8332

Fast Set Epoxy

8332 is a quick-set 2-part epoxy adhesive. Bonded parts need only be held together for eight to ten minutes before handling. It offers excellent adhesion to a wide range of materials that are difficult to bond with, including glass, fiberglass, concrete, ceramics, woods, and most metals and plastics

This is a general-purpose adhesive suitable for household, industrial and manufacturing applications.



Features & Benefits

Quick set time

Low shrinkage

Provides strong electrical insulation

Protects against thermal and mechanical shocks

Strong resistance to humidity, salt water, acids, bases, and aliphatic hydrocarbons

Comes in convenient dual cartridges, suitable for automated dispensing applications

Cure Instructions

Allow to cure at room temperature for 5 hours, or cure the adhesive in an oven at one of these time/temperature options:

Temperature	65 °C
Time	15 min

Storage and Handling

Store between 16 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.
8332-25ML	Dual Syringe	25 mL	28.6 g
8332-50ML	Dual Cartridge	46 mL	79.3 g

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
8332-25ML	N/A	8MT-25
8332-50ML	8DG-50-1-1	8MT-50

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Liquid Properties

Density	1.1 g/mL (Mixed)	ASTM D1475
Viscosity @ 25 ˚C	12 000 cP (A) 14 000 cP (B)	Brookfield Engineering labs Inc. IPCTM-65- Method 2.4.24.4
Working Time [a]	4 min	—
Set Time [a]	5 min	—
Functional Cure [a]	5 h	—
Mix Ratio	1:1 (Volume) 1:1 (Weight)	—
Shelf Life	5 y	—
Peak Exotherm [b]	96 °C	ASTM D2471

[a] Ambient temperature of 22 °C
[b] Based on a 20 mL sample in a fixed container geometry.

Cured Properties

Color	Translucent	—
Service Temperature Range	-40–150 ˚C	—
Breakdown Voltage	23 200 V	—
Dielectric Strength	250 V/mil	—
Resistivity	1.7 x 10^{14} Ω·cm	ASTM D257
Hardness	82 D	ASTM D2240
Tensile Strength	34 N/mm^2	ASTM D638
Compressive Strength	63 N/mm^2	ASTM D695
Lap Shear	4.9 N/mm^2 (Stainless steel) 5.9 N/mm^2 (Aluminum)	ASTM D1002
Glass Transition Temperature (T_g)	64 ˚C	ASTM E1545
Coefficient of Thermal Expansion (CTE)	76 ppm/˚C (Prior T_g) 175 ppm/˚C (After T_g)	ASTM E831
Weight Loss @ 155 °C (600 hrs)	1.9 %	–

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Application Instructions

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

Recommended Preparation

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

Syringe or Cartridge

1. Twist and remove the cap from the syringe or cartridge. 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. Dispense a small amount to ensure even flow of both parts. A manual or pneumatic dispensing gun is required for a 50 mL cartridge.
4. (Optional) Attach a static mixer.

   a. Dispense and discard 3 to 5 mL of the product to ensure a homogeneous mixture.

   b. After use, dispose of static mixer.
5. Without a static mixer, dispense material on a mixing surface or container, and thoroughly mix parts A and B together.
6. To stop the flow, pull back on the plunger.
7. Clean nozzle to prevent contamination and material buildup.
8. Re-place the cap on the cartridge or syringe or cartridge.

Disclaimer: This information is believed to be accurate. It is intended for professional end-users who have the skills required to evaluate and use the data properly. M.G. Chemicals Ltd. does not guarantee the accuracy of the data and assumes no liability in connection with damages incurred while using it.