

Product Data

Aerospace Adhesives



Paste Adhesive

EA 9390 STRUCTIL



DESCRIPTION

Two-component epoxy adhesive. Designed for composite repair by wet lay up process and bonding by injection.

FEATURES

- Temperature cure >90°C
- Service temperature to 180°C

UNCURED ADHESIVE PROPERTIES

	PART A	PART B	MIXTURE
Colour	Beige	Blue	Blue
Brookfield viscosity at 25°C (Poise)	600 to 10000	0.8 - 1.6	80
Density (g/mL)	1.22	0.95	1.33
Shelf life at 4°C / 25°C from date of shipment	1 year / 6 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 100/56.
Thoroughly mix the two parts. The resulting colour is a consistent grey.
Pot life of 100g mass (part A + B) at 25°C: > 5 hours.
Do not mix quantities greater than 450g as dangerous heat buildup can occur.
- Bonding surfaces should be clean, dry and properly prepared.
- Curing: 200 minutes at 93°C or 130 minutes at 150°C with a pressure from 0.5 to 1.0 bar.

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



Product Data

Aerospace Adhesives



Paste Adhesive

EA 9390 STRUCTIL

BOND STRENGTH PERFORMANCE AFTER CURE	
TEST TEMPERATURE (°C)	SHEAR ⁽¹⁾ LAP SHEAR STRENGTH (MPa)
23	20
180	15

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

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 9390 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

