



HexBond™ EA9321 STRUCTIL

Epoxy Paste Adhesive



Product Data Sheet

Description

Thixotropic two-part epoxy adhesive. Its viscosity allows to be used for potting, edge filling, shimming, fairing and bonding applications.

Packaging: Kit 908g, Semkit® barrier cartridge 6oz 195g, cartridge Semkit® barrier 2.5oz 60g.

Features

- Room temperature cure ($\geq 18^{\circ}\text{C}/64^{\circ}\text{F}$)
- Outstanding mechanical properties over a wide range of temperatures ($-55^{\circ}\text{C}/-67^{\circ}\text{F}$ to $120^{\circ}\text{C}/250^{\circ}\text{F}$)

Uncured Adhesive Properties

	Part A	Part B	Mixture
Color	Grey	Off-white	Grey
Brookfield viscosity 25°C (Poise)	3000 to 6000	350 to 1000	1600
Density (g/cm ³)	1.31	1.24	1.25
Standard shelf-life at 4°C (39°F) / 25°C (77°F) from date of shipment	1 year / 3 months	1 year / 1 year	

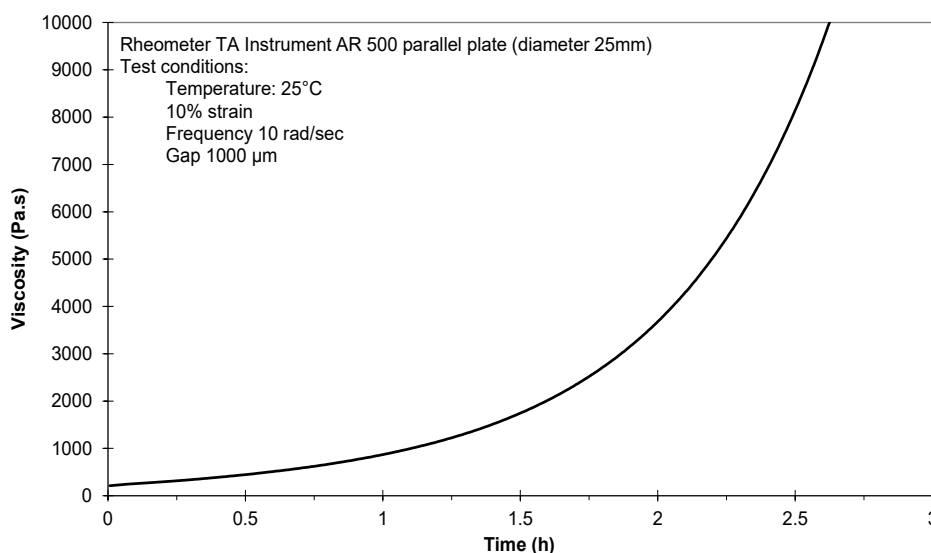
Instructions For Use

Refer to the Safety Data Sheet before handling.

- Mixing: Mix ratio by weight: Part A/Part B 100/50
Pot-life of 100g mass (Part A + Part B) at $23^{\circ}\text{C}/73^{\circ}\text{F}$
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 $23^{\circ}\text{C}/77^{\circ}\text{F}$ to achieve optimal performance

The polymerisation time can be reduced by heating at maximum $80^{\circ}\text{C}/176^{\circ}\text{F}$. For example, one hour at $80^{\circ}\text{C}/176^{\circ}\text{F}$ to obtain the best performance.

HexBond™ EA9321 STRUCTIL viscosity evolution at 25°C





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Mechanical Properties

Test Temperature °C/°F	Shear ⁽¹⁾ : Lap Shear Strength (MPa / psi)	Peel ⁽²⁾ : Bell peel strength (N/25mm)
-55 / -67	24.0 / 3480	-
23 / 73	27.0 / 3900	75
80 / 176	15.0 / 2175	-
100 / 212	14.0 / 2030	-
120 / 248	9.0 / 1300	-
180 / 356	4.5 / 650	-
23 / 73 WA ⁽³⁾	22.5 / 3200	-

⁽¹⁾ According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 7 days at 23°C/73°F

⁽²⁾ According to EN 2243-2, aluminum 20243-2, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 7 days at 23°C/73°C

⁽³⁾ WA: Wet ageing 70°C/158°F, 85% RH (saturation)

This information is provided for informal purposes only, without legal responsibility and does not constitute a specification. User 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® prepregs
- HexAM™ additive manufacturing
- HexMC® molding compounds
- HexFlow® RTM resins
- HexTool® tooling materials
- HexWeb® honeycombs
- HexBond™ adhesives
- 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:

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