



PARTITE **METHACRYLATE ADHESIVES**

High Performance Structural Adhesives

PARTITE® Acrylic Adhesives

No-Mix Structural Adhesive System

PARTITE® Acrylic Adhesives are a no-mix, two-part system. Apply the high-performance adhesive to one surface, the activator to the other, and join the parts together. Fixture time will range from 60 seconds to 5 minutes depending upon the grade. Custom formulations and a variety of packaging are available.

PARTITE® Acrylic Adhesives

Product	Color	Viscosity, cps 20 rpm	Cure Speed	Shear Strength (psi)	Temperature Range	Activator	Application
9326	Amber	18,000 – 26,000	Fixture: 1 min Full: 24 hrs	3,000	-65°F to 250°F	1387	General purpose structural adhesive. Ideal for fast-fixturing. Excellent adhesion to a wide variety of surfaces.
9330	Amber	67,000 – 82,000	Fixture: 5 min Full: 24 hrs	3,700	-65°F to 275°F	1387	Excellent adhesion to a wide variety of surfaces such as glass, plastics, metals, ferrite, wood, ceramics, etc.

PARTITE® Activators and Primers

Product	Color	Viscosity, cps	Use With	Application
1200	Amber	2 - 4	Methacrylates	Primer to improve adhesion of methacrylates on metal surfaces.
1387	Tan	3 - 5	9326, 9330	Activator to increase the cure speed of structural acrylic adhesives.
77	Amber	2 - 4	All methacrylates, PU, and epoxy adhesives	Primer for TPO, polypropylene, and tough-to-bond plastic surfaces.

PARTITE 7509 Galvanized Metal Bonding Structural Adhesive

Parson offers an innovative nanotechnology-based structural adhesive for bonding galvanized metals, composites, and plastics for powder coating applications.

Product	Part No.	Packaging	Color	Viscosity, cps	Working Time (mins)	Fixture Time (mins)	Shear Strength (psi)	Mix Ratio	Application
7509	750950 750949 750918	50 ml 490 ml 18 kg	Blue Black	R: 200,000 – 350,000 A: 100,000 – 200,000	3 – 5	8 – 12	3,200 – 3,500	10:1	Non-sag, primer-less metal bonder. Ideal for composites and plastic bonding. High temperature resistant properties.

PARTITE® Methacrylate Adhesives

1:1 Mix Ratio

Parson Adhesives produces a full line of high-performance two-part methacrylate structural adhesives for a wide variety of applications. Methyl methacrylate adhesives are commonly used as structural adhesives due to their excellent strength, impact resistance, thermal shock, fatigue resistance, and peel strength. Custom formulations and a variety of packaging are available.

Product	Part No.	Packaging	Color	Viscosity, cps	Working Time (mins)	Fixture Time (mins)	Shear Strength (psi)	Tensile Elongation (%)	Application
7300	730025	25 mL	Cream Black	A: 40,000 - 60,000 B: 40,000 - 60,000	4 - 6	12 - 15	3,200 - 3,750	20 - 30	UL Ceritified. General purpose adhesive for bonding to plastics, composites, and metal surfaces.
	730050	50 mL							
	730020	200 mL							
	730040	400 mL							
	730018	18 kg							
	730080	180 kg							
7302	730225	25 mL	Cream	A: 40,000 - 60,000 B: 40,000 - 60,000	2 - 3	6 - 9	3,000 - 5,000	15 - 27	Faster curing version of 7300.
	730250	50 mL							
	730240	400 mL							
7310	731050	50 mL	Cream	A: 40,000 - 60,000 B: 40,000 - 60,000	15 - 18	30 - 35	3,100 - 3,300	7 - 18	Excellent adhesion to wide variety of metal, composites, and plastic surfaces.
	731020	200 mL							
	731040	400 mL							
	731018	18 kg							
	731080	180 kg							
7315	731520	200 mL	Ultra-white	A: 40,000 - 60,000 B: 40,000 - 60,000	3 - 6	12 - 16	3,800 - 4,200	3 - 6	Ultra-white UV stable adhesive ideal for fiberglass, plastics, and metals.
	731540	400 mL							
	731518	18 kg							
	731580	180 kg							
7330	733050	50 mL	Cream	A: 40,000 - 60,000 B: 40,000 - 60,000	25 - 30	60 - 75	3,000 - 3,200	9 - 20	Excellent adhesion to wide variety of metal, composites, and plastic surfaces.
	733040	400 mL							
	733018	18 kg							
	733080	180 kg							
7333	733350	50 mL	Ultra white	A: 40,000 - 60,000 B: 40,000 - 60,000	6 - 9	22 - 28	3,100 - 3,300	7 - 18	UV stable, ultra-white adhesive to bond variety of plastics, composites and metals.
	733320	200 mL							
	733340	400 mL							
	733318	18 kg							
7350	735050	400 mL	Cream	A: 40,000 - 60,000 B: 40,000 - 60,000	40 - 45	90 - 120	3,250 - 3,500	40 - 45	All-purpose adhesive with high toughness and long open time.
	735040	18 kg							
	735018	180 kg							
	735080	180 kg							
7390	739040	400 ml	Cream	A:165,000 - 200,000 B:165,000 - 200,000	90 - 95	190 - 225	2,800 - 3,100	55 - 65	High viscosity marine adhesive with long open time.
	739018	18 kg							
	739080	180 kg							

