**Description**

Liquid two-part epoxy adhesive filled with microspheres. Its low viscosity allows to be used for filling, potting and fastening inserts applications.

Packaging: Semkit® barrier cartridge 6oz – 60 g.

**Features**

- Room temperature cure (≥ 18°C/ 64°F)
- Low density: Filled with ≈ 12 % of glass microspheres with a density of 0,2 (crush-resistance: 1000 PSI / 6,9 MPa)
- Outstanding mechanical properties over a wide range of temperature

**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>Blue</td>
<td>Black</td>
<td>Grey</td>
</tr>
<tr>
<td>Density</td>
<td></td>
<td></td>
<td>0.70</td>
</tr>
<tr>
<td>Standard shelf life</td>
<td>1 year</td>
<td>1 year</td>
<td></td>
</tr>
</tbody>
</table>

|                      |        |        |
| Standard shelf life  | 1 year | 1 year |

**Instructions for use**

Refer to the Safety Data Sheet before handling.

- Mixing: Semco MC Standard-type mixer.
  - 90 back-and-forth en 2 min 30 sec.
  - Propeller speed: 120 tr/min.
- The use of the cartridge shall not exceed 1 hour. If the cartridge is not entirely used, discharge and spread the remaining product before discarding the product.

- **Do not mix quantities greater than 60g as dangerous buildup can occur.**
- Curing: 3 to 5 days at 25°C / 77°F

The polymerisation time can be reduced by heating at maximum 93°C / 200°F (leave the product for at least 4 hours at room temperature before heating). For example, one hour at 65°C/ 149°F to obtain the best performance.
## Bond Strength Performance After Cure

<table>
<thead>
<tr>
<th>Test temperature ('C/ °F)</th>
<th>Shear (1) : Lap shear strength (MPa/psi)</th>
<th>Compression (2) : Compression strength (MPa/psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Curing 5 days at 25°C/ 77°F</td>
<td>Curing 1 h at 65°C/ 149°C</td>
</tr>
<tr>
<td>23 / 73</td>
<td>18,6 / 2700</td>
<td>20,8 / 3000</td>
</tr>
<tr>
<td>80 / 176</td>
<td>-</td>
<td>17,4 / 2500</td>
</tr>
<tr>
<td>100 / 212</td>
<td>-</td>
<td>15,7 / 2250</td>
</tr>
<tr>
<td>120 / 120</td>
<td>-</td>
<td>12,9 / 1870</td>
</tr>
<tr>
<td>150 / 150</td>
<td>-</td>
<td>10,6 / 1500</td>
</tr>
<tr>
<td>180 / 356</td>
<td>-</td>
<td>6,6 / 950</td>
</tr>
</tbody>
</table>

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

(2) According to DIN 53454, rectangular blocks 12,5 × 12,5 × 25 mm.

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](http://www.hexcel.com/contact/salesoffice)