



# HexBond™ EA9674 STRUCTIL BMI Adhesive Film



## Product Data Sheet

### Description

Hexbond™ EA9674 is an epoxy/bismaleimide film adhesive designed for high temperature bonding application. It is specially recommended for metal/metal or composite/metal bonding and for co-curing of sandwich structures.

### Features

- Outstanding mechanical properties over a wide range of temperature (-55°C/-67°F to 210°C/410°F)
- Can be reticulate on acoustic panel
- Storage life: 1 year at or below -18°C/0°F +2 weeks at room temperature ( $\leq 23^{\circ}\text{C}/73^{\circ}\text{F}$ )

### Applications

- Metal-to-metal bonding
- Sandwich construction
- Composite-to-composite bonding

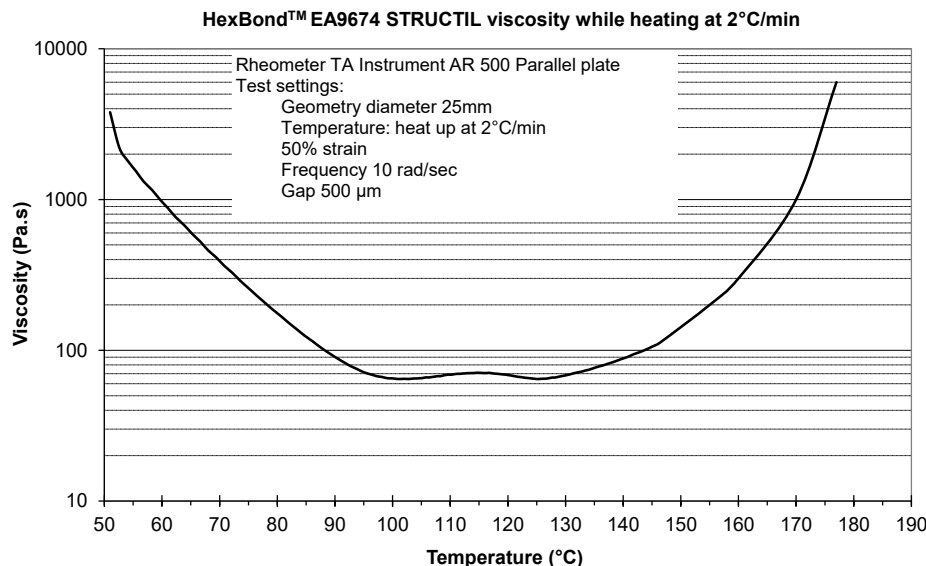
### Uncured Adhesive Properties

	Areal Weight (g/m <sup>2</sup> )	Support	Roll Width (mm)	Standard Roll m <sup>2</sup>
EA9674.06 UNS	300	None	500	15
EA9674.06 GLS	300	Glass fabric	500	25

### Instructions For Use

Refer to the Safety Data Sheet before handling.

- To avoid any moisture, allow the adhesive to warm at room temperature before opening the waterproof polyethylene bag
- Bonding surfaces should be clean, dry and properly prepared
- Remove protective liners before bonding (release paper and polyethylene film)
- Typical cure cycles: 1h at 180°C/356°F under pressure + 6h at 230°C/446°F without pressure  
Heat up rate: 1 to 4°C/min  
Pressure: 1.5 to 3.5 bar





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#### Bond Strength Performance After Cure

Test	Test Temperature (°C / °F)	EA9674.06 UNS	EA9674.06 GLS
Simple lap shear strength <sup>(1)</sup> (MPa / psi)	23 / 73	31.4 / 4550	30.4 / 4400
	180 / 356	30.5 / 4400	28.4 / 4100
	230 / 446	-	14.0 / 2030
	250 / 482	-	6.1 / 880
Honeycomb climbing drum peel torque <sup>(2)</sup> (mN/m)	23 / 73	23.9	22.7
Flatwise tension strength <sup>(3)</sup> (MPa / psi)	23 / 73	7.7 / 1100	7.7 / 1100

Cure: 1h at 140°C (284°F) + 3h at 190°C (374°F) under 2.5 bar + post cure: 8h at 230°C (446°F) without pressure/heat up/cool down rate: 1.5°C/min

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

<sup>(2)</sup> According to EN 2243-3, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, honeycomb core aluminum PAA 5052 N 6.0 1/4, 16mm high, unslotted

<sup>(3)</sup> According to EN 2243-4, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, honeycomb core aluminum PAA 5052 N 6.0 1/4, 16mm high, unslotted

The 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
- Acousti-Cap® sound attenuating honeycomb
- HexForce® reinforcements
- HexFlow® RTM resins
- Engineered core
- HiMax™ multiaxial reinforcements
- HexTool® tooling materials
- Engineered products
- HexPly® prepregs
- HexWeb® honeycombs
- Polyspeed™ laminates
- HexAM™ additive manufacturing
- HexBond™ adhesives

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:

<http://www.hexcel.com/contact/salesoffice>

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