HexBond™ EA934NA STRUCTIL
Two-component epoxy paste adhesive

**Description**
Thixotropic two-component epoxy adhesive. Its viscosity allows it to be used for structural bonding, potting, filling, liquid shim and fairing applications.

**Features**
- Room temperature curing (≥ 18°C/64°F)
- Excellent mechanical properties at temperatures ranging from -55°C/-67°F to 150°C/300°F
- High compression strength

**Uncured Adhesive Properties**

<table>
<thead>
<tr>
<th></th>
<th>Part A</th>
<th>Part B</th>
<th>Mixture</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Grey</td>
<td>Amber</td>
<td>Grey</td>
</tr>
<tr>
<td>Brockfield Viscosity at 23°C / 73°F (Poise)</td>
<td>4000 to 8000</td>
<td>10 to 30</td>
<td>80</td>
</tr>
<tr>
<td>Density (g/cm³)</td>
<td>1.55</td>
<td>0.96</td>
<td>1.36</td>
</tr>
<tr>
<td>Standard shelf-life ≤ 4°C / 39°F &amp; ≤ 23°C / 73°F</td>
<td>1 year / 3 months</td>
<td>1 year / 1 year</td>
<td></td>
</tr>
</tbody>
</table>

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

Mixing: Mix ratio by weight: Part A/Part B / 100/33
Thoroughly mix the two parts until the resulting colour is a consistent grey
Do not mix quantities greater than 450g as dangerous heat build-up can occur

Pot-life: Pot-life of 100g mass (Part A + B) at 23°C/73°C = 50 minutes

Bonding surfaces should be clean, dry and properly prepared.

Curing: 5 to 7 days at 23°C/73°F to achieve optimal performance

It is possible to reduce the cure time by heating at 93°C/200°F. The product must be kept at least 4 hours at room temperature prior to heating - For example, 120 minutes at 65°C/150°F or 60 minutes at 80°C/176°F for best performance.
## Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test Temperature (°C/°F)</th>
<th>Shear(^{(1)}): Lap Shear Strength (MPa / psi)</th>
<th>Compression(^{(2)}): Ultimate Strength (MPa / psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>23 / 73</td>
<td>22 / 3190</td>
<td>80 / 11600</td>
</tr>
<tr>
<td>80 / 176</td>
<td>13 / 1885</td>
<td>-</td>
</tr>
<tr>
<td>150 / 302</td>
<td>7 / 1015</td>
<td>-</td>
</tr>
</tbody>
</table>

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cured 7 days at 23°C/73°F

(2) According to ASTM D695, on rectangular sample 12.5mm side, 25mm high, cure 7 days at 23°C/73°F

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:

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- 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

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