

Product Data

Aerospace Adhesives



Paste Adhesive

EA 9396 STRUCTIL



DESCRIPTION

Liquid two-part epoxy resin adhesive. Its low viscosity allows it to be used for bonding by injection process and repairing by wet layup of fabrics.

FEATURES

- Low viscosity
- Room temperature cure ($\geq 18^{\circ}\text{C}$)
- Excellent mechanical properties over a wide range of temperature (-55°C to 180°C)

UNCURED ADHESIVE PROPERTIES

	PART A	PART B	MIXTURE
Colour	Blue	Orange	Green
Brookfield viscosity at 25°C (Poise)	400 - 1000	0.4 - 1.0	35
Density	1.20	1.00	1.14
Shelf life ($\leq 25^{\circ}\text{C}$) 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 100/30.

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

Pot life of 100g mass (part A + B) at $25^{\circ}\text{C} \approx 80$ 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, 1 hour at 65°C to obtain the best performance.

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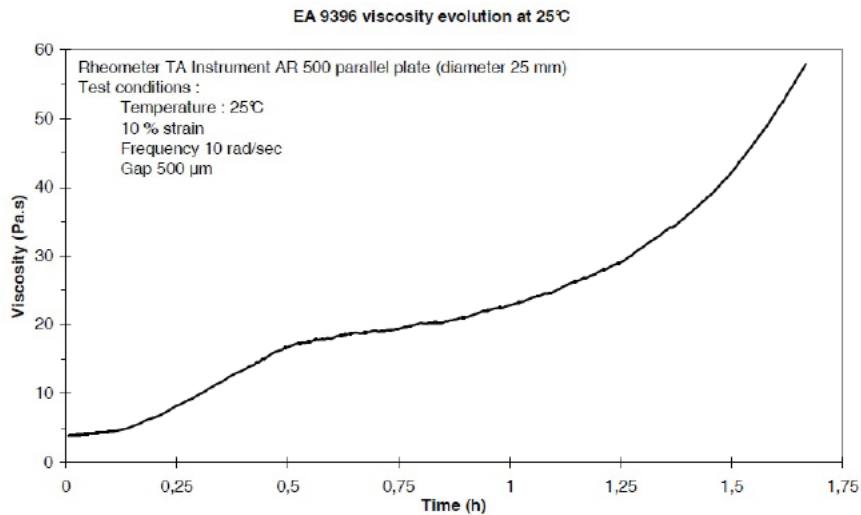
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BOND STRENGTH PERFORMANCE AFTER CURE

TEST TEMPERATURE (°C)	SHEAR LAP SHEAR STRENGTH (MPa)	
	Cure 1 hour at 65°C	Cure 7 days at 25°C
23	28.4	33.8
90	22.3	18.6
110	18.4	14.7
130	15.1	10.5

According to EN 2243-1, 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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