PARTITE® Methacrylate Adhesives

10:1 Mix Ratio

PARTITE® MMAs can withstand paint bake cycles, including powder coating and electron coating, at 220°C–230°C for up to 35 minutes with no loss of strength. The differences in viscosity, pot life, and cure times enable manufacturers to choose the product that best meets their production needs. No other adhesive offers this combination of convenience, ease of use, and superior mechanical strengths for bonding engineered plastics, composites, and metals.

Product	Part No.	Packaging	Color	Viscosity, cps	Working Time (mins)	Fixture Time (mins)	Shear Strength (psi)	Strain to Failure (%)	Application
7402	740238 740249 740218	380 ml 490 ml 18 kg	White	R:160,000 – 200,000 B: 60,000 – 80,000	3 – 6	8 – 12	3,200 – 3,500	60 – 80	UL Certified. General purpose adhesive with fast cure speed. High adhesion to most metals and plastics.
7405	740538 740549 740518	380 ml 490 ml 18 kg	Blue	A: 100,000 – 125,000 B: 50,000 – 70,000	8 – 12	25 – 30	3,200 – 3,500	70 – 90	Adhesive with excellent peel, impact and shear resistance. Moderate working time for larger assembly.
7418	741838 741849 741818 741880	380 ml 490 ml 18 kg 180 kg	Black	R: 125,000 – 175,000 A: 50,000 – 70,000	3 – 5	8 – 12	3,200 – 3,500	20 – 30	Adhesive with fast cure speed and flexibility with toughness and strength.
7420	742050 742038 742049 742018 742082	50 ml 380 ml 490 ml 18 kg 180 kg	Blue	R: 100,000 – 125,000 A: 50,000 – 70,000	4 – 6	15 – 18	3,200 – 3,500	30 – 50	UL certified adhesive with fast curing time. High toughness and strength with excellent resistance properties.
7422	742238 742249 742218 742280	380 ml 490 ml 18 kg 180 kg	Blue	R: 100,000 – 125,000 A: 50,000 – 70,000	17 – 25	35 – 40	3,200 – 3,500	75 – 100	UL certified with medium working time adhesive. Excellent adhesion to a variety of plastic, composites, and metal surfaces.
7425	742538 742549 742518 742580	380 ml 490 ml 18 kg 180 kg	Blue	R: 100,000 – 125,000 A: 50,000 – 70,000	30 – 35	80 – 90	3,100 – 3,300	30 – 50	All-purpose adhesive with long working time. Excellent adhesion to wide variety of plastic, composites, and metal surfaces.
7440	744049 744018 744080	490 ml 18 kg 180 kg	White	R: 135,000 – 165,000 A: 45,000 – 60,000	40 – 45	70 – 80	2,600 – 2,900	30 – 50	UV-stable formulation designed for marine applications. High toughness with long working time.
7482	748238 748249 748218 748280	380 ml 490 ml 18 kg 180 kg	Black	R: 90,000 – 125,000 A: 50,000 – 70,000	4 – 6	15 – 18	3,200 – 3,500	30 – 50	UL certified. High-temperature resistant. High toughness and strength with excellent resistance properties.
7504	750438 750449 750418 750480	380 ml 490 ml 18 kg 180 kg	Black	R: 90,000 – 125,000 A: 50,000 – 70,000	4 – 6	15 – 18	3,200 – 3,600	35 – 45	Designed for primer-less metal bonding with fast cure time. High toughness and strength.

