

**LOCTITE®**

**Structural Adhesives**

# Aerospace Product Selector Guide



**Henkel**

# Structural Adhesives

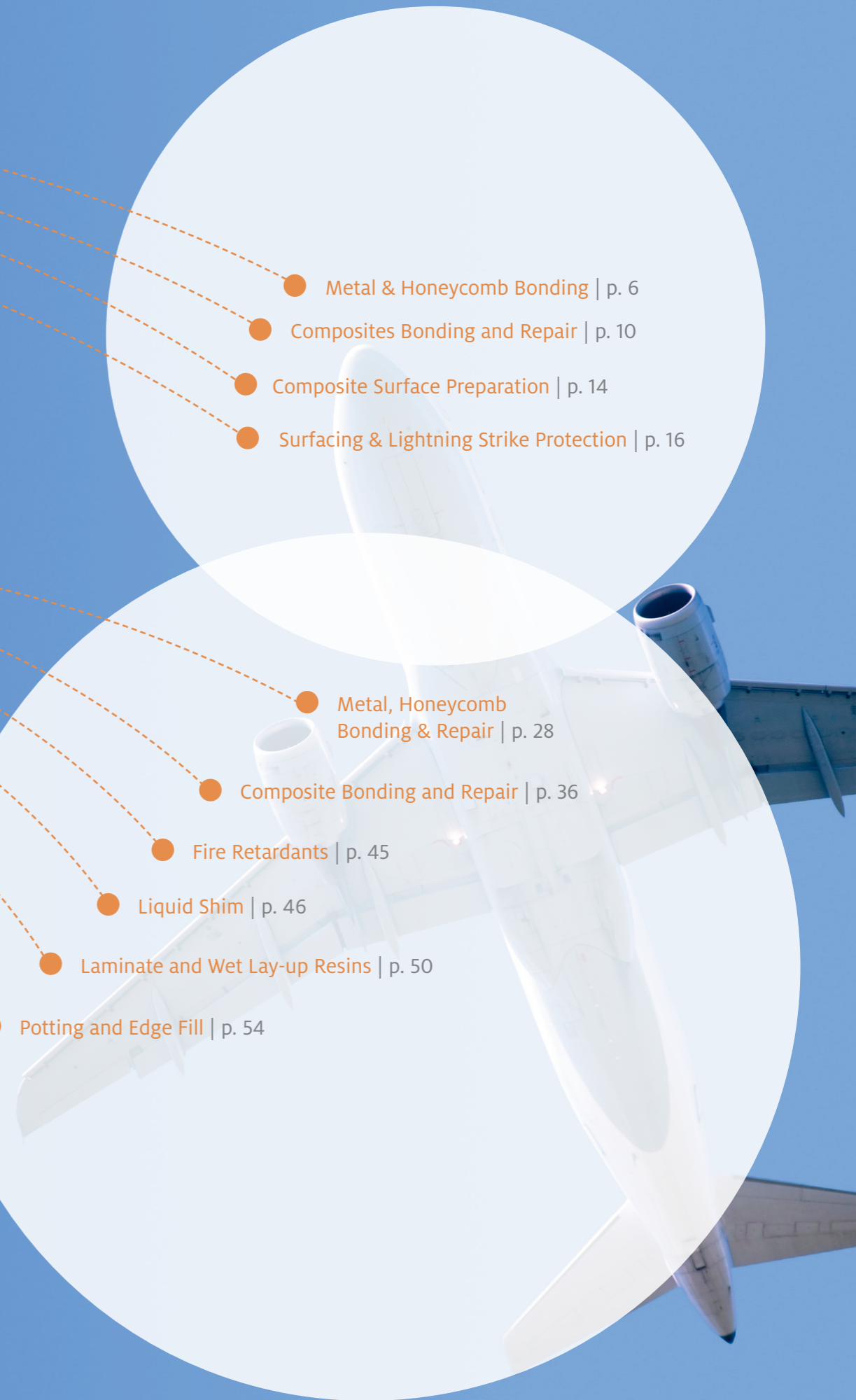
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## With over four decades of experience: **LOCTITE film adhesives**

### Film adhesives: the basics

Film adhesives are pre-catalyzed adhesives offered in sheet form for metal, composite bonding, and honeycomb applications. Film adhesives are offered in defined areal weights in roll or sheet form.

