



Hysol® EA 9396/C-2

Epoxy Paste Adhesive

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Description

Hysol EA 9396/C-2 is an elevated curing, low viscosity structural adhesive. Hysol EA 9396/C-2 uses a non-aromatic amine curing agent that retains many of the excellent properties offered by aromatic amine curing systems.

Features

Low Viscosity
Long Worklife
Non-MDA Curing Agent
Ideal for use as Neat Lay-up Resin

Uncured Adhesive Properties

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	Blue	Purple	Violet
Viscosity @ 77°F	800 - 1,200 Poise	1 Poise	
Brookfield, HBT	Spdl 4 @ 10 rpm	Spdl 6 @ 100 rpm	
Viscosity @ 25°C	80 - 120 Pa·S	0.1 Pa·S	
Brookfield, HBT	Spdl 4 @ 1.0 rad/s	Spdl 6 @ 10.5 rad/s	
Density (g/ml)	1.17	1.00	
Shelf life			
@ <40°F/4°C	1 year	1 year	
@ <77°F/25°C	1 year	1 year	

This material will normally be shipped at ambient conditions, which will not alter our standard warranty, provided that the material is placed into its intended storage upon receipt. Premium shipment is available upon request.

Handling

Mixing - This product requires mixing two components together just prior to application to the parts to be

Note: Volume measurement is not recommended for structural applications unless special precautions are taken to assure proper ratios.

bonded. Complete mixing is necessary. The temperature of the separate components prior to mixing is not critical, but should be close to room temperature (77°F/25°C).

<u>Mix Ratio</u>	<u>Part A</u>	<u>Part B</u>
By Weight	100	36

Pot Life (100 g mass) 480 minutes @ 77°F/25°C
Method - ASTM D2471 in water bath.

Application

Mixing - Combine Part A and Part B in the correct ratio and mix thoroughly. **THIS IS IMPORTANT!** Heat buildup during or after mixing is normal. Do not mix quantities greater than 450 grams as dangerous heat buildup can occur causing uncontrolled decomposition of the mixed adhesive. **TOXIC FUMES CAN OCCUR, RESULTING IN PERSONAL INJURY.** Mixing smaller quantities will minimize the heat buildup.

Applying - Bonding surfaces should be clean, dry and properly prepared. For optimum surface preparation consult the Hysol Surface Preparation Guide. The bonded parts should be held in contact until the adhesive is set.

Curing - This adhesive should be cured for a minimum of 1 hour @ 200°F/93°C to achieve normal performance.

Cleanup - It is important to remove excess adhesive from the work area and application equipment before it hardens. Denatured alcohol and many common industrial solvents are suitable for removing uncured adhesive. Consult your supplier's information pertaining to the safe and proper use of solvents.

Bond Strength Performance

Tensile Lap Shear Strength

Tensile lap shear strength tested per ASTM D1002 after curing for 1 hour @ 180°F/82°C.

Adherends are 2024-T3 bare aluminum treated with phosphoric acid anodized per ASTM D3933.

<u>Test Temperature °F/°C</u>	Typical Results	
	psi	MPa
-67/-55	2,500	17.2
77/25	3,000	20.7
180/82	2,100	14.5
250/121	1,800	12.4
300/149	1,700	11.7
350/177	1,600	11.0
400/204	1,200	8.3
500/260	400	2.8

Service Temperature

Service temperature is defined as that temperature at which this adhesive still retains 1000 psi/6.9 MPa using test method ASTM D1002 and is approximately 400°F/204°C.

Handling Precautions

Do not handle or use until the Material Safety Data Sheet has been read and understood.

For industrial use only.

General:

As with most epoxy based systems, use this product with adequate ventilation. Do not get in eyes or on skin. Avoid breathing the vapors. Wash thoroughly with soap and water after handling. Empty containers retain product residue and vapors, so obey all precautions when handling empty containers.

PART A

CAUTION! This material may cause eye and skin irritation or allergic dermatitis. It contains epoxy resins.

PART B

WARNING! This material causes eye and skin irritation or allergic dermatitis. It contains amines.

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Users should review the Materials Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and label are available upon request.

