HexBond™ EA9392 STRUCTIL
Two-component epoxy paste adhesive

HEXCEL®

Description

Thixotropic two-component epoxy adhesive. Its viscosity allows for it to be used for structural bonding, potting, filling, liquid shim and fairing applications. HexBond™ EA9392 STRUCTIL is the toughened version of HexBond™ EA9394 STRUCTIL.

Features

- Room temperature curing (≥ 18°C/64°F)
- Excellent mechanical properties at temperatures ranging from -55°C/-67°F to 180°C/356°F
- Good toughness

Uncured Adhesive Properties

	Part A	Part B	Mixture
Colour	Grey	Amber	Grey
Brookfield viscosity at 23°C / 73°F (Poise)	2000 to 6000	3000 to 7000	
Density (g/cm³)	1.4	1.0	
Standard shelf-life at ≤ 23°C / 73°F (From date of shipment)	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: 100/32
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°C/73°F ≈ 130 minutes

Bonding surfaces should be clean, dry and properly prepared.

Curing: 3 to 5 days at 23°C/73°F to achieve optimal performance

It is possible to reduce the polymerisation time by heating at a maximum temperature of 93°C/200°F. The product must be kept at least 4 hours at room temperature prior to testing. For example, 60 minutes at 65°C/150°F to obtain the best performance.

Bond Strength Performance After Cure

Test Temperature (°C / °F)	Shear[1]: Lap Shear Strength (MPa / psi)	Peel[2]: Bell Peel Strength (N/25mm)
23 / 73	29 / 4200	150
80 / 176	20 / 2900	
121 / 250	17 / 2465	
150 / 302	10 / 1450	

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cured 5 days at 23°C/73°F

(2) According to EN 2243-2, on aluminum 2024T3 clad treated with sulfochromic acid etch, cured 5 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