



HexBond™ EA934NA STRUCTIL

Two-component epoxy paste adhesive



Product Data Sheet

Description

Thixotropic two-component epoxy adhesive. Its viscosity allows it to be used for structural bonding, potting, filling, liquid shim and fairing applications.

Features

- Room temperature curing ($\geq 18^{\circ}\text{C}/64^{\circ}\text{F}$)
- Excellent mechanical properties at temperatures ranging from $-55^{\circ}\text{C}/-67^{\circ}\text{F}$ to $150^{\circ}\text{C}/300^{\circ}\text{F}$
- High compression strength

Uncured Adhesive Properties

	Part A	Part B	Mixture
Colour	Grey	Amber	Grey
Brookfield Viscosity at 23°C / 73°F (Poise)	4000 to 8000	10 to 30	80
Density (g/cm^3)	1.55	0.96	1.36
Standard shelf-life $\leq 4^{\circ}\text{C}$ / 39°F & $\leq 23^{\circ}\text{C}$ / 73°F	1 year / 3 months	1 year / 1 year	

Instructions For Use

Refer to the Material Safety Data Sheet before handling.

Mixing: Mix ration by weight: Part A/Part B / 100/33

Thoroughly mix the two parts until the resulting colour is a consistent grey

Do not mix quantities greater than 450g as dangerous heat build-up can occur

Pot-life: Pot-life of 100g mass (Part A + B) at $23^{\circ}\text{C}/73^{\circ}\text{C}$ ≈ 50 minutes

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

It is possible to reduce the cure time by heating at $93^{\circ}\text{C}/200^{\circ}\text{F}$. The product must be kept at least 4 hours at room temperature prior to heating - For example, 120 minutes at $65^{\circ}\text{C}/150^{\circ}\text{F}$ or 60 minutes at $80^{\circ}\text{C}/176^{\circ}\text{F}$ for best performance.



HexBond™ EA934NA STRUCTIL

Two-component epoxy paste adhesive



Product Data Sheet

Bond Strength Performance After Cure

Test Temperature (°C/°F)	Shear ⁽¹⁾ : Lap Shear Strength (MPa / psi)	Compression ⁽²⁾ : Ultimate Strength (MPa / psi)
23 / 73	22 / 3190	80 / 11600
80 / 176	13 / 1885	-
150 / 302	7 / 1015	-

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

(2) According to ASTM D695, on rectangular sample 12.5mm side, 25mm high, cure 7 days at 23°C/73°F

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
- 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>

©2019 Hexcel Corporation – All rights reserved. Hexcel Corporation and its subsidiaries (“Hexcel”) believe that the technical data and other information provided herein was materially accurate as of the date this document was issued. Hexcel reserves the right to update, revise or modify such technical data and information at any time. Any performance values provided are considered representative but do not and should not constitute a substitute for your own testing of the suitability of our products for your particular purpose. Hexcel makes no warranty or representation, express or implied, including but not limited to the implied warranties of merchantability and fitness for a particular purpose, and disclaims any liability arising out of or related to, the use of or reliance upon any of the technical data or information contained in this document.

