

# Product Data

## Aerospace Adhesives



## Paste Adhesive

### EA 9321 STRUCTIL



#### DESCRIPTION

Thixotropic two-part epoxy adhesive. Its viscosity allows it to be used for potting, edge filling, shimming, fairing and bonding applications.

Packaging: Kit 908g, Semkit® barrier cartridge 6oz 195g, Semkit® barrier cartridge 2.5oz 60g.

#### FEATURES

- Room temperature cure ( $\geq 18^{\circ}\text{C}$ )
- Excellent mechanical properties over a range of temperature  $-55^{\circ}\text{C}$  to  $120^{\circ}\text{C}$

#### UNCURED ADHESIVES PROPERTIES

|  | PART A            | PART B          | MIXTURE |
|--|-------------------|-----------------|---------|
| Colour   | Grey              | Off-white       | Grey    |
| Brookfield viscosity at $25^{\circ}\text{C}$ (Poise)                           | 3000 - 6000       | 350 - 1000      |         |
| Density  | 1.31              | 1.24            | 1.25    |
| Shelf life at $4^{\circ}\text{C}$ / $25^{\circ}\text{C}$ from date of shipment | 1 year / 3 months | 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 100/50.

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

Pot life of 100g mass (part A + B) at  $25^{\circ}\text{C}$ :  $\approx 60$  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  $25^{\circ}\text{C}$  to achieve optimal performance.

The polymerisation time can be reduced by heating at maximum  $80^{\circ}\text{C}$ . For example, 1 hour at  $80^{\circ}\text{C}$  to obtain the best performance.

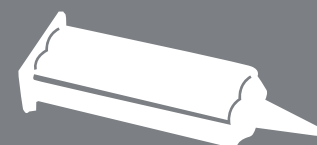
PRF Composite Materials

3 Upton Road, Poole, Dorset BH17 7AA, England

• t: +44 (0) 1202 680022 • f: +44 (0) 1202 680077

• e: [orders@prfcomposites.com](mailto:orders@prfcomposites.com)

[www.prfcomposites.com](http://www.prfcomposites.com)



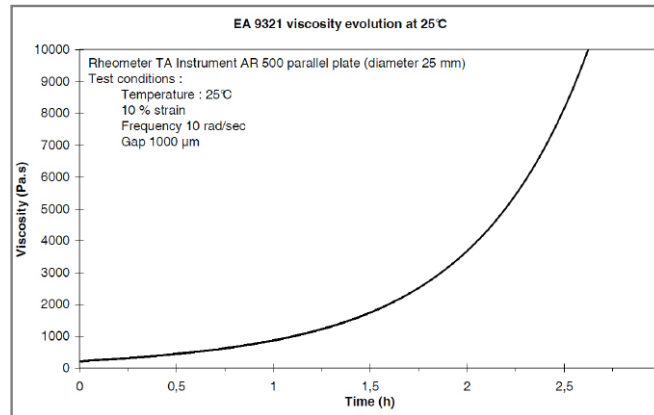
# Product Data

## Aerospace Adhesives



## Paste Adhesive

### EA 9321 STRUCTIL



#### BOND STRENGTH PERFORMANCE AFTER CURE

| TEST TEMPERATURE (°C) | SHEAR <sup>(1)</sup>     | PEEL <sup>(2)</sup>       |
|-----------------------|--------------------------|---------------------------|
|                       | LAP SHEAR STRENGTH (MPa) | BELL PEEL STRENGTH (N/mm) |
|                       | 7 days at 25°C           | 7 days at 25°C            |
| -55                   | 24                       | /                         |
| 23                    | 27                       | 3                         |
| 80                    | 15                       | /                         |
| 100                   | 14                       | /                         |
| 120                   | 9                        | /                         |
| 180                   | 4.5                      | /                         |
| 23 WA <sup>(3)</sup>  | 22.5                     | /                         |

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

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

<sup>(3)</sup> WA: wet ageing 70°C, 85% RH (saturation)

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.

EA 9321 STRUCTIL ed. 1.2 Jul 2015

Plastic Reinforcement  
 Fabrics Ltd



PRF Composite Materials  
 3 Upton Road, Poole, Dorset BH17 7AA, England  
 • t: +44 (0) 1202 680022 • f: +44 (0) 1202 680077  
 • e: orders@prfcomposites.com  
 www.prfcomposites.com

