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PARTITE 9326
Acrylic Structural Adhesive

PARTITE 9326 a no-mixing, high viscosity combined with faster cure speed structural adhesive for wide variety of industrial assembly applications. It bonds wide range of materials with the use of Activator 1165.

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.
- Low odor, low irritating, non-flammable.

APPLICATIONS:

- Ideal for bonding Metals, Ferrite, Plastics, Glass, Ceramic, Wood, etc.
- Ideal for Speaker Assembly, Electric motors, Automotive Components, Sporting goods, Electronics Parts, Tool handles, Appliances, Computer Assemblies, Electrical Components, etc.

ADHESIVE PROPERTIES

Liquid

Composition	Methacrylate Ester
Appearance	Light Amber liquid
Viscosity @ 25 ^{0}C, Brookfield RVT	8,000 – 20,000 mPa.s
Flash Point (TCC), ^{0}C	> 88
Specific Gravity @ 25^{0}C	1.06
Cure Speed @ 25 ^{0}C	1 – 3 minutes
Functional Strength	30 – 60 minutes

Cured Adhesive

Gap Filling	0.05 – 1.0 mm
Shear Strength DIN 53283	15-25 N/mm^2
Peeling Strength	3 – 5 N/mm
Tensile Strength DIN 53288	30 - 34 N/mm^2
Elongation, % ASTM D 412	138

Physical Properties:

Temperature Range, ^{0}C	- 50 to 120
Dielectrical Constant DIN 53483 (Mhz)	4.6
Dielectric Strength ASTM D149, kV/mm	30
Coefficient of Thermal Expansion, ASTM D696, K^{-1}	80 x 10^{-6}
Coefficient of thermal conductivity, ASTM C177, $W.m^{-1}k^{-1}$	0.1

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 per form reliable cure Activator 1165 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.