



Hysol® EA 9339

Epoxy Paste Adhesive

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Description

Hysol EA 9339 is a two-component paste adhesive, which features a long pot life and excellent peel strength. Because of its room temperature cure and easy mixing, it is a good general purpose adhesive.

Features

Two Components
High Peel Strength
Room Temperature Cure
Long Pot Life

Uncured Adhesive Properties

	<u>Part A</u>	<u>Part B</u>
Color	Beige	Blue
Viscosity @ 77°F	2,500 - 5,500 Poise	100 - 400 Poise
Brookfield, HBT	Spdl 7 @ 20 rpm	Spdl 4 @ 20 rpm
Viscosity @ 25°C	250 - 559 Pa·S	10 - 40 Pa·S
Brookfield, HBT	Spdl 7 @ 2.1 rad/s	Spdl 4 @ 2.1 rad/s
Shelf life @ <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 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	44.5

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

Pot Life (450 g mass) 2 hours
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 days @ 77°F/25°C to achieve normal performance. Accelerated cures up to 180°F/82°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 Alclad aluminum treated with phosphoric acid anodized per ASTM D3933.

<u>Test Temperature, °F/°C</u>	Typical Results	
	<u>psi</u>	<u>MPa</u>
77/25	4,500	31.0

Peel Strength

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

<u>Test Temperature, °F/°C</u>	Typical Results	
	<u>lbs/in</u>	<u>N./25mm</u>
77/25	20	89

Bell Peel strength tested per ASTM D3167 after curing for 5 days @ 77°F/25°C. Adherends are 2024-T3 Alclad aluminum treated with chromic acid etch per ASTM D2651-90.

<u>Test Temperature, °F/°C</u>	Typical Results	
	<u>lbs/in</u>	<u>N./25mm</u>
77/25	22	98

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 150°F/66°C.

Bulk Resin Properties

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

Tensile Strength @ 77°F/25°C	5,000 psi	34.5 MPa
Tensile Modulus @ 77°F/25°C	330 ksi	2274 GPa
Elongation at Break, @ 77°F/25°C	2.6%	
Shore D Hardness @ 77°F/25°C	75	
Tg, tan delta by DMTA	133°F	56°C
Shear Modulus @ 77°F/25°C	150 ksi	1.03 GPa
Poisson's Ratio	0.37	

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

Compressive Modulus @ 77°F/25°C	180 ksi	1.24
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Electrical Properties - tested per ASTM D149, D150.

Dielectric Constant, 1 KHz, 77°F/25°C	3.55
Dissipation Factor, 1 KHz, 77°F/25°C	0.055

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.



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