HexBond™ EA9394 STRUCTIL Paste Adhesive

Description
Thruxotropic two-part epoxy adhesive. Its viscosity means it can be used for structural bonding, potting, filling, liquid shim and fairing applications.

Packaging: Kit 908g, dual cartridge 318g/200mL(1), dual cartridge 57g/50mL(2), Semkit® Injection 6oz/155g

Features
- Room temperature cure (≥ 18°C/64°F)
- Outstanding mechanical properties over a wide range of temperature (-55°C/-67°F to 180°C/356°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>Color</td>
<td>Grey</td>
<td>Black</td>
<td>Grey</td>
</tr>
<tr>
<td>Brookfield viscosity at 23°C / 77°F (Poise)</td>
<td>4000 to 8000</td>
<td>100 to 700</td>
<td>1600</td>
</tr>
<tr>
<td>Density (g/m³)</td>
<td>1.45</td>
<td>1.00</td>
<td>1.33</td>
</tr>
<tr>
<td>Standard shelf-life ≤ 23°C / 73°C from date of shipment</td>
<td>1 year</td>
<td>1 year</td>
<td></td>
</tr>
<tr>
<td>Shelf-life of dual cartridge ≤ 30°C / 86°F from date of shipment</td>
<td>10 months</td>
<td>10 months</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: 100/17
  Thoroughly mix both parts until the resulting colour is a consistent grey
  Pot-life of 100g mass (Part A + B) at 23°C/75°F = 150 minutes
  Do not mix quantities greater than 450g as dangerous heat build-up can occur
- Bonding surfaces should be clean, dry and properly prepared
- Curing: 3 to 5 days at 23°C/73°F to achieve optimal performance

The polymerisation time can be reduced by heating at maximum 93°C/200°F (leave the product for at least 4h at room temperature before heating). For example, 1h at 65°C/149°F to obtain the best performance.
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Rheometer TA Instrument AR 500 parallel plate (diameter 25mm)
Test conditions:
Temperature: 25°C
10% strain
Frequency 10 rad/sec
Gap 1000 μm

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): Compression Strength at 2% Offset (MPa / ksi)</th>
<th>Peel (3): Bell Peel Strength (N/25mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>-55 / -67</td>
<td>22 / 3200</td>
<td>173 / 25000</td>
<td>-</td>
</tr>
<tr>
<td>23 / 73</td>
<td>30 / 4300</td>
<td>68 / 9900</td>
<td>90</td>
</tr>
<tr>
<td>80 / 176</td>
<td>22 / 3200</td>
<td>43 / 6200</td>
<td>-</td>
</tr>
<tr>
<td>120 / 248</td>
<td>17 / 2450</td>
<td>37 / 5300</td>
<td>-</td>
</tr>
<tr>
<td>150 / 302</td>
<td>12 / 1750</td>
<td>-</td>
<td>-</td>
</tr>
</tbody>
</table>

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 5 days at 23°C/73°F
(2) According to ISO 604, on cylindrical test specimen 13.7mm diameter, 36mm high, cure 5 days at 23°C/73°F
(3) According to En 2243-2, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, cure 5 days at 23°C/73°C

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.

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
- Engineered core
- Acousti-Cap® sound attenuating honeycomb
- 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

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