



HexBond™ EA9346.5 STRUCTIL

Epoxy Paste Adhesive



Product Data Sheet

Description

Low viscosity one-component paste adhesive. High peel and shear strength with aluminum and composite substrates.

Features

- Low viscosity
- Low moisture absorption
- Maximum service temperature of 135°C/275°F

Uncured Adhesive Properties

Properties	
Colour	Blue
Brookfield viscosity at 23°C / 73°F (Poise)	3100
Density (g/cm ³)	1.15
Standard shelf-life at ≤ -18°C / 0°F & ≤ 23°C / 73°F (From date of shipment)	1 year / 7 days

Instructions For Use:

Refer to the Material Safety Data Sheet before handling.

Mixing: One-component adhesive
No mixing required

Bonding surfaces should be clean, dry and properly prepared.

Curing: 1 hour at 121°C/250°F or 1 hour at 177°C/350°F



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Bond Strength Performance After Cure

Test	Cure Cycle	Environmental Conditioning	Test Temperature (°C/°F)	Typical Values
Shear ⁽¹⁾ : Lap shear strength (MPa / psi)	8 ± 0.5hrs at 179 ± 3°C (335 ± 5°F)	Dry	23 / 73	48 / 6960
			71 / 160	45 / 6500
		Wet 1000h at 71°C / 160°F & 95% at RH	71 / 160	22 / 3190
T-peel ⁽²⁾ strength (N/mm)	2.75 ± 0.35 bar (40 ± 5 psi) ⁽³⁾	Dry	23 / 73	170
			71 / 160	135

(1) According to ASTM D 1002, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

(2) According to ASTM D 1876, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

(3) According to HS12973

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® prepregs
- HexAM™ additive manufacturing
- HexMC® molding compounds
- HexFlow® RTM resins
- HexBond™ adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- 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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