



# Hysol® EA 9396.6MD

## 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 9396.6MD is an easy mixing, two-part syntactic epoxy adhesive with good compressive strength at higher temperatures. Hysol EA 9396.6MD can be cured at room temperature (77°F/25°C).

### Features

Good High Temperature Properties  
Easy to Mix  
Low Density  
Good for Potting, Edge Filling

### Uncured Adhesive Properties

	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color	Light Blue	White	Light Blue
Density (g/ml)	0.60-0.65	0.48-0.53	0.55
Shelf life			
@ <0°F/-18°C	1 year	1 year	
@ <40°F/4°C	1 year	6 months	

Note: 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.

### 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	31

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

**Pot Life** (450 gm mass) 120 minutes  
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 at 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 at 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 at 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.

### **Bulk Resin Properties**

#### ***Tensile Lap Shear Strength***

Tensile lap shear strength tested per ASTM D1002 after curing for 5 days at 77°F/25°C. Adherends are 2024-T3 bare aluminum treated with phosphoric acid anodized per ASTM D3933.

<u>Test Temperature °F/°C</u>	<u>Typical Results</u>	
	<u>psi</u>	<u>MPa</u>
77/25	2,600	17.9

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

	<u>psi</u>	<u>MPa</u>
Compressive Strength @ 77°F/25°C	3,800	26.2
Compressive Strength @ 250°F/121°C	2,000	13.8
Compressive Strength @ 300°F/149°C	1,500	10.3

### **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.

Hysol® is a registered trademark of Henkel Corporation.

Rev. 1/01

---

**DISCLAIMER:** The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed, including without limitation any warranty of merchantability and fitness for use. All users of the materials are responsible for assuring that it is suitable for their needs, environmental and use. All data is subject to change as Henkel deems appropriate.

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.

---

