HexBond™ ST1030
Two-component epoxy paste adhesives

Description
Two-component epoxy adhesive. Designed for composite repair by wet lay-up process and bonding by injection.

Features
- Cure temperature > 90°C/194°F
- Service temperature up to 200°C/392°F
- Low viscosity

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>Beige</td>
<td>Black</td>
<td>Black</td>
</tr>
<tr>
<td>Brookfield viscosity at 23°C/73°F (Poise)</td>
<td>600 to 10000</td>
<td>0.8 to 1.6</td>
<td>80</td>
</tr>
<tr>
<td>Density (g/cm³)</td>
<td>1.22</td>
<td>0.95</td>
<td>1.13</td>
</tr>
<tr>
<td>Standard shelf-life at ≤ 4°C (39°F) &amp; ≤ 23°C (73°F) (From date of shipment)</td>
<td>1 year / 6 months</td>
<td>1 year / 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: 100/49
- Thoroughly mix the two parts until the resulting colour is a consistent black
- 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 > 5 hours

Bonding surfaces should be clean, dry and properly prepared.

Curing: 220 minutes at 93°C/200°F or 130 minutes at 149°C/300°F with pressure from 0.5 to 1 bar to acheive optimal performance.
## Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test</th>
<th>Cure Cycle</th>
<th>Environmental Conditioning</th>
<th>Test Temperature (^{\circ}\text{C}/^{\circ}\text{F})</th>
<th>Typical Values (\text{MPa} / \text{psi})</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shear(^{(1)}): Lap shear strength</td>
<td>220 minutes at 93(^{\circ}\text{C} / 200^{\circ}\text{F})</td>
<td>Dry</td>
<td>23 / 73</td>
<td>21.6 / 3130</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>82 / 180</td>
<td>30.9 / 4480</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>121 / 250</td>
<td>27.7 / 4020</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>149 / 300</td>
<td>21.8 / 3160</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>177 / 350</td>
<td>18.3 / 2650</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>200 / 392</td>
<td>11.9 / 1725</td>
</tr>
</tbody>
</table>

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

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
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- HexTow\(^{\text{®}}\) carbon fibers
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- HexPly\(^{\text{®}}\) prepregs
- HexAM\(^{\text{™}}\) additive manufacturing

- HexMC\(^{\text{®}}\) molding compounds
- HexFlow\(^{\text{®}}\) RTM resins
- HexBond\(^{\text{™}}\) adhesives
- HexTool\(^{\text{®}}\) tooling materials
- HexWeb\(^{\text{®}}\) honeycombs

- Acousti-Cap\(^{\text{®}}\) sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed\(^{\text{™}}\) laminates

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