



# HexBond™ EA9395 STRUCTIL

## Epoxy Paste Adhesive



### Product Data Sheet

#### Description

Thixotropic two-part epoxy adhesive. Its viscosity allows to be used for bonding, potting, filling and fairing applications.

Packaging: Kit 908g, Semkit® Injection cartridge 6oz/155g, dual cartridge 200ml and 50ml

#### 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  $180^{\circ}\text{C}/356^{\circ}\text{F}$ )
- Suitable for radome repair, non-metallic filler

#### Uncured Adhesive Properties

	Part A	Part B	Mixture
Colour	Blue	Black	Grey
Brookfield viscosity at $23^{\circ}\text{C}$ / $73^{\circ}\text{F}$ (Poise)	4000 to 8000	100 to 700	1600
Density ( $\text{g}/\text{m}^3$ )	1.4	1.0	1.3
Standard shelf-life ( $\leq 23^{\circ}\text{C}$ / $73^{\circ}\text{F}$ ) from date of shipment	1 year	1 year	

#### 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 color is a consistent grey  
Pot-life of 100g mass (Part A + B) at  $23^{\circ}\text{C}/73^{\circ}\text{F} \approx 150$  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 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.



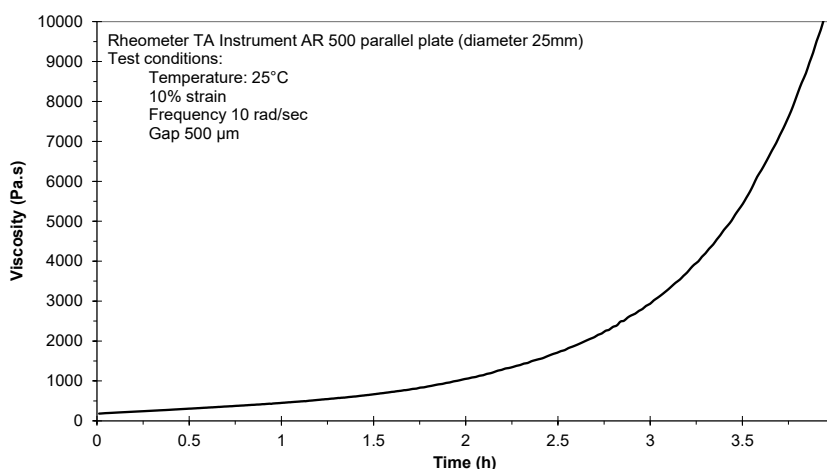
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HexBond™ EA9395 STRUCTIL viscosity evolution at 25°C



### Bond Strength Performance After Cure

Test Temperature (°C/°F)	Shear <sup>(1)</sup> : Lap Shear Strength (MPa / psi)	Peel <sup>(2)</sup> : Bell Peel Strength (N/25mm)
-55 / -67	15 / 2150	-
23 / 73	25 / 3600	65
80 / 176	20 / 2900	-
120 / 248	15 / 2150	-
150 / 302	11 / 1600	-

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

<sup>(2)</sup> According to EN2243-2, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 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
- HexTool® tooling materials
- HexWeb® honeycombs
- HexBond™ adhesives
- Engineered core
- Acousti-Cap® sound attenuating honeycomb
- 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:

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