

# Product Data

## Aerospace Adhesives



## Paste Adhesive

### EA 9394 STRUCTIL



#### DESCRIPTION

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

Packaging: Kit 908g, dual cartridge 318g / 200ml<sup>(1)</sup>, dual cartridge 57g / 50ml<sup>(2)</sup>, Semkit® Injection 6oz / 155g.

<sup>(1)</sup> Extrusion process with a SETE-MIP CO200PB-MR/SA dispenser with a ratio 4/1 (pneumatic gun)

<sup>(2)</sup> Extrusion process with a Mixpac DMA 50 / PLA 050-01 dispenser with a ratio 4/1 (manual gun)

#### FEATURES

- Room temperature cure ( $\geq 18^{\circ}\text{C}$ )
- Outstanding mechanical properties over a wide range of temperature ( $-55^{\circ}\text{C}$  to  $180^{\circ}\text{C}$ )
- High compression strength

#### UNCURED ADHESIVE PROPERTIES

	PART A	PART B	MIXTURE
Colour	Grey	Black	Grey
Brookfield viscosity at 25°C (Poise)	4000 - 8000	100 - 700	1600
Density	1.45	1.00	1.33
Shelf life at $\leq 25^{\circ}\text{C}$ 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 100/17.

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

Pot life of 100g mass (part A + B) at 25°C:  $\approx 150$  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 maximum 93°C (leave the product for a least 4 hours at room temperature before heating). For example, one hour at 65°C to obtain the best performance.

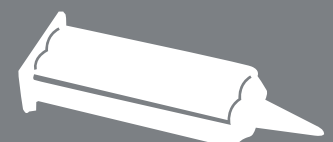
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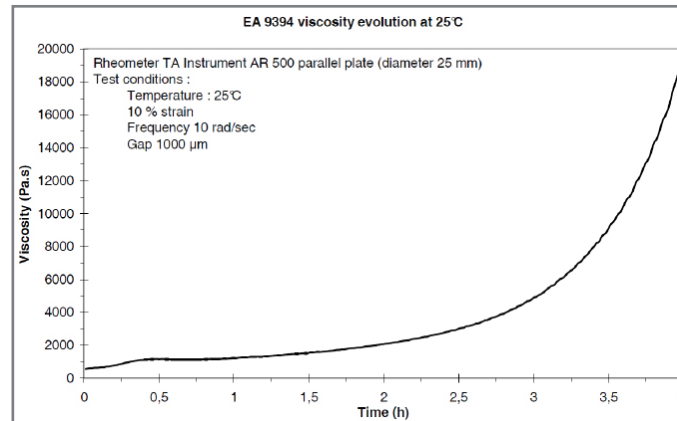
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### BOND STRENGTH PERFORMANCE AFTER CURE

TEST TEMPERATURE (°C)	SHEAR <sup>(3)</sup> LAP SHEAR STRENGTH (MPa)	COMPRESSION <sup>(4)</sup>		PEEL <sup>(5)</sup> BELL PEEL STRENGTH (N/mm)
		COMPRESSION STRENGTH AT 2% OFFSET (MPa)	MODULUS (MPa)	
-55	22	173	4040	
23	30	68	2870	90
80	22	43	2640	
120	17	37	1530	
150	12			

<sup>(3)</sup> According to EN2243-1, on aluminium 2024T3 glad treated with sulfo-chromic acid etch, cure 5 days at 25°C

<sup>(4)</sup> According to ISO 604, on cylindrical test specimen 13.7mm diameter, 36mm high, cure 5 days at 25°C

<sup>(5)</sup> 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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