HexBond™ EA9674 STRUCTIL
BMI Adhesive Film

**Description**

Hexbond™ EA9674 is an epoxy/bismaleimide film adhesive designed for high temperature bonding application. It is specially recommended for metal/metal or composite/metal bonding and for co-curing of sandwich structures.

**Features**

- Outstanding mechanical properties over a wide range of temperature (-55°C/-67°F to 210°C/410°F)
- Can be reticulate on acoustic panel
- Storage life: 1 year at or below -18°C/0°F +2 weeks at room temperature (≤ 23°C/73°F)

**Applications**

- Metal-to-metal bonding
- Sandwich construction
- Composite-to-composite bonding

**Uncured Adhesive Properties**

<table>
<thead>
<tr>
<th></th>
<th>Areal Weight (g/m²)</th>
<th>Support</th>
<th>Roll Width (mm)</th>
<th>Standard Roll m²</th>
</tr>
</thead>
<tbody>
<tr>
<td>EA9674.06 UNS</td>
<td>300</td>
<td>None</td>
<td>500</td>
<td>15</td>
</tr>
<tr>
<td>EA9674.06 GLS</td>
<td>300</td>
<td>Glass fabric</td>
<td>500</td>
<td>25</td>
</tr>
</tbody>
</table>

**Instructions For Use**

Refer to the Safety Data Sheet before handling.

- To avoid any moisture, allow the adhesive to warm at room temperature before opening the waterproof polyethylene bag
- Bonding surfaces should be clean, dry and properly prepared
- Remove protective liners before bonding (release paper and polyethylene film)
- Typical cure cycles: 1h at 180°C/356°F under pressure + 6h at 230°C/446°F without pressure
  - Heat up rate: 1 to 4°C/min
  - Pressure: 1.5 to 3.5 bar

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![HexBond™ EA9674 STRUCTIL viscosity while heating at 2°C/min](chart.png)
### Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test</th>
<th>Test Temperature (°C / °F)</th>
<th>EA9674.06 UNS</th>
<th>EA9674.06 GLS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Simple lap shear strength (MPa / psi)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(1)</td>
<td>23 / 73</td>
<td>31.4 / 4550</td>
<td>30.4 / 4400</td>
</tr>
<tr>
<td></td>
<td>180 / 356</td>
<td>30.5 / 4400</td>
<td>28.4 / 4100</td>
</tr>
<tr>
<td></td>
<td>230 / 446</td>
<td>-</td>
<td>14.0 / 2030</td>
</tr>
<tr>
<td></td>
<td>250 / 482</td>
<td>-</td>
<td>6.1 / 880</td>
</tr>
<tr>
<td>Honeycomb climbing drum peel torque (mN/m)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(2)</td>
<td>23 / 73</td>
<td>23.9</td>
<td>22.7</td>
</tr>
<tr>
<td>Flatwise tension strength (MPa / psi)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(3)</td>
<td>23 / 73</td>
<td>7.7 / 1100</td>
<td>7.7 / 1100</td>
</tr>
</tbody>
</table>

Cure: 1h at 140°C (284°F) + 3h at 190°C (374°F) under 2.5 bar + post cure: 8h at 230°C (446°F) without pressure/heat up/cool down rate: 1.5°C/min

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch
(2) According to EN 2243-3, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, honeycomb core aluminum PAA 5052 N 6.0 ¼, 16mm high, unslotted
(3) According to EN 2243-4, on aluminum 2024T3 clad treated with sulfo-chromic acid etch, honeycomb core aluminum PAA 5052 N 6.0 ¼, 16mm high, unslotted

The 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
- HexTool® tooling materials
- HexWeb® honeycombs
- HexBond™ adhesives
- 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)

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