### Advanced level: LOCTITE film adhesives

Our broad portfolio of film adhesives includes advanced technologies to address today and tomorrow's most demanding applications. Being a long-term partner for aircraft manufacturers globally, Henkel provides sustainable film adhesive solutions that enhance performance and safety of aircraft as well as the manufacturer's production efficiency.

### Why choose LOCTITE film adhesives?

- › Enables large part manufacture
- › Better toughness
- › Durable bonding
- › Bond line thickness control
- › Handling and reliability
- › Long shop life

## LOCTITE film adhesives: Facts at a glance

### LOCTITE film adhesives key features

- › Pre-catalyzed, no mixing or measuring needed
- › Mix of epoxy resin and curing agent cast into a film.
- › Typical thickness ranges from 5 mils to 15 mils (0.1 – 0.4 mm)
- › Enables up to 15 days to assemble aircraft parts
- › Controlled flow, ability to reticulate
- › Usually supplied with a scrim for bond line control, toughness and handling
- › Allows precise placement of adhesive on part
- › Allows precise amount of adhesive to be placed on part
- › Bonds various substrates

### Key factors to consider when choosing the right LOCTITE film adhesive:

- › Environmental and temperature resistance
- › Cure time and temperature
- › Fracture toughness
- › Lightning strike protection

## Qualified to major aerospace specifications: **LOCTITE metal & honeycomb bonding products**

### Fully developed metal & honeycomb solutions

How to identify a technically advanced metal & honeycomb bonding solution? Just ask if it offers very low weight, high fatigue resistance, maximum durability and significant production costs savings. If it does, this is a LOCTITE solution.

In the honeycomb and metal assembly segment, Henkel offers metal bonding films for original construction and repair qualified to all major aerospace specifications. LOCTITE films are one component, heat curing thin film adhesives. Materials are specifically designed for maximum durability, high strength and toughness with temperature resistance designed for their operating environment

The LOCTITE portfolio of metal bonding films is broad and addresses many needs of customer applications. LOCTITE has products covering service temperatures from 250 °F / 121 °C to 550 °F / 288 °C and will bond to chemically treated metallic substrates.

### Why choose LOCTITE metal & honeycomb solutions?

- › Improved toughness
- › Excellent resistance to high temperatures
- › Good tack and drape
- › Good reticulation
- › Excellent adhesion to aluminum and composite substrates

## LOCTITE metal & honeycomb bonding: Facts at a glance

### LOCTITE metal and honeycomb film key features

- › Pre-catalyzed, no mixing or measuring
- › Typical thicknesses range from 5 mils to 15 mils (0.1 – 0.4 mm)
- › More durable bonds
- › Controlled flow
- › Ability to reticulate
- › Long out time

### Key factors to consider when choosing the right LOCTITE product for metal & honeycomb bonding

- › Substrate preparation
- › Operating temperature requirements
- › Operating environment
- › Part size and shape
- › Bond joint design
- › Strength requirements (peel or shear)

