



Hysol® EA 9361

Epoxy Paste Adhesive

Henkel Corporation
Aerospace Group
2850 Willow Pass Road
P.O. Box 312
Bay Point, CA 94565 USA
925.458.8000
Fax: 925.458.8030
www.aerospace.henkel.com

Description

Hysol EA 9361 is a high elongation two-component paste adhesive that cures at room temperature. Hysol EA 9361 has a good combination of high shear, peel strength, and flexibility. This product is suitable for general purpose bonding as well as applications that require high elongation, such as sealing and cryogenic applications.

Features

High Elongation
Bonds Many Substrates
Long Pot Life
Excellent Low Temperature Properties

Uncured Adhesive Properties

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	White	Black	Gray
Viscosity @ 77°F	1,300 Poise	700 Poise	1,000 Poise
Brookfield, HBT	Spdl 5 @ 20 rpm	Spdl 5 @ 20 rpm	Spdl 5 @ 20 rpm
Viscosity @ 25°C	130 Pa·S	70 Pa·S	100 Pa·S
Brookfield, HBT	Spdl 5 @ 2.1 rad/s	Spdl 5 @ 2.1 rad/s	Spdl 5 @ 2.1 rad/s
Density (g/ml)	1.33	1.26	1.28
Shelf life			
@ <77°F/25°C	1 year	1 year	
@ <90°F/32°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	140

Pot Life (450 g mass) 120 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. Handling strength for this adhesive will occur in 24 hours @ 77°F/25°C, after which the support tooling or pressure used during cure may be removed. Since full bond strength has not yet been attained, load application should be small at this time.

Curing - This adhesive may be cured for 5 to 7 days @ 77°F/25°C to achieve normal performance. Accelerated cures up to 200°F/93°C (for small masses only) may be used as an alternative. For example, 1 hour @ 180°F/82°C will give complete cure.

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 5 days @ 77°F/25°C. Adherends are 2024-T3 bare phosphoric acid anodized per ASTM D3933.

<u>Test Temperature, °F/°C</u>	Typical Results	
	<u>psi</u>	<u>MPa</u>
-320/-196	4,000	27.6
-67/-55	4,000	27.6
77/25	3,500	24.1
160/71	850	5.9

Peel Strength

T-Peel strength tested per ASTM D1876 after curing for 5 days @ 77°F/25°C. Adherends are 2024-T3 bare phosphoric acid anodized per ASTM D3933.

<u>Test Temperature, °F/°C</u>	Typical Results	
	<u>Lb/in</u>	<u>N/25 mm</u>
-67/-55	10.0	44
77/25	25.0	111

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 140°F/60°C.

Bulk Resin Properties

Tensile Properties - tested using 0.125 inch/3.18 mm castings per ASTM D638.

Elongation at Break, @ -67°F/-55°C	>7%
Elongation at Break, @ 77°F/25°C	40%
Shore D Hardness @ 77°F/25°C	70
Tensile Modulus @ 77°F/25°C	105 ksi/723 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.

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.

