HexBond™ EA9685-1 STRUCTIL
Epoxy Fillet

Description
HexBond™ EA 9685-1 Epoxy Fillet is a profile of semi-solid resin designed to be used in self-stiffened composite panels manufacturing. Its function is to fill the cavity between the panel and the stiffener. HexBond™ EA 9685-1 is a 180°C/356°F cure epoxy resin. When curing, due to its rheology, the resin fills the cavity without excess flow nor air trap.

Example of configuration:

![EA 9685-1 Epoxy Fillet is pre-shaped with an equilateral triangle section](image1)

![EA 9685-1 Epoxy Fillet is pre-shaped with an isosceles right-angled triangle section](image2)

Features
- Co-curable with most 180°C / 356°F cure prepreg systems
- Allows saving work time
- Assuring good reproducibility of structures
- Spares the use of rolled resin film or UD tape

Uncured Adhesive Properties
The length of a Fillet is 1 meter; it is supplied on a PVC support. The support's color varies according to the reference, see the following table. HexBond™ EA 9685-1 Epoxy Fillet is available as sets of 35 profiles of 1m.

<table>
<thead>
<tr>
<th>Pre-shape section</th>
<th>Equilateral triangle</th>
<th>Isosceles right-angled triangle</th>
</tr>
</thead>
<tbody>
<tr>
<td>Indicative dimensions</td>
<td>5 mm</td>
<td>6.4 mm</td>
</tr>
<tr>
<td>Linear mass</td>
<td>15.5 ± 3 g/m</td>
<td>12.5 ± 2 g/m</td>
</tr>
<tr>
<td>Airbus Specification</td>
<td>ASNA 5052</td>
<td>IPS 10-17-002-01</td>
</tr>
<tr>
<td>Support color</td>
<td>White</td>
<td>Yellow</td>
</tr>
<tr>
<td>Length (m)</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>Units per packaging</td>
<td>35</td>
<td>35</td>
</tr>
</tbody>
</table>

Product shelf life from date of manufacturing is 2 years at -18°C / 0°F and 3 weeks at ambient temperature (≤ 25°C/77°F).
Instructions for use
Refer to the Safety Data Sheet before handling.

- Usual precautions necessary when handling epoxy resins should be observed.
- In case of several fillets laid up in the same cavity, the exothermic risk when curing has to be considered.
- Before using, the set should be removed from the freezer and store at 20-25°C in its original packaging until warming to room temperature
- The standard cure cycle is 1 hour at 180°C/356°F.

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
- HexMC® molding compounds
- HexFlow® RTM resins
- Redux® & HexBond™ adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed® laminates & pultruded profiles
- HexAM™ additive manufacturing

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

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