## Metal & Honeycomb Bonding

Application	Metal & Honeycomb Bonding				
Characteristics	250 °F / 121 °C Service				
	300 °F / 149 °C Service				
	350 °F / 177 °C Service				
	550 °F / 288 °C Service				
	Cure Temperature (°F / °C)	250 °F / 121 °C	250 °F / 121 °C	350 °F / 177 °C	
	Cure Time	90 Minutes	90 Minutes	60 Minutes	
	Storage Temperature (°F / °C)	0 °F / -18 °C	0 °F / -18 °C	0 °F / -18 °C	
	Out-time (Days @ 77 °F / 25 °C) – FILM	20 Days	20 Days	15 Days	
	Out-time (Days @ 90 °F / 32 °C) – FILM	10 Days	10 Days	10 Days	
Mechanical Properties	Bell Peel 77 °F (lb / in) / 25 °C (N / 25 mm)	54 lbs / in / 240 N / 25 mm	–	13 lb / in / 58 N / 25 mm	
	T Peel 77 °F (lb / in) / 25 °C (N / 25 mm)	37 lbs / in / 165 N / 25 mm	35 lbs / in / 156 N / 25 mm	–	
	TENSILE LAP SHEAR	-67 °F (psi) / -55 °C (MPa)	5,500 psi / 37.9 MPa	5,500 psi / 38.0 MPa	3,900 psi / 27.0 MPa
		77 °F (psi) / 25 °C (MPa)	6,000 psi / 41.3 MPa	5,850 psi / 40.3 MPa	4,800 psi / 33.1 MPa
		180 °F (psi) / 82 °C (MPa)	4,000 psi / 27.6 MPa	3,700 psi / 25.5 MPa	–
		Elevated Temperature (psi / MPa)	250 °F / 121 °C: 2,000 psi / 13.8 MPa	250 °F / 121 °C: 1,300 psi / 9.0 MPa	350 °F / 177 °C: 2,800 psi / 19 MPa
	Honeycomb Climbing Drum Peel @ 77 °F (in-lb/in) / 25° (m-N/m)	60 in.lb / 3 in / 80 m.N / m	60 in.lb / 3 in / 89 m.N / m	12 in.lb / 3 in / 50 m.N / m	
	Flatwise Tension @ 77 °F / 25 °C (psi / MPa)	1,400 psi / 9.6 MPa	1,100 psi / 7.6 MPa	1,000 psi / 6.9 MPa	
	Bulk Properties	Tg Dry (°F / °C)	248 °F / 120 °C	240 °F / 116 °C	392 °F / 200 °C
Tg Wet (°F / °C)		210 °F / 99 °C	200 °F / 93 °C	300 °F / 150 °C	
Tensile Strength (dogbone) @ 77 °F (psi) / 25 °C (MPa)		7,500 psi / 51.7 MPa	7,500 psi / 51.7 MPa	–	
Tensile Modulus @ 77 °F (ksi) / 25 °C (MPa)		345 ksi / 2,377 MPa	346 ksi / 2,377 MPa	–	
Elongation @ 77 °F / 25 °C (% at break)		7.5 %	7.5 %	–	
Compressive Strength @ 77 °F (psi) / 25 °C (MPa)		11,500 psi / 79.3 MPa	11,500 psi / 79.3 MPa	–	
Compressive Modulus @ 77 °F (ksi) / 25 °C (MPa)		310 ksi / 2,136 MPa	310 ksi / 2,136 MPa	–	
Product		New Product Name	<b>LOCTITE EA 9628 AERO</b>	<b>LOCTITE EA 9628H AERO</b>	<b>LOCTITE EA 9658 AERO</b>
	Known As	Hysol® EA 9628™	Hysol® EA 9628H™	Hysol® EA 9658™	
Availability	Packaging	Roll	Roll	Roll	
Description	<b>LOCTITE EA 9628 AERO</b>	<b>LOCTITE EA 9628H AERO</b>	<b>LOCTITE EA 9658 AERO</b>		
	<ul style="list-style-type: none"> <li>• Good Toughness</li> <li>• 250 °F/ 121 °C Cure</li> <li>• Bonds Many Materials</li> <li>• Excellent Durability</li> </ul>	<ul style="list-style-type: none"> <li>• Excellent Durability</li> <li>• 250 °F/ 121 °C Cure</li> <li>• Applications Include Helicopter Blade Bonding</li> <li>• Good Toughness</li> <li>• Product is preferred for helicopter blade construction because of the product flow characteristics and its ability to be cured in an out of autoclave process</li> </ul>	<ul style="list-style-type: none"> <li>• Increased toughness with high temperature performance</li> <li>• Designed for composite, metal or honeycomb</li> <li>• State of the art flow control to minimize hole blockage and excess flash/flow</li> <li>• Thermally stable</li> <li>• Offered with a companion low VOC water based corrosion inhibiting primer, LOCTITE EA 9258.1 AERO</li> </ul>		

