



## Hysol® EA 9205R

### Adhesive Bonding Primer

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#### Description

Hysol EA 9205R is a corrosion inhibiting adhesive bonding primer which has been designed for long term service @ 350°F/177°C and intermittent use @ 420°F/216°C. It is particularly suited for use in conjunction with EA 9689 film adhesive.

#### Features

Adhesive Bonding Primer  
Effective as a Corrosion Inhibitor in the Bondline  
Long Term, High Service Temperature  
Easy Application

#### Uncured Adhesive Properties

Color	<b>One Part</b> Yellow-Green
Solids	20%
Density	7.5 lbs/gal (0.9 kg/l)
Warranty Life @ 0°F/-18°C	6 months

#### Handling

This product is a one component primer. Warm to room temperature (77°F/25°C), then mix well before using. Since the primer contains insoluble pigments, COMPLETE MIXING AND CONTINUOUS AGITATION IS REQUIRED! This product contains solvents which are flammable. Observe all necessary precautions for the proper and safe use of solvents.

#### Application

**Applying** - Bonding surfaces should be clean, dry and properly prepared. For optimum surface preparation consult the Hysol Surface Preparation Guide. The primer should be sprayed after mixing well (15 to 30 minutes) using the following procedure:

1. Spray to a dry primer film thickness of 0.1 to 0.3 mils (0.003 to 0.008 mm).
2. Air dry the primed surfaces for at least 30-60 minutes before cure.

**Curing** - Hysol EA 9205R should be cured 1 hour @ 350°F/177°C prior to bonding with a film or paste adhesive.

**Open Assembly Time** - Parts, which have been primed and cured, may be stored for up to 6 months. They should be protected from gross contamination during storage. Just prior to the adhesive application, the surfaces to be bonded should be wiped with a ketone solvent.

**Cleanup** - Overspray must be removed prior to curing the primer. Uncured primer may be removed with a ketone solvent in a well ventilated area. Saturate a clean cloth or industrial wiper with solvent and apply just enough to do the job. Consult your solvent supplier's information pertaining to the safe and proper use of flammable solvents.

### ***Bond Strength Performance***

The physical property data was generated using Hysol EA 9205R primer with Hysol EA 9689 film adhesive. Please consult Hysol EA 9689 Data Sheet for these properties.

### **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.

***DANGER! FLAMMABLE!*** Keep away from heat, sparks or flame. Do not cut or weld on or near this container. Contains a small amount of strontium chromate, a carcinogen, for corrosion protection. Avoid all contact.

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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.

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