



HexBond™ EA956 STRUCTIL

Two-component epoxy liquid adhesive



Product Data Sheet

Description

Liquid two-part epoxy adhesive. Its viscosity allows it to be used for the wet lay-up of fabrics and bonding by injection process.

Features

- Low viscosity
- Room temperature curing ($\geq 18^{\circ}\text{C}/64^{\circ}\text{F}$)
- Good mechanical properties at temperatures ranging from $-55^{\circ}\text{C}/-67^{\circ}\text{F}$ to $150^{\circ}\text{C}/302^{\circ}\text{F}$

Uncured Adhesive Properties

	Part A	Part B	Mixture
Colour	Amber	Amber	Amber
Brookfield viscosity at $23^{\circ}\text{C} / 73^{\circ}\text{F}$ (Poise)	200 to 700	10 to 30	
Density (g/cm^3)	1.25	0.96	1.15
Standard shelf-life $\leq 4^{\circ}\text{C} / 39^{\circ}\text{F}$ & $\leq 23^{\circ}\text{C} / 73^{\circ}\text{F}$ (From date of shipment)	1 year / 3 months	1 year / 1 year	

Instructions For Use

Refer to the Material Safety Data Sheet before handling.

Mixing: Mix ration by weight: Part A/Part B: 100/58

Thorough mix the two parts until the resulting colour is a consistent amber.

Do not mix quantities greater than 450g as dangerous heat build-up can occur.

Pot-life: Pot-life of 100g mass (Part A + B) at $23^{\circ}\text{C}/73^{\circ}\text{F} \approx 40$ minutes

Bonding surfaces should be clean, dry and properly prepared.

Curing: 3 to 5 days at $23^{\circ}\text{C}/73^{\circ}\text{F}$

It is possible to reduce the polymerisation time by heating at a maximum temperature of $93^{\circ}\text{C}/200^{\circ}\text{F}$. The product must be kept at least 4 hours at room temperature prior to heating. For example, 8 hours at $50^{\circ}\text{C}/122^{\circ}\text{F}$ or 1 hour at $82^{\circ}\text{C}/180^{\circ}\text{F}$ for best performance.



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Bond Strength Performance After Cure

Test Temperature (°C / °F)	Shear ⁽¹⁾ : Lap Shear Strength (MPa / psi)
23 / 73	23 / 3330
82 / 180	20 / 2900
149 / 300	7 / 1015
177 / 350	5 / 725

(1) According to EN 2243-1, on aluminum 2024T3 1.6mm glad treated with sulfo-chromic acid etch, cure 1 hour at 82°C/180°F

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For more information

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- HexTow® carbon fibers
- HexForce® reinforcements
- HiMax™ multiaxial reinforcements
- HexPly® prepregs
- HexAM™ additive manufacturing
- HexMC® molding compounds
- HexFlow® RTM resins
- HexBond™ adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- 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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