## Metal & Honeycomb Bonding

Notes

Application	Metal & Honeycomb Bonding							
Characteristics	250 °F / 121 °C Service		•			•		
	300 °F / 149 °C Service				•	•		
	350 °F / 177 °C Service							
	550 °F / 288 °C Service		•					
	Cure Temperature (°F / °C)	350 °F / 177 °C + 475 °F / 121 °C	250 °F / 121 °C	250 °F / 121 °C or 350 °F / 177 °C		225 – 275 °F / 107 – 129 °C	250 °F / 121 °C or 350 °F / 177 °C	
	Cure Time	60 Minutes / 120 Minutes	60 Minutes	60 – 120 Minutes		60 – 90 Minutes	60 – 120 Minutes	
	Storage Temperature (°F / °C)	0 °F / -18 °C	0 °F / -18 °C	0 °F / -18 °C		0 °F / -18 °C	0 °F / -18 °C	
	Out-time (Days @ 77 °F / 25 °C) – FILM	30 Days	14 Days	90 Days		60 Days	30 Days	
	Out-time (Days @ 90 °F / 32 °C) – FILM	15 Days	10 Days	45 Days		30 Days	30 Days	
Mechanical Properties	Bell Peel 77 °F (lb / in) 25 °C (N / 25 mm)	–	87 lbs / in 387 N / 25 mm	20 lbs / in 89.6 N / 25 mm		75 lbs / in 334 N / 25 mm	20 lbs / in 89 N / 25 mm	
	T Peel 77 °F (lb / in) 25 °C (N / 25 mm)	–	–	–		–	–	
	TENSILE LAP SHEAR	-67 °F (psi) / -55 °C (MPa)	2,000 psi / 13.8 MPa	6,350 psi / 43.8 MPa	4,400 psi / 30.3 MPa		7,000 psi / 48.3 MPa	3,600 psi / 26.2 MPa
		77 °F (psi) / 25 °C (MPa)	2,000 psi / 13.8 MPa	6,100 psi / 42.0 MPa	5,000 psi / 34.5 MPa		6,000 psi / 41.3 MPa	4,500 psi / 31.0 MPa
		180 °F (psi) / 82 °C (MPa)	–	3,900 psi / 26.9 MPa	4,500 psi / 31.0 MPa		4,507 psi / 31.1 MPa	–
	Elevated Temperature (psi / MPa)	350 °F / 177 °C: 2,400 psi / 16.5 MPa	250 °F / 121 °C: 2,100 psi / 14.5 MPa	300 °F / 149 °C: 3,400 psi / 23.4 MPa		250 °F / 121 °C: 2,000 psi / 12.8 MPa	270 °F / 132 °C: 1,300 psi / 9.0 MPa	
	Honeycomb Climbing Drum Peel @ 77 °F (in-lb/in) / 25° (m-N/m)	–	18 in.lb / in 80 N.m / m	18 in.lb / 3 in 82 m.N / m		78 lbs / in 116 m.N / m	27 in.lb / 3in 40 m.N / m	
	Flatwise Tension @ 77 °F / 25 °C (psi / MPa)	–	925 psi / 6.4 MPa	1,200 psi / 8.3 MPa		1,298 psi / 9.0 MPa	1,070 psi / 7.4 MPa	
Bulk Properties	Tg Dry (°F / °C)	568 °F / 298 °C	240 °F / 115 °C	302 °F / 150 °C		253 °F / 123 °C	293 °F / 145 °C	
	Tg Wet (°F / °C)	410 °F / 210 °C	200 °F / 95 °C	203 °F / 95 °C		200 °F / 93 °C	190 °F / 88 °C	
	Tensile Strength (dogbone) @ 77 °F (psi) / 25 °C (MPa)	–	–	11,000 psi / 76 MPa		6,839 psi / 47.3 MPa	–	
	Tensile Modulus @ 77 °F (ksi) / 25 °C (MPa)	–	–	450 ksi / 3,100 MPa		277.3 ksi / 1,912 MPa	–	
	Elongation @ 77 °F / 25 °C (% at break)	–	–	3.00 – 4.00 %		16.00 %	–	
	Compressive Strength @ 77 °F (psi) / 25 °C (MPa)	–	–	–		–	–	
	Compressive Modulus @ 77 °F (ksi) / 25 °C (MPa)	–	–	–		–	–	
	Product	New Product Name	<b>LOCTITE EA 9673 AERO</b>	<b>LOCTITE EA 9690 AERO</b>	<b>LOCTITE EA 9695 AERO</b>		<b>LOCTITE EA 9696 AERO</b>	<b>LOCTITE EA 7000 AERO</b>
Known As		Hysol® EA 9673™ (BMI)	Hysol® EA 9690™	Hysol® EA 9695™		Hysol® EA 9696™	Hysol® PL 7000™ NEW!	
Availability	Packaging	Roll	Roll	Roll		Roll	Roll	
Description	<b>LOCTITE EA 9673 AERO</b>	<b>LOCTITE EA 9690 AERO</b>	<b>LOCTITE EA 9695 AERO</b>		<b>LOCTITE EA 9696 AERO</b>	<b>LOCTITE EA 7000 AERO</b>		
	<ul style="list-style-type: none"> <li>• Service to 550 °F / 288 °C</li> <li>• No Volatiles During Cure</li> <li>• Bismalimide based chemistry</li> </ul>	<ul style="list-style-type: none"> <li>• Low Flow</li> <li>• Exceptional Peel Strength</li> <li>• Available with Knit or Non-Woven Mat</li> <li>• Excellent Performance with Low Pressure Cures</li> </ul>	<ul style="list-style-type: none"> <li>• X-ray Opaque</li> <li>• Excellent Environmental Resistance</li> <li>• Reticulatable</li> <li>• Good Pre and Post Bond Moisture Resistance</li> <li>• Low Flow</li> <li>• Allows 250 °F / 121 °C or 350 °F / 177 °C Cure</li> <li>• Co-Cure with Composites</li> <li>• Long Out time Facilitates Shop Floor Usage and Repair Applications</li> </ul>		<ul style="list-style-type: none"> <li>• Excellent Environmental Resistance</li> <li>• High Toughness Maintaining Service Temperature</li> <li>• Balanced Flow</li> <li>• Allows from 225 °F to 265 °F / 107 °C to 129 °C Cure</li> <li>• Long Out-time Facilitates Shop Floor Usage and Repair Applications</li> <li>• Reticulatable</li> </ul>	<ul style="list-style-type: none"> <li>• Dual temperature cure capabilities</li> <li>• Epoxy film adhesive for composite bonding applications</li> <li>• Excellent performance properties in composite bonding</li> <li>• Excellent results on composite surfaces</li> <li>• Excellent fracture toughness (G1c)</li> </ul>		

