



# 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°C/-67°F to 180°C/356°F)
- Suitable for radome repair, non-metallic filler

#### Uncured Adhesive Properties

|  | Part A       | Part B     | Mixture |
|--|--------------|------------|---------|
| Colour   | Blue         | Black      | Grey    |
| Brookfield viscosity at 23°C / 73°F (Poise)  | 4000 to 8000 | 100 to 700 | 1600    |
| Density (g/m <sup>3</sup> )  | 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°C/73°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

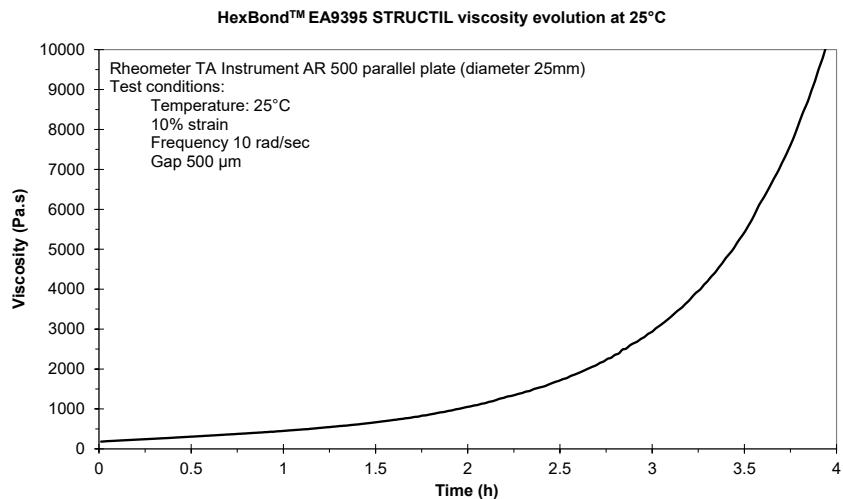
The polymerisation time can be reduced by heating at maximum 93°C/200°F (leave product for at least 4h at room temperature before heating). For example, 1h at 65°C/149°F to obtain the best performance.



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### Bond Strength Performance After Cure

| Test Temperature<br>(°C/°F) | Shear <sup>(1)</sup> :<br>Lap Shear Strength (MPa / psi) | Peel <sup>(2)</sup> :<br>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
- HexMC® molding compounds
- Engineered core
- HexForce® reinforcements
- HexFlow® RTM resins
- Acousti-Cap® sound
- HiMax® multiaxial reinforcements
- HexTool® tooling materials
- attenuating honeycomb
- HexPly® prepgres
- HexWeb® honeycombs
- Engineered products
- HexAM® additive manufacturing
- HexBond™ adhesives
- 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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