

Product Data

Aerospace Adhesives



Paste Adhesive

EA 9309.3NA STRUCTIL



DESCRIPTION

Toughened two-part adhesive, specially designed for metal skins, composites, thermoplastic and thermosetting materials and elastomers bonding.

FEATURES

- Room temperature cure ($\geq 18^{\circ}\text{C}$)
- Service temperature to 80°C
- High shear and peel strength
- 0.12 mm glass beads for bondline thickness control
- Good tolerance to the surfaced preparation and the type of substrate

UNCURED ADHESIVES PROPERTIES

	PART A	PART B	MIXTURE
Colour	Pink	Blue	Pink
Brookfield viscosity at 25°C (Poise)	1800 - 3800	0.1 - 0.3	1600
Density	1.15	1.00	1.12
Shelf life at 4°C / 25°C from date of shipment	1 year	1 year	

INSTRUCTIONS FOR USE

- Refer to the Material Safety Data Sheet before handling.
- Mixing:

Mix ratio by weight: Part A / Part B 100/22.

Thoroughly mix the two parts. The resulting colour is a consistent pink.

Pot life of 100g mass (part A + B) at 25°C : ≈ 40 minutes.

Do not mix quantities greater than 450g as dangerous heat buildup can occur.

- Bonding surfaces should be clean, dry and properly prepared.
- Curing: 3 to 5 days at 25°C to achieve optimal performance.

The polymerisation time can be reduced by heating at 70°C for 2 hours or at 80°C for one hour.

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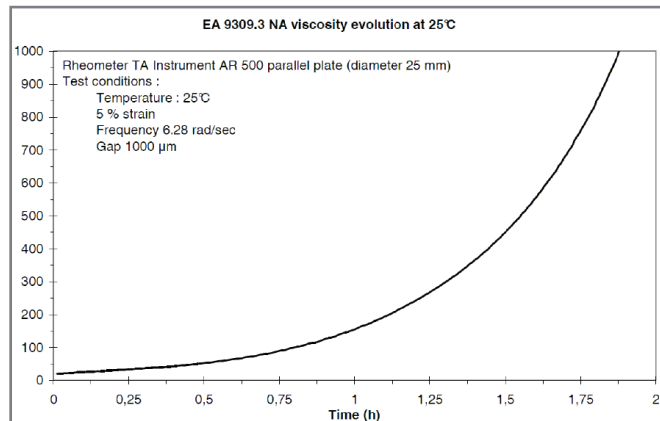
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BOND STRENGTH PERFORMANCE AFTER CURE

TEST TEMPERATURE (°C)	SHEAR ⁽¹⁾		PEEL ⁽²⁾	
	LAP SHEAR STRENGTH (MPa)		BELL PEEL STRENGTH (N/mm)	
	7 days at 25°C	2h at 70°C	7 days at 25°C	2h at 70°C
-55	44.8	38	10.4	/
23	35	33	12	6.9
60	12.5	25	/	/
80	6.9	/	/	/

⁽¹⁾ According to EN 2243-1, on aluminium 2024T3 glad treated with sulfo-chromic acid etch, cure 5 days at 25°C

⁽²⁾ According to EN 2243-2, on aluminium 2024T3 glad treated with sulfo-chromic acid etch, cure 5 days at 25°C

All values are nominal.

Important notice

All statements, technical information and recommendations offered are only for consideration and evaluation. Whilst they are believed to be accurate they are not guaranteed and are provided without warranty of any kind. No undertaking is given that the goods/products supplied are fit for any particular purpose and the buyer/user should rely upon its own tests to establish suitability of the goods/products for its particular purpose. The buyer/user shall assume all risks and liabilities in connection therewith.

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