

Product Data

Aerospace Adhesives



Paste Adhesive

EA 934NA STRUCTIL



DESCRIPTION

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

FEATURES

- Room temperature cure ($\geq 18^{\circ}\text{C}$)
- Outstanding mechanical properties over a wide range of temperature (-55°C to 150°C)
- High compression strength

UNCURED ADHESIVES PROPERTIES

	PART A	PART B	MIXTURE
Colour	Grey	Amber	Grey
Brookfield viscosity at 25°C (Poise)	4000 - 8000	10 - 30	80
Density	1.55	0.96	1.36
Shelf life at 4°C / 25°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 100/33.

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

Pot life of 100g mass (part A + B) at 25°C : ≈ 50 minutes.

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

- Bonding surfaces should be clean, dry and properly prepared.
- Curing: 5 to 7 days at 25°C to achieve optimal performance.

The cure time can be reduced by heating at maximum 93°C (leave the product for a least 4 hours at room temperature before heating). For example, 2 hours at 65°C or 1 hour @ 80°C to obtain the best performance.

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BOND STRENGTH PERFORMANCE AFTER CURE		
TEST TEMPERATURE (°C)	SHEAR ⁽¹⁾ LAP SHEAR STRENGTH (MPa)	COMPRESSION ⁽²⁾ ULTIMATE STRENGTH (MPa)
23	22	80
80	13	
150	7	

⁽¹⁾ According to EN 2243-1, on aluminium 2024T3 glad treated with sulfo-chromic acid etch, cure 7 days at 25°C

⁽²⁾ According to ASTM D695, on rectangular sample 12.5 mm side, 25 mm high, cure 7 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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