When structural integrity matters:

## LOCTITE composite bonding and repair film adhesives

### Concerning critical aircraft components, some questions might come up

In order to preserve the structural integrity of critical aircraft components, manufacturers need the right adhesives to bond composite sub-components with excellent chemical resistance and extraordinary mechanical performance.

### Henkel gives a strong answer: LOCTITE composite bonding adhesives

LOCTITE products for composite bonding fulfill all these requirements and allow engineers to create efficient structures. No fasteners are needed. They offer lower adherent thickness, let you take advantage of stiffness properties of composites and provide a separation of dissimilar materials.

#### Why choose LOCTITE composite bonding adhesives?

- › Good environmental resistance
- › Improved toughness
- › Bond line thickness control
- › Good tack and drape
- › Excellent adhesion to composite substrates

## LOCTITE composite bonding adhesives: Facts at a glance

#### LOCTITE composite bonding adhesives key features:

- › High temperature service
- › Compatibility with aerospace prepreg systems
- › Good wetting of composite surfaces
- › High mechanical performance
- › Toughness tailorable to requirements
- › Variations in form: thickness or weight
- › Excellent chemical resistance

#### Key factors to consider when choosing the right LOCTITE composite bonding adhesive

- › Service temperature
- › Shelf life / out-time
- › Cure temperature
- › Glass transition temperature (Tg)
- › Toughness

