



PARSON ADHESIVES, INC.

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PARTITE 9325 Acrylic Structural Adhesive

PARTITE 9325 a no-mixing, 100% reactive, high strength adhesive designed for bonding wide variety of metals and ceramic close fitting rigid parts. It bonds wide range of materials with the use of Activator 1075.

FEATURE:

- No mixing required. Only contacting together.
- Adhesive is applied to one surface and Activator to the other; press together and fixing is achieved within few minutes.
- High impact resistance, good peel and tensile strength. Excellent resistance to gasoline, lubricants, water, solvents, etc.
- 100% solid, Low odor, low irritating, non-flammable.

APPLICATIONS:

- Ideal for bonding ferrite to plated metals in electric motors and speaker assembly. Excellent adhesion to Metals, Ferrite, Plastics, Glass, Ceramic, Wood, etc.
- Ideal for fuel-pump assembly, electric motors, speaker assembly, Automotive Components, Electronics Parts, Appliances, etc.

ADHESIVE PROPERTIES

Liquid

Composition	Modified Urethane
Appearance	Light Amber liquid
Viscosity	12, 000 to 22,000 mPa.s
@ 25 °C, Brookfield RVT	
Flash Point (TCC), °C	> 88
Specific Gravity @ 25°C	1.08
Cure Speed @ 25 °C	5 - 15 minutes
Functional Strength	30 – 60 minutes

Cured Adhesive

Gap Filling	0.05 – 1.0 mm
Shear Strength	2, 600 – 3, 000 psi
DIN 53283	
Peeling Strength	2 – 3 N/mm
Tensile Strength	2200 psi
ASTM D412	



% Elongation at break 140
ASTMD412
Modulus, ASTM D638 45,000 psi

Physical Properties:

Temperature Range, °C - 50 to 120
Dielectrical Constant DIN 53483 (Mhz) 4.6
Coefficient of Thermal Expansion, ASTM D696, K⁻¹ 80 x 10⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m⁻¹k⁻¹ 0.1

Resistance Properties:

Shear strength of steel after heat aging for 1000 hours, % retention:

At 95 °C	112	at 125 °C	119
At 149 °C	134	at 210 °C	85

Chemical resistance:

Chemicals	Temperature °C	% Initial Strength
Brake Fluid	90	10
Gasoline	90	28
Motor Oil	90	107
Glycol Solution	90	117

APPLICATION INSTRUCTIONS

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- To perform reliable cure Activator 1075 should be applied to one of the bond surfaces and the adhesive to the other surface. Where bond gaps are larger or faster cure speed is required, activator should be applied to both surfaces. Parts should be bond assembled within 15 minutes.
- Excess adhesive can be wiped away with organic solvent. Adhesive bond should be allowed to develop full strength before subjecting to any service loads.

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the product.

Warranty: All products purchased from or supplied by Parson are subject to terms and conditions set out in the contract. Parson warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Parson is consider accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Parson makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will nor infringe any patent.