Description
Thixotropic two-component epoxy adhesive. Its viscosity allows for it to be used for structural bonding, potting, filling, liquid shim and fairing applications. HexBond™ EA9392 STRUCTIL is the toughened version of HexBond™ EA9394 STRUCTIL.

Features
- Room temperature curing (≥ 18°C/64°F)
- Excellent mechanical properties at temperatures ranging from -55°C/-67°F to 180°C/356°F
- Good toughness

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>Brookfield viscosity at 23°C / 73°F (Poise)</td>
<td>2000 to 6000</td>
<td>3000 to 7000</td>
<td></td>
</tr>
<tr>
<td>Density (g/cm³)</td>
<td>1.4</td>
<td>1.0</td>
<td></td>
</tr>
<tr>
<td>Standard shelf-life at ≤ 23°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 Material Safety Data Sheet before handling.

Mixing: Mix ration by weight: Part A/Part B: 100/32
- 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°F = 130 minutes

Bonding surfaces should be clean, dry and properly prepared.

Curing: 3 to 5 days at 23°C/73°F to achieve optimal performance

It is possible to reduce the polymerisation time by heating at a maximum temperature of 93°C/200°F. The product must be kept at least 4 hours at room temperature prior to testing. For example, 60 minutes at 65°C/150°F to obtain the 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>Peel(^{(2)}): Bell Peel Strength (N/25mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>23 / 73</td>
<td>29 / 4200</td>
<td>150</td>
</tr>
<tr>
<td>80 / 176</td>
<td>20 / 2900</td>
<td></td>
</tr>
<tr>
<td>121 / 250</td>
<td>17 / 2465</td>
<td></td>
</tr>
<tr>
<td>150 / 302</td>
<td>10 / 1450</td>
<td></td>
</tr>
</tbody>
</table>

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cured 5 days at 23°C/73°F

(2) According to EN 2243-2, on aluminum 2024T3 clad treated with sulfochromic acid etch, cured 5 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:

- 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:

[http://www.hexcel.com/contact/salesoffice](http://www.hexcel.com/contact/salesoffice)