



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⁽¹⁾, dual cartridge 57g/50mL⁽²⁾, 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 ($-55^{\circ}\text{C}/-67^{\circ}\text{F}$ to $180^{\circ}\text{C}/356^{\circ}\text{F}$)
- High compression strength

Uncured Adhesive Properties

	Part A	Part B	Mixture
Color	Grey	Black	Grey
Brookfield viscosity at $23^{\circ}\text{C} / 77^{\circ}\text{F}$ (Poise)	4000 to 8000	100 to 700	1600
Density (g/m^3)	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 $23^{\circ}\text{C}/75^{\circ}\text{F} \approx 150$ 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 $23^{\circ}\text{C}/73^{\circ}\text{F}$ to achieve optimal performance

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

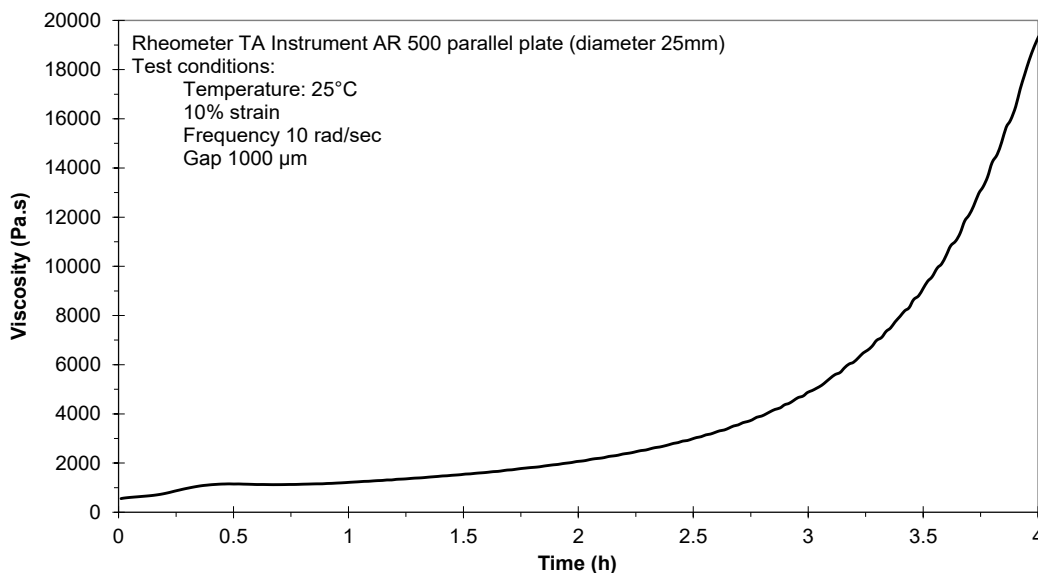


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HexBond™ EA9394 STRUCTIL viscosity evolution at 25°C



Bond Strength Performance After Cure

Test Temperature °C / °F	Shear ⁽¹⁾ : Lap Shear Strength (MPa / psi)	Compression ⁽²⁾ :	Peel ⁽³⁾ :
		Compression Strength at 2% Offset (MPa / ksi)	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	-	-

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

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

⁽³⁾ 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
- HexMC® molding compounds
- Acousti-Cap® sound attenuating honeycomb
- HexForce® reinforcements
- HexFlow® RTM resins
- Engineered products
- HiMax™ multiaxial reinforcements
- HexTool® tooling materials
- Polyspeed™ laminates
- HexPly® prepregs
- HexWeb® honeycombs
- Engineered core
- HexAM™ additive manufacturing

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:

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