Description
Liquid two-part epoxy resin adhesive. Its low viscosity makes it suitable for bonding by injection process and repairing by war lay up of fabrics.

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)
- Low viscosity

Uncured Adhesives 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>Blue</td>
<td>Orange</td>
<td>Green</td>
</tr>
<tr>
<td>Brookfield viscosity at 23°C / 73°F (Poise)</td>
<td>400 to 1000</td>
<td>0.4 to 1</td>
<td>35</td>
</tr>
<tr>
<td>Density (g/cm³)</td>
<td>1.20</td>
<td>1.00</td>
<td>1.14</td>
</tr>
<tr>
<td>Standard shelf-life (≤ 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 Safety Data Sheet before handling.

- **Mixing:** Mix ratio by weight: Part A/Part B 100/30
  Thoroughly mix both parts until the resulting colour is a consistent green
  Pot-life of 100g mass (Part A + B) at 23°C/73°F ≈ 80 mins
  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.
Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test Temperature (°C / °F)</th>
<th>Shear (1) Lap Shear Strength (MPa / psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>5 Days at 25°C / 77°F</td>
</tr>
<tr>
<td>23 / 73</td>
<td>33.8 / 4900</td>
</tr>
<tr>
<td>90 / 194</td>
<td>18.6 / 2700</td>
</tr>
<tr>
<td>110 / 230</td>
<td>14.7 / 2130</td>
</tr>
<tr>
<td>130 / 266</td>
<td>10.5 / 1520</td>
</tr>
</tbody>
</table>

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch

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For more information

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- 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:

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