Description
Thixotropic two-part epoxy adhesive. Its viscosity allows to be used for potting, edge filling, shimming, fairing and bonding applications.

Packaging: Kit 908g, Semkit® barrier cartridge 6oz 195g, cartridge Semkit® barrier 2.5oz 60g.

Features
- Room temperature cure (≥ 18°C/64°F)
- Outstanding mechanical properties over a wide range of temperatures (-55°C/-67°F to 120°C/250°F)

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>Grey</td>
<td>Off-white</td>
<td>Grey</td>
</tr>
<tr>
<td>Brookfield viscosity 25°C (Poise)</td>
<td>3000 to 6000</td>
<td>350 to 1000</td>
<td>1600</td>
</tr>
<tr>
<td>Density (g/cm³)</td>
<td>1.31</td>
<td>1.24</td>
<td>1.25</td>
</tr>
<tr>
<td>Standard shelf-life at 4°C (39°F) / 25°C (77°F) from date of shipment</td>
<td>1 year / 3 months</td>
<td>1 year / 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 100/50
  Pot-life of 100g mass (Part A + Part B) at 23°C/73°F
  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/77°F to achieve optimal performance
  The polymerisation time can be reduced by heating at maximum 80°C/176°F. For example, one hour at 80°C/176°F to obtain the best performance.

HexBond™ EA9321 STRUCTIL viscosity evolution at 25°C

Rheometer TA Instrument AR 500 parallel plate (diameter 25mm)
Test conditions:
  Temperature: 25°C
  10% strain
  Frequency 10 rad/sec
  Gap 1000 μm
HexBond™ EA9321 STRUCTIL
Epoxy Paste Adhesive

Mechanical Properties

<table>
<thead>
<tr>
<th>Test Temperature °C/°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>-55 / -67</td>
<td>24.0 / 3480</td>
<td>-</td>
</tr>
<tr>
<td>23 / 73</td>
<td>27.0 / 3900</td>
<td>75</td>
</tr>
<tr>
<td>80 / 176</td>
<td>15.0 / 2175</td>
<td>-</td>
</tr>
<tr>
<td>100 / 212</td>
<td>14.0 / 2030</td>
<td>-</td>
</tr>
<tr>
<td>120 / 248</td>
<td>9.0 / 1300</td>
<td>-</td>
</tr>
<tr>
<td>180 / 356</td>
<td>4.5 / 650</td>
<td>-</td>
</tr>
<tr>
<td>23 / 73 WA (3)</td>
<td>22.5 / 3200</td>
<td>-</td>
</tr>
</tbody>
</table>

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 7 days at 23°C/73°F
(2) According to EN 2243-2, aluminum 20243-2, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 7 days at 23°C/73°C
(3) WA: Wet ageing 70°C/158°F, 85% RH (saturation)

This information is provided for informal purposes only, without legal responsibility and does not constitute a specification. User 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® prepregs
- HexAM™ additive manufacturing
- HexMC® molding compounds
- HexFlow® RTM resins
- HexTool® tooling materials
- HexWeb® honeycombs
- HexBond™ adhesives
- 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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