PARTITE 7425
*Methacrylate Structural Adhesive*

PARTITE 7425 is a two-component, 100% reactive, toughened structural methacrylate adhesive specifically formulated for bonding wide variety of metals, thermoplastics, thermosets, and composite assemblies.

**FEATURE:**

- Combined at a 10:1 mix ratio, Non-sagging and thixotropic formulation.
- Excellent impact, peel and shear resistance
- No surface preparation with excellent durability.
- Working time 30 to 35 minutes and achieves 80% ultimate strength in 80 to 90 minutes.

**APPLICATIONS:**

- Ideal for bonding all types of PVC, Polycarbonate, Acrylic, Fiberglass, PBT, PPO, ABS, FRT, Polyurethane, Epoxy, Wood, RIM, Nylon, FRP, Polyesters, Gelcoats, Styrene, Stainless Steel, Carbon Steel, Galvanized Steel, etc.
- Ideal for Automotive Components, transportation industry, Sporting goods, Electronics Parts, Tool handles, Appliances, Computer Assemblies, Electrical Components, Furniture, Marine assemblies, Plastic Fabrications, Sign & Display, Composite assemblies, etc.

**ADHESIVE PROPERTIES**

<table>
<thead>
<tr>
<th>Liquid</th>
<th>Adhesive</th>
<th>Activator</th>
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<tbody>
<tr>
<td>Appearance</td>
<td>Milky-White</td>
<td>Blue</td>
</tr>
<tr>
<td>Viscosity @ 25 °C, Brookfield RVT</td>
<td>100,000 – 125,000</td>
<td>40,000 – 60,000</td>
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<tr>
<td>Flash Point (TCC), °F</td>
<td>51</td>
<td>51</td>
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<tr>
<td>Density (lbs/gal)</td>
<td>7.95</td>
<td>8.85</td>
</tr>
<tr>
<td>Mix Ratio by Volume</td>
<td>10.0</td>
<td>1.00</td>
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<tr>
<td>By Weight</td>
<td>9.0</td>
<td>1.0</td>
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</tbody>
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**Cure Characteristics**

- Working Time: 30 - 35 minutes
- Fixture Time: 80 – 90 minutes
- Full Cure: 24 hours
- Mixed Density (lbs/gal): 8.05
Coverage/lb: 148 sq.in @ .010"
Service Temperature: -40°F to 180°F

**Cured Adhesive Properties**

- **Gap Filling**: Up to 0.375 inches
- **Shore Hardness**: 73D ASTM D 2240
- **Elongation**: 125 - 140%
- **Tensile Shear Strength**: 2,200 – 2,600 psi DIN 53283
- **Peeling Strength**: 16-22 pli
- **Adhesive Tensile Shear (Steel/Steel)**: 3,550 psi ASTM D 1002
- **Adhesive Tensile Shear (Al/Al)**: >2,800 psi
- **Adhesive Tensile Shear (ABS/PVC)**: 1,600 psi
- **Adhesive Tensile Shear (Fiberglass)**: > 1,550 psi
- **Impact Resistance**: 21 ft.lb./in.

**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.
- Proper mixing is required for the curing and adhesive strength development.
- Excess adhesive can be wiped away with organic solvent. Adhesive bond should be allowed to develop full strength before subjecting to any service loads.

**Packaging:**

PARTITE 7425 is available in 380 ml cartridge, 5 gallon and 50 gallon kit.

**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 considered 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 not infringe any patent.