



Hysol[®] EA 9346.5

Epoxy Paste Adhesive

Loctite Aerospace

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Description

Hysol EA 9346.5 is a low viscosity one-component paste adhesive that has high peel and high shear strength when bonded to aluminum and composite substrates.

Features

Low Viscosity
Low Moisture Absorption
275°F/135°C Service

Uncured Adhesive Properties

Color	Blue
Viscosity @ 77°F	3500 Poise
Brookfield, HBT	7 @ 20 rpm
Viscosity @ 25°C	350 Pa-S
Brookfield, HBT	2.09 rad/sec
Specific Gravity	1.15
Shelf Life	
@ 0°F/-18°C	1 year
@ 77°F/25°C	7 days

Handling

Mixing - This product is one-component and requires no mixing.

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 - Hysol EA 9346.5 may be cured for 1 hour @ 250°F/121°C or 1 hour @ 350°F/177°C.

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 D 1002.

Adherends are 2024-T3 clad aluminum treated with phosphoric acid anodize per BAC 5555.

Typical Results
Cure 1 hour @ 250°F/121°C

<u>Test Temperature, °F/°C</u>	<u>psi</u>	<u>MPa</u>
-67/-55	4500	31.0
77/25	5500	37.9
180/82	4500	31.0
250/121	2500	17.2

T-Peel Strength

T-Peel strength tested per ASTM D1876.

Adherends are 2024-T3 clad aluminum treated with phosphoric acid anodize per BAC 5555.

<u>Test Temperature, °F/°C</u>	<u>Typical Results</u>	
	<u>pli</u>	<u>klm</u> kilograms per linear meter
-67/-55	10	178.6
77/25	35	625.0
180/82	35	625.0

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 275°F/135°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.

WARNING! The uncured adhesive causes eye irritation and may cause skin irritation such as allergic dermatitis. Contains epoxy resins.

DANGER! Causes severe skin and eye burns. Do not get in eyes, on skin or on clothing. Vapors may be irritating to the respiratory tract.

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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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