



# HexBond™ EA9394 STRUCTIL Paste Adhesive



## Product Data Sheet

### Description

Thixotropic two-part epoxy adhesive. Its viscosity means it can be used for structural bonding, potting, filling, liquid shim and fairing applications.

Packaging: Kit 908g, dual cartridge 318g/200mL<sup>(1)</sup>, dual cartridge 57g/50mL<sup>(2)</sup>, Semkit® Injection 6oz/155g

### Features

- Room temperature cure ( $\geq 18^{\circ}\text{C}/64^{\circ}\text{F}$ )
- Outstanding mechanical properties over a wide range of temperature (-55°C/-67°F to 180°C/356°F)
- High compression strength

### Uncured Adhesive Properties

	Part A	Part B	Mixture
Color	Grey	Black	Grey
Brookfield viscosity at 23°C / 77°F (Poise)	4000 to 8000	100 to 700	1600
Density (g/m <sup>3</sup> )	1.45	1.00	1.33
Standard shelf-life ( $\leq 23^{\circ}\text{C} / 73^{\circ}\text{C}$ ) from date of shipment	1 year	1 year	
Shelf-life of dual cartridge ( $\leq 30^{\circ}\text{C} / 86^{\circ}\text{F}$ ) from date of shipment	10 months	10 months	

### Instructions For Use

Refer to the Safety Data Sheet before handling.

- Mixing: Mix ratio by weight: Part A/Part B: 100/17  
Thoroughly mix both parts until the resulting colour is a consistent grey  
Pot-life of 100g mass (Part A + B) at 23°C/75°F  $\approx$  150 minutes  
Do not mix quantities greater than 450g as dangerous heat build-up can occur
- Bonding surfaces should be clean, dry and properly prepared
- Curing: 3 to 5 days at 23°C/73°F to achieve optimal performance

The polymerisation time can be reduced by heating at maximum 93°C/200°F (leave the product for at least 4h at room temperature before heating). For example, 1h at 65°C/149°F to obtain the best performance.

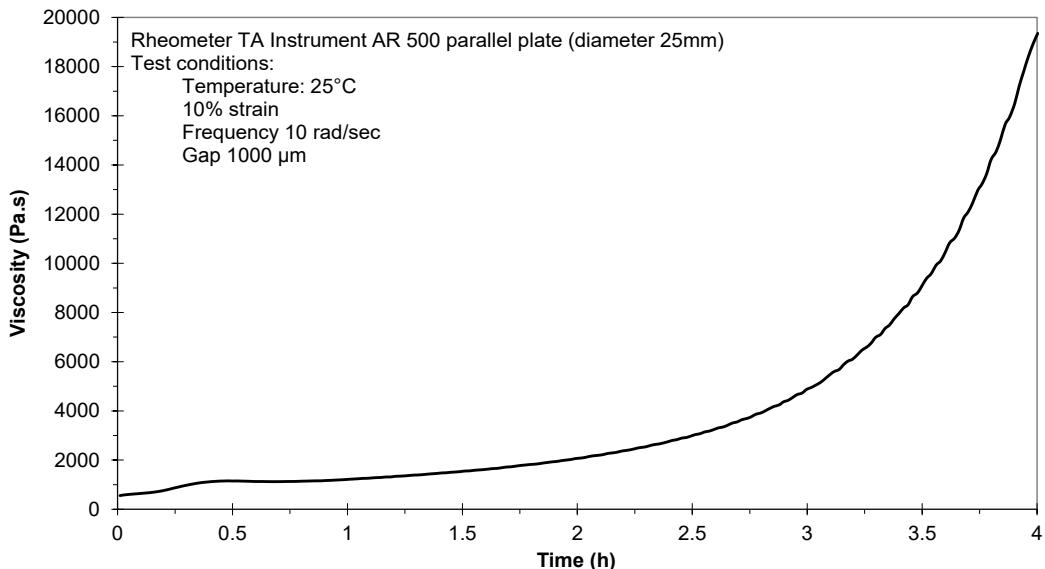


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HexBond™ EA9394 STRUCTIL viscosity evolution at 25°C



### Bond Strength Performance After Cure

Test Temperature °C / °F	Shear <sup>(1)</sup> : Lap Shear Strength (MPa / psi)	Compression <sup>(2)</sup> :	
		Compression Strength at 2% Offset (MPa / ksi)	Peel <sup>(3)</sup> : Bell Peel Strength (N/25mm)
-55 / -67	22 / 3200	173 / 25000	-
23 / 73	30 / 4300	68 / 9900	90
80 / 176	22 / 3200	43 / 6200	-
120 / 248	17 / 2450	37 / 5300	-
150 / 302	12 / 1750	-	-

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

<sup>(2)</sup> According to ISO 604, on cylindrical test specimen 13.7mm diameter, 36mm high, cure 5 days at 23°C/73°F

<sup>(3)</sup> According to En 2243-2, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 5 days at 23°C/73°C

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
- HexTool® tooling materials
- HexWeb® honeycombs
- Engineered core
- Acousti-Cap® sound attenuating honeycomb
- Engineered products
- Polyspeed™ laminates

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