



HexBond™ ST1060

Two-component epoxy paste adhesive



Product Data Sheet

Description

Two-part epoxy adhesive. This product is designed for applications requiring high deformation. It is adapted to paste any rubber EPDM and suitable for low temperature applications down to -40°C/-40°F.

Features

- Room temperature curing $\geq 18^{\circ}\text{C}/64^{\circ}\text{F}$
- High elongation at break $\approx 85\%$ at $23^{\circ}\text{C}/73^{\circ}\text{F}$
- Long pot-life

Uncured Adhesive Properties

	Part A	Part B	Mixture
Colour	White	Amber	Amber
Brookfield viscosity at $23^{\circ}\text{C} / 73^{\circ}\text{F}$ (Poise)	300 to 500	1000 to 3000	-
Density (g/cm ³)	-	-	-
Standard shelf-life at $\leq 4^{\circ}\text{C}$ (39°F) & $\leq 23^{\circ}\text{C}$ (73°F) (From date of shipment)	1 year / 6 months	1 year / 1 year	-

Instructions For Use

Refer to the Material Safety Data Sheet before handling.

Mixing: Mix ratio by weight: Part A/Part B: 100/200

Thoroughly 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 at $23^{\circ}\text{C}/73^{\circ}\text{F}$ for 2 hours

Bonding surfaces should be clean, dry and properly prepared.

Curing: 5 to 7 days at $23^{\circ}\text{C}/73^{\circ}\text{F}$ to achieve optimal performance

Cure time can be reduced by heating for 1 hour at $60^{\circ}\text{C}/140^{\circ}\text{F}$



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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)	7 days at 23°C / 73°F	Dry	23 / 73	17 / 2465
			82 / 180	5 / 725
Bell peel strength ⁽²⁾ (N/25mm)	7 days at 23°C / 73°F	Dry	82 / 180	150

(1) According to EN 2243-1, on aluminum 2024T3 clad, 1.6mm, treated with sulfo-chromic acid etch

(2) According to EN 2243-2, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

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For more information

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- HiMax™ multiaxial reinforcements
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- 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
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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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