9201

Structural Epoxy Adhesive

9201 is a 2-component epoxy structural epoxy adhesive that forms bonds capable of withstanding heavy shocks. The adhesive has high impact resistance and high strength, helping replace a wide range of mechanical techniques like welding. By avoiding joining parts with metal fasteners, the glue can help lightweight modular devices during assembly.

9201 epoxy structural adhesive bonds strongly to a variety of surfaces like metals, glass, composite and most plastics. The glue also bonds many engineered thermoplastics such as sheet molded compounds and glass reinforced plastics. The epoxy is useful for bonding dissimilar materials and cures at room temperature.

Features & Benefits

1:1 mix ratio

Excellent bond strength to a wide array of substrates

Non-sag consistency

High tensile and compressive strength

Excellent chemical resistance

Cure Instructions

Allow to cure at room temperature for 48 hours, or cure in an oven at one of these time/temperature options:

Temperature	65 °C	80 °C	100 °C
Time	30 min	15 min	10 min

Storage and Handling

Store between -10 and 27 ˚C in a dry area, away from sunlight (see SDS). To maximize shelf life, recap product firmly when not in use.

Available Packaging

Part #	Packaging	Net Vol.	Net Wt.
9201-25ML	Dual syringe	25 mL	32.7 g
9201-50ML	Dual cartridge	45 mL	58.9 g
9201-40L	Dual Pail kit	40 L	52.3 kg

Dispensing Accessories

Consult the table below for accessory selection. See the Dispensing Accessories Application Guide for usage instructions. 8MT-50-FT should only be used with a pneumatic dispenser.

Part #	Dispensing Gun	Static Mixer
9201-25ML	N/A	N/A
9201-50ML	8DG-50-1-1	8MT-50
9201-40L	N/A	N/A

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Liquid Properties

Chemistry	Epoxy	—
Density	1.3 g/mL (Mixed) 1.4 g/mL (A) 1.2 g/mL (B)	ASTM D1475
Viscosity @ 25 ˚C	TBD (Mixed) 89 250 cP (A) 36 025 cP (B)	Brookfield Engineering labs Inc. IPCTM-65- Method 2.4.24.4
Mix Ratio	1:1 (Volume) 1:1.17 (Weight)	—
Working Time [a]	50 min	—
Peak Exotherm [b]	33 ˚C	—
Shrinkage	4.1%	Calculated
Shelf Life	3 y	—

[a] Based on 100 g sample. Varies by volume and geometry.
[b] Based on a 250 g sample in a fixed container geometry.

Cured Properties

Flame Retardancy	No	—
Color	Beige	—
Density	1.4 g/mL	Hydrostatic Weighing
Service Temperature Range	-40–150 ˚C	—
Intermittent Temperature	TBD	—
Thermal Conductivity @ 25 ˚C Specfic Heat Capacity @ 25 ˚C Thermal Diffusivity @ 25 ˚C	0.4 W/(m·K) 1.1 J/(g·K) 0.3 mm^2/s	ASTM E1461
Glass Transition Temperature (T_g)	42 ˚C	ASTM E1545
Coefficient of Thermal Expansion (CTE)	86 ppm/˚C (Prior T_g) 216 ppm/˚C (After T_g)	ASTM E831
Hardness	79 D	ASTM D2240
Tensile Strength	23 N/mm^2	ASTM D638
Compressive Strength	110 N/mm^2	ASTM D695

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Cured Properties Continued

Lap Shear	20 N/mm^2 (Stainless Steel) 26 N/mm^2 (Aluminum) 3.6 N/mm^2 (ABS) 2.0 N/mm^2 (PC)	ASTM D1002
Resistivity	1.4 x 10^{13} Ω·cm	ASTM D257
Breakdown Voltage @ 3.175 mm Dielectric Strength @ 3.175 mm	49 270 V 394 V/mil	ASTM D149

Application Instructions

Read the product SDS and Application Guide for more detailed instructions before using this product.

Recommended Preparation

Clean the substrate with 824 99.9% Isopropyl Alcohol, so the surface is free of oils, dust, and other residues.

Syringe and Cartridge

1. Twist and remove the cap from the cartridge or syringe. Do not discard cap.
2. If nozzle is blocked, clean any hardened material on both the inside and outside using a needle and paper towel.
3. (Optional) Attach static mixer to the 9201-50ML.
   a. Dispense and discard 3 to 5 mL of the product to ensure a homogeneous mixture.
   b. After use, dispose of static mixer.
4. Without a static mixer, dispense material on a mixing surface or container, and thoroughly mix parts A and B together.
5. To stop the flow, pull back on the plunger.
6. Clean nozzle to prevent contamination and material buildup. Replace the cap on the cartridge.