



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 ($-55^{\circ}\text{C}/-67^{\circ}\text{F}$ to $180^{\circ}\text{C}/356^{\circ}\text{F}$)
- Low viscosity

Uncured Adhesives Properties

	Part A	Part B	Mixture
Color	Blue	Orange	Green
Brookfield viscosity at $23^{\circ}\text{C} / 73^{\circ}\text{F}$ (Poise)	400 to 1000	0.4 to 1	35
Density (g/cm^3)	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 $23^{\circ}\text{C}/73^{\circ}\text{F} \approx 80$ 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 $23^{\circ}\text{C}/73^{\circ}\text{F}$ 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.

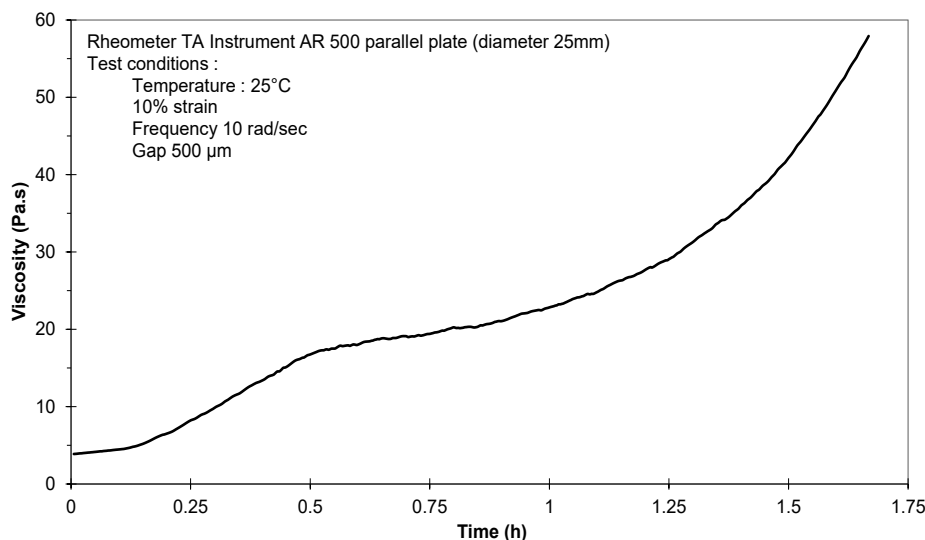


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HexBond™ EA 9396 STRUCTIL viscosity evolution at 25°C



Bond Strength Performance After Cure

Test Temperature (°C / °F)	Shear ⁽¹⁾ : 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

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

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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
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- 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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