



# HexBond™ EA9396 STRUCTIL Paste Adhesive



## Product Data Sheet

### Description

Liquid two-part epoxy resin adhesive. Its low viscosity makes it suitable for bonding by injection process and repairing by war lay up of fabrics.

### 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)
- Low viscosity

### Uncured Adhesives Properties

	Part A	Part B	Mixture
Color	Blue	Orange	Green
Brookfield viscosity at 23°C / 73°F (Poise)	400 to 1000	0.4 to 1	35
Density (g/cm³)	1.20	1.00	1.14
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 100/30  
Thoroughly mix both parts until the resulting colour is a consistent green  
Pot-life of 100g mass (Part A + B) at 23°C/73°F  $\approx$  80 mins  
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.

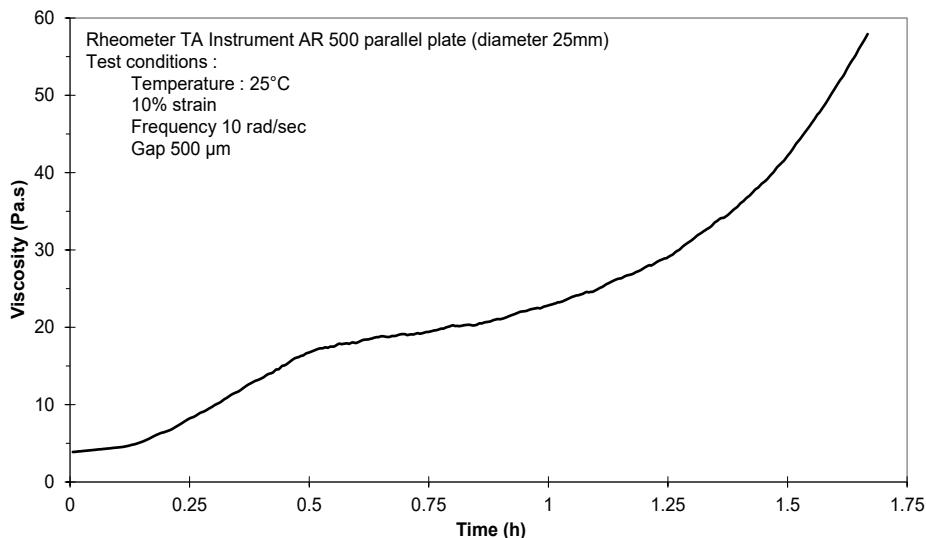


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HexBond™ EA 9396 STRUCTIL viscosity evolution at 25°C



### Bond Strength Performance After Cure

Test Temperature (°C / °F)	Shear <sup>(1)</sup> : Lap Shear Strength (MPa / psi)	
	5 Days at 25°C / 77°F	1h at 65°C / 149°F
23 / 73	33.8 / 4900	28.4 / 4120
90 / 194	18.6 / 2700	22.3 / 3235
110 / 230	14.7 / 2130	18.4 / 2670
130 / 266	10.5 / 1520	15.1 / 2190

<sup>(1)</sup> According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

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### For more information

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