



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 $23^{\circ}\text{C} / 73^{\circ}\text{F}$ (Poise)	4000 to 8000	10 to 30	80
Density (g/cm^3)	1.55	0.96	1.36
Standard shelf-life $\leq 4^{\circ}\text{C} / 39^{\circ}\text{F}$ & $\leq 23^{\circ}\text{C} / 73^{\circ}\text{F}$	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 $23^{\circ}\text{C}/73^{\circ}\text{C} \approx 50$ 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.



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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® 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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