	14 N/mm <sup>2</sup>
<b>Electrical Properties</b>		
Volume Resistivity	2.5 x 10 <sup>13</sup> Ω·cm	1.14 x 10 <sup>13</sup> Ω·cm
Breakdown Voltage @3.175 mm [1/8"]	51 kV	50 kV
Dielectric Strength @3.175 mm [1/8"]	16.1 kV/mm	15.7 kV/mm
<b>Thermal Properties</b>		
Thermal Conductivity @25 °C [77 °F]	0.31 W/(m·K)	0.40 W/(m·K)
Glass Transition Temperature (T <sub>g</sub> )	44 °C [111 °F]	59 °C [138 °F]
CTE prior T <sub>g</sub>	95 ppm/°C	79 ppm/°C
CTE after T <sub>g</sub>	215 ppm/°C	126 ppm/°C

## Available Packaging



**Dual Syringes**  
9200-25ML  
9200FR-25ML



**Dual Cartridges**  
9200-50ML  
9200FR-50ML



*Dispensing guns and additional mixing tips sold separately.*