



HexBond™ ST1020

Two-Component Epoxy Paste



Product Data Sheet

Descriptions

Thixotropic two-component epoxy adhesive. Its viscosity allows to be used for structural bonding, potting, filling, liquid shim and fairing applications.

Packaging: Kit 908g

Features

- Cures in 60 mins at 90°C/194°F or 150 mins at 80°C/176°F
- Excellent mechanical properties at temperatures ranging from -55°C/-67°F
- Long pot-life

Uncured Adhesive Properties

	Part A	Part B	Mixture
Color	Black	Yellow	Black
Brookfield viscosity at 25°C / 77°F (Poise)	6000 to 11000	0.2 to 1.2	
Density at 25°C / 77°F	1.45	1.00	1.33
Standard shelf-life (4°C / 39°F // 77°F) from date of shipment	1 year / 1 year	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: 100/19
Thoroughly mix the two parts until the resulting colour is a consistent black
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 25°C/77°F > 8h
Method based on ASTM D2471 in a thermostatically controlled water bath
- **Bonding surfaces** should be clean, dry and properly prepared
- **Curing:** 60 mins at 90°C/194°F to achieve optimal performance



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Bond Strength Performance After Cure

Test	Cure Cycle	Environmental Conditioning	Test Temperature (°C / °F)	Typical Values
Shear ⁽¹⁾ : Lap shear strength (MPa / psi)	60 min at 90°C / 194°F	Dry	25 / 77	29.5
			82 / 180	30.2
			121 / 250	22.6
			149 / 300	19.9
			177 / 350	18.1
			204 / 400	14.9
			232 / 450	8.3
		Ageing for 192h at 149°C / 300°F	149 / 300	20.5
	150 min at 80°C / 176°F	Dry	25 / 77	26.7
			82 / 180	28.1
			121 / 250	24.7
			149 / 300	21.7
			177 / 350	16.7
			204 / 400	11.9

⁽¹⁾ 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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