



# 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 ( $\text{g}/\text{m}^3$ )	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

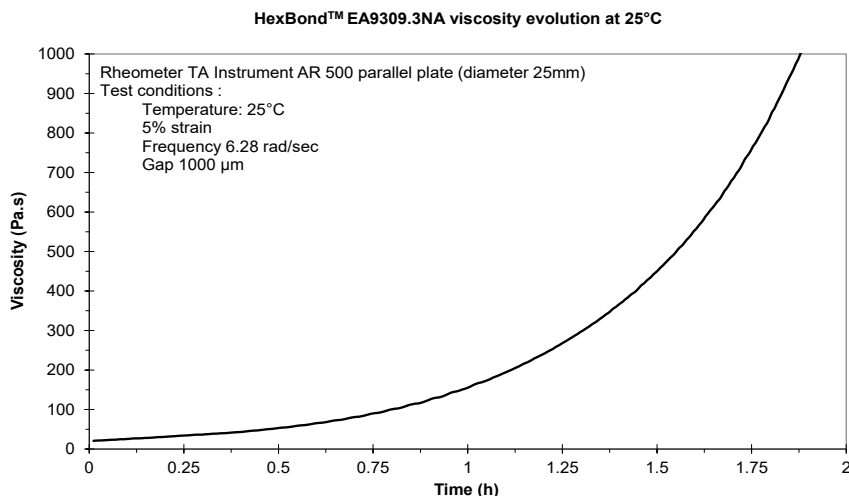
The polymerisation time can be reduced by heating at  $70^{\circ}\text{C}/158^{\circ}\text{F}$  for 2h or at  $80^{\circ}\text{C}/176^{\circ}\text{F}$  for 1h.



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### Bond Strength Performance After Cure

Test Temperature (°C / °F)	Shear <sup>(1)</sup> :		Peel <sup>(2)</sup> :	
	Lap Shear Strength (MPa / psi)		Bell Peel Strength (N / 25mm)	
	7 days at 25°C / 77°C	2h at 70°C / 158°F	7 days at 25°C / 77°C	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	-	-	-

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

<sup>(2)</sup> 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
- HexMC® molding compounds
- Acousti-Cap® sound attenuating honeycomb
- HexForce® reinforcements
- HexFlow® RTM resins
- Engineered core
- HiMax™ multiaxial reinforcements
- HexTool® tooling materials
- Engineered products
- HexPly® prepregs
- HexWeb® honeycombs
- Polyspeed™ laminates
- HexAM™ additive manufacturing
- HexBond™ adhesive

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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