**Description**
HexBond™ EA9833.1 50MIL is a 180°C/356°F cure modified bismaleimide foaming core splice adhesive.

**Features**
- High service temperature
- Expansion: 100% to 150%
- Storage life: 1 year minimum at or below -18°C/0°F + 3 weeks at room temperature (≤ 25°C/73°F)

**Applications**
- Core splice bonding
- Sandwich construction

**Form**

<table>
<thead>
<tr>
<th>Form</th>
<th>Weight (g/m²)</th>
<th>Thickness (mm)</th>
<th>Color</th>
<th>Package</th>
</tr>
</thead>
<tbody>
<tr>
<td>EA9833.1 50MIL</td>
<td>1655± 200</td>
<td>1.27</td>
<td>Green</td>
<td>Box of 3.72m² (20 sheets)</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 papers before bonding
- Typical cure cycles:
  - 1h at 177°C/350°F
  - Heat up rate: 0.5°C to 2.5°C/min
  - Post cure: 2h to 6h at 204°C/400°F to 246°C/475°F for optimum properties
HexBond™ EA9833.1 STRUCTIL Adhesive Film

Mechanical Properties

<table>
<thead>
<tr>
<th>Test</th>
<th>Test Temperature (°C/°F)</th>
<th>EA9833.1 50MIL Typical Result (MPa/psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>-55 / -67</td>
<td>14.5 / 2100</td>
</tr>
<tr>
<td></td>
<td>23 / 73</td>
<td>12.5 / 1800</td>
</tr>
<tr>
<td></td>
<td>150 / 300</td>
<td>10.5 / 1500</td>
</tr>
<tr>
<td></td>
<td>210 / 410</td>
<td>10.0 / 1450</td>
</tr>
<tr>
<td></td>
<td>23 / 73 after WA (3)</td>
<td>14.5 / 2100</td>
</tr>
<tr>
<td></td>
<td>150 / 300 after WA (3)</td>
<td>11.0 / 1600</td>
</tr>
<tr>
<td></td>
<td>210 / 410 after WA (3)</td>
<td>6.0 / 870</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Test</th>
<th>Conditioning</th>
<th>EA9833.1 50MIL Tg Onset Storage Modulus (°C/°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Initial</td>
<td>293 / 559</td>
</tr>
<tr>
<td></td>
<td>WA (3)</td>
<td>280 / 536</td>
</tr>
</tbody>
</table>

(1) According to prEN 2667-2, on aluminum 5052 treated with sulfo-chromic acid etch, cure(4)
(2) According to prEN 6032, cure(4)
(3) Wet ageing: 1000 hours at 70°C/158°F and 85% relative humidity
(4) Cure cycle:
  2.5°C/min from ambient 10 177°C/350°F +1h at 177°C/350°F +
  2.2°C/min from 177°C/350°F to 225°C +2h at 225°C/437°F (post cure) +
  -1.7°C/min from 225°C/427°F to ambient

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
- Redux® 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:

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