



HexBond™ EA9390 STRUCTIL

Epoxy Paste Adhesive



Product Data Sheet

Description

Two-component epoxy adhesive. Designed for composite repair by wet lay up process and bonding by injection.

Features

- Temperature cure $\geq 90^{\circ}\text{C} / 194^{\circ}\text{F}$
- Service temperature to $180^{\circ}\text{C} / 356^{\circ}\text{F}$

Uncured Adhesive Properties

The length of a Fillet is 1 meter; it is supplied on a PVC support.

The support's color varies according to the reference, see the following table.

HexBond™ EA 9685-1 Epoxy Fillet is available as sets of 35 profiles of 1m.

	PART A	PART B	MIXTURE
Colour	Beige	Blue	Blue
Brookfield viscosity at $25^{\circ}\text{C} / 77^{\circ}\text{F}$ (Poise)	600 to 1000	0.8 to 1.6	80
Density at $25^{\circ}\text{C} / 77^{\circ}\text{F}$	1,22	0.95	1,33
Standard shelf life ($4^{\circ}\text{C}(39^{\circ}\text{F}) / 25^{\circ}\text{C}(77^{\circ}\text{F})$) from date of shipment	1 year / 6 months	1 year/ 1 year	

Instructions for use

Refer to the Safety Data Sheet before handling.

- Mixing:
 - Mix ration by weight: Part A/Part B : 100/56.
 - Thoroughly mix the two parts. The resulting colour is a consistent grey.
 - Pot life of 100 g mass (part A+B) at $25^{\circ}\text{C} / 77^{\circ}\text{C} > 5$ hours.
 - Do not mix quantities greater than 450 g as dangerous heat buildup can occur.
- Bonding surfaces should be clean, dry and properly prepared.
- Curing: 200 minutes at $93^{\circ}\text{C} / 200^{\circ}\text{F}$ or 130 minutes at $150^{\circ}\text{C} / 300^{\circ}\text{F}$ with a pressure from 0,5 to 1 bar.



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Bond Strength Performance After Cure

Test temperature (°C/°F)	Shear ⁽¹⁾ : Lap shear strength (MPa/ psi)
23 / 73	22 / 3190
80 / 176	22 / 3190
180 / 356	13 / 1890

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

This 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
- HexForce® reinforcements
- HiMax™ multiaxial reinforcements
- HexPly® prepgs
- HexMC® molding compounds
- HexFlow® RTM resins
- Redux® & HexBond™ adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed® laminates & pultruded profiles
- 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:

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

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