Technical Process Bulletin

LOCTITE EA 9345 AERO
Epoxy Paste Adhesive
(KNOWN AS Hysol EA 9345)

INTRODUCTION
LOCTITE EA 9345 AERO is a two-part toughened epoxy paste adhesive with long pot life. LOCTITE EA 9345 AERO is based upon the formulation of LOCTITE EA 9309NA AERO.

FEATURES
- Long Pot Life
- Non-Asbestos
- Toughened

Uncured Properties

	Part A	Part B	Mixed
Color	Gray	Blue	Violet
Viscosity @ 77°F/25°C	3600 Poise/360 Pa•S	0.5 Poise/0.05 Pa•S	
Brookfield Viscometer	HBT, Spdl 7 @ 20 rpm/2.1 rad/s	LVF, Spdl 1 @ 60/6.3 rad/s	
Density, g/ml	1.15	1.00	
Shelf Life			
@ <40°F/4°C	1 year	1 year	
@ <77°F/25°C	1 year	1 year	

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).

Mix Ratio	Part A	Part B
By Weight	100	35

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

Pot Life (400 gram mass) 90 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 LOCTITE 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 at >77°F/25°C or 1 hour at 150°F/66°C to achieve normal performance. Accelerated cures up to 200°F/93°C (for small masses only) may be used as an alternative.

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 with 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 foe 5 days at 77°F/25°C. Adherends are 2024-T3 AlClad FPL etched per ASTM D2651-90.

	Typical Results	
Test Temperature, °F/°C	psi	MPa
77/25	4800	33.1

Handling Precautions
Do not handle or use until the Material Safety Data Sheet has been read and understood.
For industrial use only.

DISPOSAL INFORMATION
Dispose of spent remover and paint residue per local, state and regional regulations. Refer to HENKEL TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional disposal information.

PRECAUTIONARY INFORMATION
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.

Before using this product refer to container label and HENKEL TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional precautionary, handling and first aid information.

Note

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