PARTITE® 7400 PP Bonder

Parson Adhesives has developed a unique structural adhesive to bond low surface energy plastics such as polypropylene, TPO, LDPE, HDPE, Teflon, and more. This adhesive allows engineers to select from a variety of plastics based on their design and performance requirements.

Product	Part No.	Packaging	Color	Viscosity, cps	Working Time (mins)	Fixture Time (mins)	Shear Strength (psi)	Mix Ratio	Application
7400	740050 740049 740018	50 ml 490 ml 18 kg	Hazy/ Off- White	R: 7,000 – 9,000 A: 7,000 – 9,000	2 – 3	120 – 180	1,200 – 1,550	10:1	Ideal to bond low surface energy plastics without any surface preparation. Ideal for PP, TPO, and polyethylene.

PARTITE® 7411 Clear Methacrylate Adhesive

Parson Adhesives has developed a clear methacrylate adhesive to bond plexiglass (acrylics), polycarbonate, PET, ABS, and other plastics. This adhesive is widely used for displays, signs, electronics, and other industrial bonding applications.

Product	Part No.	Packaging	Color	Viscosity, cps	Working Time (mins)	Fixture Time (mins)	Shear Strength (psi)	Mix Ratio	Application
7411	741150 741149 741118	50 ml 250 ml 490 ml 18 kg	Clear	R: 75,000 – 100,000 A: 25,000 – 30,000	6 – 9	14 – 18	1,200 – 1,750	10:1	Ideal for clear bonding requirement. Widely used for sign, display, electronics and many other industrial bonding applications.

Static Mixers and Dispensing Guns

Part No.	Shape	No. of Elements	Recommendation
7300-028	Square	16	Recommended for 50 mL cartridges (1:1 ratio)
736-1697	Square	25	Recommended for 200 mL, 400 mL, and 380 mL cartridges
968-24	Square	24	Recommended for 200 ml cartridges (1:1 ratio)
975-24	Square	24	Recommended for 200 ml cartridges (1:1 ratio)
706-18T	Round	18	Recommend for 490 ml cartridges (10:1 Ratio)
705-16L	Square	16	Recommended for 50 mL cartridges (10:1 ratio)
116-039	Square	24	Recommended for 250 ml and 500 ml cartridge (10:1 ratio)
720			Dispensing gun for 200 mL 1:1 ratio cartridges
738			Dispensing gun for 380 mL 1:1 co-axial cartridges
740			Dispensing gun for 400 mL 1:1 ratio cartridges
745			Dispensing gun for 50 mL 10:1 ratio cartridges
749			Dispensing gun for 490 ml 10:1 ratio side-by-side cartridges
750			Dispensing gun for 50 mL 1:1 ratio cartridges



Parson Adhesives is the leading manufacturer of high-quality methacrylate adhesives for a wide variety of industrial assembly applications. PARTITE® methacrylate adhesives are available in 1:1 and 10:1 mix ratios to provide the highest structural strength and resistance properties with consistent performance for every assembly application. PARTITE® methacrylate adhesives are available in packing ranging from 25-mL syringes to 55-gallon drums. We also offer extensive private label services and custom formulations.

Parson Adhesives also manufactures the following:

- SONLOK Anaerobic Adhesives
- PARFIX Cyanoacrylate Adhesives
- PARLITE UV Curable Adhesives
- PARBOND Epoxy & Polyurethane Adhesives
- PARCON Silicone Sealant

We supply these adhesives to a wide variety of industries including automotive, aerospace, railway, marine, electronics, sporting goods, oil and gas, sign and display, medical device, printing and graphics, furniture, construction, transmission and engine products, and general assembly. PARSON has more than 3,500 customers in 56 different countries around the world.



- ISO 9001: 2015 Certified
- DVGW Certified

- BRE Certified Products
- ROHS Compliant

- SGS Certified
- UL Approved

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