



Hysol®

FINALLY

A PASTE ADHESIVE

DESIGNED WITH THE

STRENGTH OF A FILM ADHESIVE

Hysol® EA 9380™ Assembly Paste Adhesive

Reduce costs of composite assembly with automated dispensing and Hysol® EA 9380™ assembly paste.

Hysol® EA 9380™ assembly paste is a low temperature curing two-part adhesive that can be applied to large parts for structural bonding using a controlled meter mix operation or a dual cartridge static mixer kit.

FEATURES

- High structural strength in a paste
- Lower cure temperatures under 200°F / 93°C
- Automated dispensing equipment
- Out of autoclave processing

BENEFITS

- Allows manufacture of parts at lower cure temperatures and oven processing
- Lower energy needed for cure, less cure stresses on final part. Better strength translation to the final part
- Higher shop floor productivity
- Improves shop floor flexibility, reduces energy and saves fabrication time

For more information, visit www.hysolea9380.com

Please visit us on the web to learn more about:
Henkel Aerospace Products: www.henkelna.com/aerospace
Henkel Composite Assembly: www.henkelcompositeassembly.com



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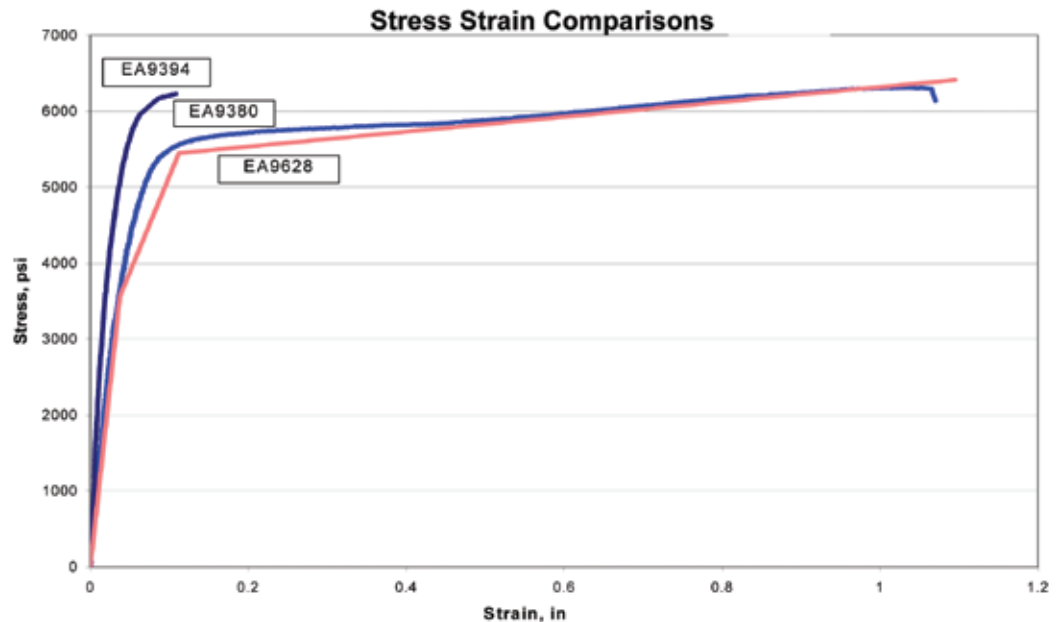
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COMPARISONS OF HYSOL® EA 9380™ WITH TYPICAL STRUCTURAL FILM ADHESIVES

		Hysol® EA 9380™	Hysol® EA 9628™	Hysol® EA 9696™
Form		Paste	Supported Film	Supported Film
Film Weight, psf		---	0.06	0.06
Support Fabric		None	Non-woven	Non-woven
Cure, hrs		4 @ 160°F / 70°C	1.5 @ 235°F / 113°C	1 @ 250°F / 120°C
Adherends		2024 T3 Clad, Phosphoric Acid Anodize, BR-127 Primed	2024 T3 Bare, Phosphoric Acid Anodize, BR-127 Primed	2024 T3 Bare, Phosphoric Acid Anodize, BR-127 Primed
Tensile Shear, psi/MPa, as cured	-67°F / -55°C	4,350 / 30.3	5,500 / 37.9	6,700 / 46.2
	75°F / 25°C	4,750 / 33.1	5,800 / 40.0	6,300 / 43.5
	180°F / 82°C	3,050 / 21.8	5,100 / 35.2	4,550 / 31.8
	250°F / 120°C	2,200 / 15.2	2,100 / 14.5	2,200 / 15.2
Environmentals, Shear @ 180°F / 82°C, psi/MPa*		3,900 / 26.9	2,650 / 18.3	2,750 / 19.0
Bell Peel, (lb/in) / N/25mm	@ 75°F / 25°C	55 / 240	55 / 240	80 / 350
	Post-cured 1 hr @ 210°F / 100°C	35 / 150	N/A	N/A
Tg, °F / °C	As Cured	210 / 99	230 / 110	225 / 107
	Water Saturated*	220 / 104	180 / 82	200 / 93

SHEAR STRESS DIAGRAM

The graph illustrates the room temperature capacity of Hysol® EA 9380™ to perform like a toughened 120°C cure film adhesive.



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