



HexBond™ ST1007

Epoxy Paste Adhesive



Product Data Sheet

Description

Liquid two-part epoxy adhesive filled with microspheres. Its low viscosity allows to be used for filling, potting and fastening inserts applications.

Packaging: Semikit® barrier cartridge 6oz – 60 g.

Features

- Room temperature cure ($\geq 18^{\circ}\text{C} / 64^{\circ}\text{F}$)
- Low density: Filled with $\approx 12\%$ of glass microspheres with a density of 0,2 (crush-resistance: 1000 PSI / 6,9 MPa)
- Outstanding mechanical properties over a wide range of temperature

Uncured Adhesive Properties

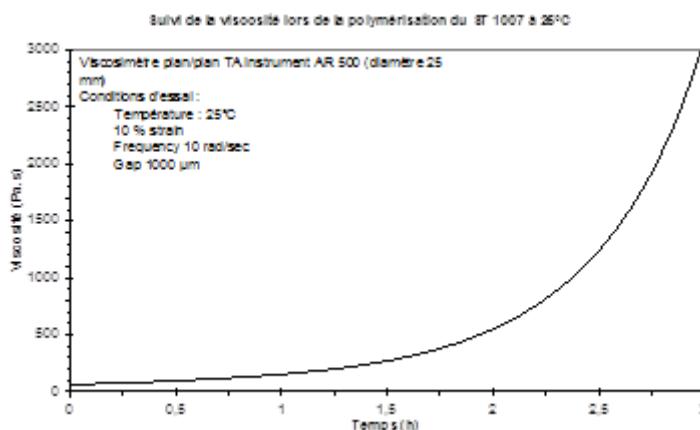
	PART A	PART B	MIXTURE
Colour	Blue	Black	Grey
Density			0.70
Standard shelf life ($\leq 25^{\circ}\text{C} / 77^{\circ}\text{F}$) from date of shipment	1 year	1 year	

Instructions for use

Refer to the Safety Data Sheet before handling.

- Mixing: Semco MC Standard-type mixer.
 - 90 back-and-forth en 2 min 30 sec.
 - Propeller speed : 120 tr/min.
- The use of the cartridge shall not exceed 1 hour. If the cartridge is not entirely used, discharge and spread the remaining product before discarding the product.
- **Do not mix quantities greater than 60g as dangerous buildup can occur.**
- Curing: 3 to 5 days at $25^{\circ}\text{C} / 77^{\circ}\text{F}$

The polymerisation time can be reduced by heating at maximum $93^{\circ}\text{C} / 200^{\circ}\text{F}$ (leave the product for at least 4 hours at room temperature before heating). For example, one hour at $65^{\circ}\text{C} / 149^{\circ}\text{F}$ to obtain the best performance.





Bond Strength Performance After Cure

Test temperature (°C/ °F)	Shear ⁽¹⁾ : Lap shear strength (MPa/psi)		Compression ⁽²⁾ : Compression strength (MPa/psi)
	Curing 5 days at 25°C/ 77°F	Curing 1 h at 65°C/ 149°C	
23 / 73	18,6 / 2700	20,8 / 3000	36,8 / 5340
80 / 176	-	17,4 / 2500	-
100 / 212	-	15,7 / 2250	-
120 / 120	-	12,9 / 1870	-
150 / 150	-	10,6 / 1500	-
180 / 356	-	6,6 / 950	-

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

(2) According to DIN 53454, rectangular blocks 12,5 x 12,5 x 25 mm.

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

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- Engineered products
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