**Description**
Two-part epoxy adhesive. This product is designed for applications requiring high deformation. It is adapted to paste any rubber EPDM and suitable for low temperature applications down to -40°C/-40°F.

**Features**
- Room temperature curing ≥ 18°C/64°F
- High elongation at break ≈ 85% at 23°C/73°F
- Long pot-life

**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>White</td>
<td>Amber</td>
<td>Amber</td>
</tr>
<tr>
<td>Brookfield viscosity at 23°C / 73°F (Poise)</td>
<td>300 to 500</td>
<td>1000 to 3000</td>
<td>-</td>
</tr>
<tr>
<td>Density (g/cm³)</td>
<td>-</td>
<td>-</td>
<td>-</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: 100/200
- Thoroughly mix the two parts until the resulting colour is a consistent amber
- Do not mix quantities greater than 450g as dangerous heat build-up can occur

Pot-life: Pot-life at 23°C/73°F for 2 hours

Bonding surfaces should be clean, dry and properly prepared.

Curing: 5 to 7 days at 23°C/73°F to achieve optimal performance
- Cure time can be reduced by heating for 1 hour at 60°C/140°F
Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test</th>
<th>Cure Cycle</th>
<th>Environmental Conditioning</th>
<th>Test Temperature (°C / °F)</th>
<th>Typical Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shear(^{(1)}): Lap shear strength (MPa / psi)</td>
<td>7 days at 23°C / 73°F</td>
<td>Dry</td>
<td>23 / 73</td>
<td>17 / 2465</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>82 / 180</td>
<td>5 / 725</td>
</tr>
<tr>
<td>Bell peel strength(^{(2)})</td>
<td>7 days at 23°C / 73°F</td>
<td>Dry</td>
<td>82 / 180</td>
<td>150</td>
</tr>
</tbody>
</table>

(1) According to EN 2243-1, on aluminum 2024T3 clad, 1.6mm, 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.

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
- HexBond™ 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:

http://www.hexcel.com/contact/salesoffice