Description
Low viscosity one-component paste adhesive. High peel and sheer strength with aluminum and composite substrates.

Features
- Low viscosity
- Low moisture absorption
- Maximum service temperature of 135°C/275°F

Uncured Adhesive Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Blue</td>
</tr>
<tr>
<td>Brookfield viscosity at 23°C / 73°F (Poise)</td>
<td>3100</td>
</tr>
<tr>
<td>Density (g/cm³)</td>
<td>1.15</td>
</tr>
<tr>
<td>Standard shelf-life at ≤ -18°C / 0°F &amp; ≤ 23°C / 73°F (From date of shipment)</td>
<td>1 year / 7 days</td>
</tr>
</tbody>
</table>

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

Mixing: One-component adhesive
No mixing required

Bonding surfaces should be clean, dry and properly prepared.

Curing: 1 hour at 121°C/250°F or 1 hour at 177°C/350°F
## Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test Description</th>
<th>Cure Cycle</th>
<th>Environmental Conditioning</th>
<th>Test Temperature (°C/°F)</th>
<th>Typical Values</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Shear</strong>: Lap shear strength (MPa / psi)</td>
<td>8 ± 0.5hrs at 179 ± 3°C (335 ± 5°F)</td>
<td>Dry</td>
<td>23 / 73</td>
<td>48 / 6960</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Wet</td>
<td>71 / 160</td>
<td>45 / 6500</td>
</tr>
<tr>
<td></td>
<td></td>
<td>1000hr at 71°C / 160°F &amp; 95% at RH</td>
<td>71 / 160</td>
<td>22 / 3190</td>
</tr>
<tr>
<td><strong>T-peel</strong> strength (N/mm)</td>
<td>2.75 ± 0.35 bar (40 ± 5 psi)(3)</td>
<td>Dry</td>
<td>23 / 73</td>
<td>170</td>
</tr>
<tr>
<td></td>
<td></td>
<td>71 / 160</td>
<td>135</td>
<td></td>
</tr>
</tbody>
</table>

(1) According to ASTM D 1002, on aluminum 2024T3 clad treated with sulfo-chromic acid etch
(2) According to ASTM D 1876, on aluminum 2024T3 clad treated with sulfo-chromic acid etch
(3) According to HS12973

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
- HexBond™ adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- 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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