



HexBond™ EA9309.3 NA STRUCTIL Epoxy Paste Adhesive



Product Data Sheet

Description

Toughened two-part adhesive, specially designed for metal skins, composites, thermoplastic and thermosetting materials and elastomers bonding.

Features

- Room temperature cure ($\geq 18^{\circ}\text{C}/64^{\circ}\text{F}$)
- Service temperature to $80^{\circ}\text{C}/176^{\circ}\text{F}$
- High shear and peel strength
- 0.12mm glass beads for bondline thickness control
- Good tolerance to the surfaced preparation and the type of substrate

Uncured Adhesive Properties

	Part A	Part B	Mixture
Color	Pink	Blue	Pink
Brookfield viscosity at $23^{\circ}\text{C} / 73^{\circ}\text{F}$ (Poise)	1800 - 3800	0.1 - 0.3	1600
Density (g/m ³)	1.15	1.00	1.12
Standard shelf life ($\leq 25^{\circ}\text{C} / 73^{\circ}\text{F}$) from date of shipment	1 year	1 year	

Instructions For Use

Refer to the Safety Data Sheet before handling.

- Mixing: Mix ratio by weight: Part A/Part B 100/22
Thoroughly mix both parts until the resulting colour is a consistent pink
Pot-life of 100g mass (Part A + B) at $23^{\circ}\text{C}/73^{\circ}\text{F} \approx 40$ mins
Do not mix quantities greater than 450g as dangerous heat build up can occur
- Bonding surfaces should be clean, dry and properly prepared
- Curing: 5 to 7 days at $23^{\circ}\text{C}/73^{\circ}\text{F}$ to achieve optimal performance

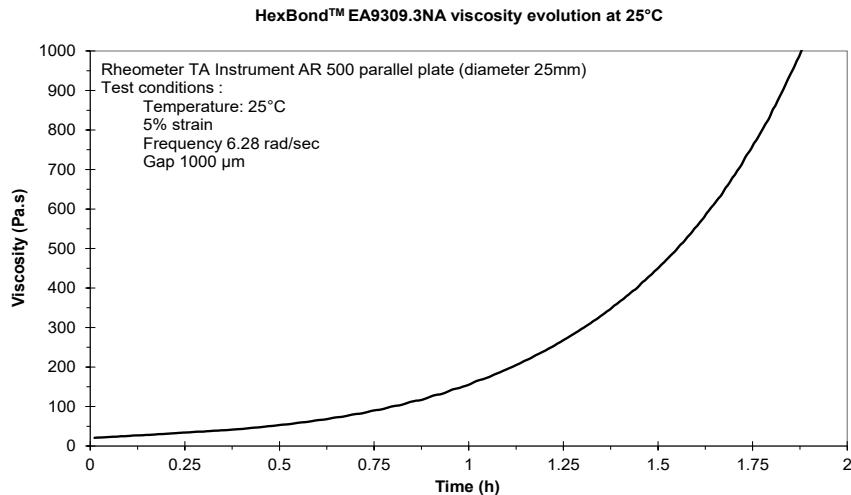
The polymerisation time can be reduced by heating at $70^{\circ}\text{C}/158^{\circ}\text{F}$ for 2h or at $80^{\circ}\text{C}/176^{\circ}\text{F}$ for 1h.



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Bond Strength Performance After Cure

Test Temperature (°C / °F)	Shear ⁽¹⁾ :		Peel ⁽²⁾ :	
	Lap Shear Strength (MPa / psi)		Bell Peel Strength (N / 25mm)	
	7 days at 25°C / 77°F	2h at 70°C / 158°F	7 days at 25°C / 77°F	2h at 70°C / 158°F
-55 / -67	44.8 / 6500	38 / 5500	260	-
23 / 77	35 / 5000	33 / 4800	300	172.5
60 / 140	12.5 / 1800	25 / 3600	-	-
80 / 176	6.9 / 1000	-	-	-

⁽¹⁾ According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

⁽²⁾ According to EN 2243-2, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

This information is provided for informal purposes only, without legal responsibility and does not constitute a specification. Users are expected to perform adequate verification and testing to ensure that materials meet required specification.

For more information

Hexcel is a leading worldwide supplier of composite materials to aerospace and industrial markets. Our comprehensive range includes:

- HexTow® carbon fibers
- HexForce® reinforcements
- HiMax™ multiaxial reinforcements
- HexPly® prepgs
- HexAM™ additive manufacturing
- HexMC® molding compounds
- HexFlow® RTM resins
- HexTool® tooling materials
- HexWeb® honeycombs
- HexBond™ adhesive
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed™ laminates

For US quotes, orders and product information call toll-free 1-800-688-7734. For other worldwide sales office telephone numbers and a full address list, please go to:

<http://www.hexcel.com/contact/salesoffice>

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