Description
Toughened two-part adhesive, specifically designed for metal skins, composites, thermoplastic and thermosetting materials and elastomers bonding. This paste adhesive has very good performance on grinding surfaces.

Features
- Cure 2h at 65°C/149°F or 15 days at room temperature
- Service temperature to 120°C/248°F
- High shear and peel strength (even with a grinding surface)
- Good tolerance to the surfaced preparation and the type of substrate

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>Pink</td>
<td>Yellow</td>
<td>Pink</td>
</tr>
<tr>
<td>Brookfield viscosity at 23°C/73°F (Poise)</td>
<td>300 to 600</td>
<td>0.1 to 0.3</td>
<td>500</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: 100/29
  Thoroughly mix the two parts until the resulting colour is a consistent pink
  Do not mix quantities greater than 450g as heat build-up can occur
- Bonding surfaces should be clean, dry and properly prepared
- Curing: 2h at 65°C/149°F to achieve optimal performance or 15 days at room temperature (23°C/73°F)
## Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test Temperature (°C / °F)</th>
<th>Lap Shear Strength (MPa / psi)</th>
<th>Bell Peel Strength (N/25mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>2 Hours at 65°C / 149°F</td>
<td>15 days at 23°C / 73°F</td>
</tr>
<tr>
<td>23 / 73</td>
<td>45 / 6500</td>
<td>37 / 5300</td>
</tr>
<tr>
<td>80 / 176</td>
<td>28 / 4000</td>
<td>18 / 2600</td>
</tr>
<tr>
<td>120 / 248</td>
<td>5 / 725</td>
<td>4 / 580</td>
</tr>
</tbody>
</table>

(1) According to EN 2243-1, on aluminum 2024T3 clad treated with sulfo-chromic acid etch
(2) According to EN 2243-2, 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.

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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
- 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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