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Product Description Sheet

Hysol® Product 9422

Industrial Products, August 2001

Description

Loctite® Hysol® 9422 is a two part, modified, low viscosity adhesive with a fast set time.

Features

Good Tensile Sheer Strength

Self Leveling

1 : 1 Ratio

Cure: Hysol 9422 can be cured by a variety of cure schedules to meet processing requirements. Full cure time at 77°F is 24 hours. Heat cures can be used to shorten this time. For instance, one hour at 160°F is sufficient to fully cure the adhesive.

Clean up: It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your solvent supplier for information pertaining to the safe and proper use of solvents.

Packaging

Five Gallon System

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Note

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Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 1 Pound mins	--	--	10
Color	Gray	Off White	Gray
Viscosity, cP	55,000 to 70,000	7,500 to 12,500	N/A
Specific Gravity	1.22	1.25	1.23
Mix Ratio			
By weight	1	1	--
By volume	1	1	--

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
3 Days @ 77°F	-40	2400
	77	2300
	150	300

Peel Strength ASTM D 3167	Etched Aluminum, pli
3 Days @ 77°F	11

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Application

Mixing: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly. Continue to mix until all gray and white streaks are gone and mix is uniformly gray. This is important! Heat build-up during or after mixing is normal. Do not mix quantities greater than one pound as excessive exotherm or heat build-up will develop. Mixing smaller quantities will minimize the heat build-up.

Application: Bonding surfaces should be clean and dry. The bonded parts should be held in contact until the adhesive is set. It not necessary to maintain fixturing for the entire cure schedule but only until handling strength is achieved.