Description
Toughened two-part adhesive, specially designed for metal skins, composites, thermoplastic and thermosetting materials and elastomers bonding.

Features
- Room temperature cure (≥ 18°C/64°F)
- Service temperature to 80°C/176°F
- High shear and peel strength
- 0.12mm glass beads for bondline thickness control
- Good tolerance to the surfaced preparation and the type of substrate

Uncured Adhesive Properties

<table>
<thead>
<tr>
<th></th>
<th>Part A</th>
<th>Part B</th>
<th>Mixture</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Pink</td>
<td>Blue</td>
<td>Pink</td>
</tr>
<tr>
<td>Brookfield viscosity at 23°C / 73°F (Poise)</td>
<td>1800 - 3800</td>
<td>0.1 - 0.3</td>
<td>1600</td>
</tr>
<tr>
<td>Density (g/m²)</td>
<td>1.15</td>
<td>1.00</td>
<td>1.12</td>
</tr>
<tr>
<td>Standard shelf life (≤ 25°C / 73°F) from date of shipment</td>
<td>1 year</td>
<td>1 year</td>
<td></td>
</tr>
</tbody>
</table>

Instructions For Use
Refer to the Safety Data Sheet before handling.

- Mixing: Mix ratio by weight: Part A/Part B 100/22
  Thoroughly mix both parts until the resulting colour is a consistent pink
  Pot-life of 100g mass (Part A + B) at 23°C/73°F = 40 mins
  Do not mix quantities greater than 450g as dangerous heat build up can occur

- Bonding surfaces should be clean, dry and properly prepared
- Curing: 5 to 7 days at 23°C/73°F to achieve optimal performance
  The polymerisation time can be reduced by heating at 70°C/158°F for 2h or at 80°C/176°F for 1h.
**HexBond™ EA9309.3 NA STRUCTIL Epoxy Paste Adhesive**

**Product Data Sheet**

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**Bond Strength Performance After Cure**

<table>
<thead>
<tr>
<th>Test Temperature (^{\circ}C / ^{\circ}F)</th>
<th>Shear (^{(1)}): Lap Shear Strength (MPa / psi)</th>
<th>Peel (^{(2)}): Bell Peel Strength (N / 25mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>7 days at 25°C / 77°C 2h at 70°C / 158°F</td>
<td>7 days at 25°C / 77°C 2h at 70°C / 158°F</td>
</tr>
<tr>
<td>-55 / -67</td>
<td>44.8 / 6500 38 / 5500</td>
<td>260</td>
</tr>
<tr>
<td>23 / 77</td>
<td>35 / 5000 33 / 4800</td>
<td>300   172.5</td>
</tr>
<tr>
<td>60 / 140</td>
<td>12.5 / 1800 25 / 3600</td>
<td>-    -</td>
</tr>
<tr>
<td>80 / 176</td>
<td>6.9 / 1000 -</td>
<td>-    -</td>
</tr>
</tbody>
</table>

\(^{(1)}\) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

\(^{(2)}\) According to EN 2243-2, on aluminum 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.

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**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® prepregs
- HexAM™ additive manufacturing
- HexMC® molding compounds
- HexFlow® RTM resins
- HexTool® tooling materials
- HexWeb® honeycombs
- HexBond™ adhesive
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed™ laminates

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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