

LOCTITE

Loctite Aerospace

Hysol® EA 9306NA

Epoxy Paste Adhesive



Authorized Distributor

1-800-375-0605

www.rudolphbros.com

Description

Hysol EA 9306NA is a gray thixotropic, one component, heat curable epoxy adhesive possessing excellent adhesion @ -67°F to 250°F (-55°C to 121°C). It is ideally suited for bonding applications where low sag and low exotherm are critical such as in core fill or potting applications. Hysol EA 9306NA contains no asbestos.

Features

One Component
Sag Resistant
Low Exotherm

Uncured Adhesive Properties

Color	Gray
Viscosity @ 77°F	5,000 - 13,000 Poise
Brookfield, HBT	Spdl 7 @ 20 rpm
Viscosity @ 25°C	500 - 1,300 Pa·S
Brookfield, HBT	Spdl 7 @ 2.1 rad/s
Density (g/ml)	1.35
Shelf life @ <40°F/4°C	1 year
@ <77°F/25°C	1 month

Handling

This product is ready to use as received, after warming to room temperature

Application

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 may be cured for 1 hour @ >270°F/132°C to achieve normal performance. Otherwise, Hysol EA 9306NA should be cured by starting in an ambient oven (100°F/38°C), heat to 250°F/121°C and hold for 3 hours, then raise temperature to 270°F/132°C for 1 hour.

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 @ 270°F/132°C. Adherends are 2024-T3 clad aluminum treated with phosphoric acid anodizing per ASTM D3933.

<u>Test Temperature, °F/°C</u>	<u>Typical Results</u>	
	<u>psi</u>	<u>MPa</u>
-67/-55	4,000	27.6
77/25	5,000	34.5
180/82	4,000	27.6

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 250°F/121°C.

Bulk Resin Properties

Compressive Properties - tested using 0.5 inch/12.7 mm castings per ASTM D695.

Compressive Strength @ 77°F/25°C 11,000 psi 75.8 MPa

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.

ONE PART

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

Hysol® is a registered trademark of Loctite Corporation

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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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