HexBond™ EA9351 MB STRUCTIL
BMI Paste Adhesive

Product Data Sheet

Description
One component epoxy/bismaleimide potting resin for filling and stiffening of honeycomb sandwich structures.

Features
- Service temperature range: -55°C/-67°F to 210°C/410°F
- Good compressive strength up to 210°C/410°F
- Low density

Uncured Adhesive Properties

<table>
<thead>
<tr>
<th></th>
<th>HexBond™ EA9351 MB STRUCTIL</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Yellow</td>
</tr>
<tr>
<td>Packaging</td>
<td>3.5kg of product in a 10 litre pail</td>
</tr>
<tr>
<td>Density at 25°C/77°F after curing</td>
<td>0.6</td>
</tr>
<tr>
<td>Standard shelf life at -18°C/0°F from date of shipment (g/cm³)</td>
<td>12 months + 3 weeks at 23°C/73°F</td>
</tr>
</tbody>
</table>

Instructions For Use
Refer to the Safety Data Sheet before handling.
- Product needs to be warmed at 50°C/120°F for applying
- Cure cycle: 1h at 175°C/347°F + post cure 2h at 245°C/473°F under 5 bar pressure
- Heat up temperature: 2°C/min//3.6°F/min
Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Tests</th>
<th>Methods</th>
<th>Temperatures (°C/°F)</th>
<th>Values (MPa/psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Lap Shear</td>
<td>EN 2243-1</td>
<td>23 / 73</td>
<td>9 / 1300</td>
</tr>
<tr>
<td>Compression</td>
<td>DIN 53454</td>
<td>23 / 73</td>
<td>80 / 11600</td>
</tr>
<tr>
<td></td>
<td></td>
<td>210 / 410</td>
<td>40 / 5800</td>
</tr>
</tbody>
</table>

Surface preparation of aluminum 2024-T3 clad: Sulfo-chromic acid etch
Cure cycle: 1h at 175°C/347°F + post cure 2h at 245°C/473°F under pressure 2°C/min

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For more information
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- HexForce® reinforcements
- HiMax™ multiaxial reinforcements
- HexPly® prepregs
- HexAM™ additive manufacturing
- HexMC® molding compounds
- HexFlow® RTM resins
- Redux® adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed™ laminates

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