## Composite Bonding

Application	Composite				
Characteristics	250 °F / 121 °C Service				
	300 °F / 149 °C Service				
	350 °F / 177 °C Service				
	550 °F / 288 °C Service				
	Cure Temperature (°F / °C)	250 °F / 121 °C	250 °F / 121 °C	350 °F / 177 °C	
	Cure Time	90 Minutes	90 Minutes	60 Minutes	
	Storage Temperature (°F / °C)	0 °F / -18 °C	0 °F / -18 °C	0 °F / -18 °C	
	Out-time (Days @ 77 °F / 25 °C) – FILM	20 Days	20 Days	15 Days	
	Out-time (Days @ 90 °F / 32 °C) – FILM	10 Days	10 Days	10 Days	
Mechanical Properties	Bell Peel 77 °F (lb / in) / 25 °C (N / 25 mm)	54 lbs / in / 240 N / 25 mm	–	13 lb / in / 58 N / 25 mm	
	T Peel 77 °F (lb / in) / 25 °C (N / 25 mm)	37 lbs / in / 165 N / 25 mm	35 lbs / in / 156 N / 25 mm	–	
	TENSILE LAP SHEAR	-67 °F (psi) / -55 °C (MPa)	5,500 psi / 37.9 MPa	5,500 psi / 38.0 MPa	3,900 psi / 27.0 MPa
		77 °F (psi) / 25 °C (MPa)	6,000 psi / 41.3 MPa	5,850 psi / 40.3 MPa	4,800 psi / 33.1 MPa
		180 °F (psi) / 82 °C (MPa)	4,000 psi / 27.6 MPa	3,700 psi / 25.5 MPa	–
		Elevated Temperature (psi / MPa)	250 °F / 121 °C: 2,000 psi / 13.8 MPa	250 °F / 121 °C: 1,300 psi / 9.0 MPa	350 °F / 177 °C: 2,800 psi / 19 MPa
	Honeycomb Climbing Drum Peel @ 77 °F (in-lb/in) / 25° (m-N/m)	60 in.lb / 3 in / 80 m.N / m	60 in.lb / 3 in / 89 m.N / m	12 in.lb / 3 in / 50 m.N / m	
	Flatwise Tension @ 77 °F / 25 °C (psi / MPa)	1,400 psi / 9.6 MPa	1,100 psi / 7.6 MPa	1,000 psi / 6.9 MPa	
Bulk Properties	Tg Dry (°F / °C)	248 °F / 120 °C	240 °F / 116 °C	392 °F / 200 °C	
	Tg Wet (°F / °C)	210 °F / 99 °C	200 °F / 93 °C	300 °F / 150 °C	
	Tensile Strength (dogbone) @ 77 °F (psi) / 25 °C (MPa)	7,500 psi / 51.7 MPa	7,500 psi / 51.7 MPa	–	
	Tensile Modulus @ 77 °F (ksi) / 25 °C (MPa)	345 ksi / 2,377 MPa	346 ksi / 2,377 MPa	–	
	Elongation @ 77 °F / 25 °C (% at break)	7.5 %	7.5 %	–	
	Compressive Strength @ 77 °F (psi) / 25 °C (MPa)	11,500 psi / 79.3 MPa	11,500 psi / 79.3 MPa	–	
	Compressive Modulus @ 77 °F (ksi) / 25 °C (MPa)	310 ksi / 2,136 MPa	310 ksi / 2,136 MPa	–	
	Product	New Product Name	LOCTITE EA 9628 AERO	LOCTITE EA 9628H AERO	LOCTITE EA 9658 AERO
Known As		Hysol® EA 9628™	Hysol® EA 9628H™	Hysol® EA 9658™	
Availability	Packaging	Roll	Roll	Roll	
Description	LOCTITE EA 9628 AERO	LOCTITE EA 9628H AERO	LOCTITE EA 9658 AERO		
	<ul style="list-style-type: none"> <li>• Good Toughness</li> <li>• 250 °F/ 121 °C Cure</li> <li>• Bonds Many Materials</li> <li>• Excellent Durability</li> </ul>	<ul style="list-style-type: none"> <li>• Excellent Durability</li> <li>• 250 °F/ 121 °C Cure</li> <li>• Applications Include Helicopter Blade Bonding</li> <li>• Good Toughness</li> <li>• Product is preferred for helicopter blade construction because of the product flow characteristics and its ability to be cured in an out of autoclave process</li> </ul>	<ul style="list-style-type: none"> <li>• Increased toughness with high temperature performance</li> <li>• Designed for composite, metal or honeycomb</li> <li>• State of the art flow control to minimize hole blockage and excess flash/flow</li> <li>• Thermally stable</li> <li>• Offered with a companion low VOC water based corrosion inhibiting primer, LOCTITE EA 9258.1 AERO</li> </ul>		

## Composite Bonding

Notes

Application	Composite							
<b>Characteristics</b>	250 °F / 121 °C Service		•			•		
	300 °F / 149 °C Service				•		•	
	350 °F / 177 °C Service							
	550 °F / 288 °C Service		•					
	Cure Temperature (°F / °C)	350 °F / 177 °C + 475 °F / 121 °C	250 °F / 121 °C	250 °F / 121 °C or 350 °F / 177 °C		225 – 275 °F / 107 – 129 °C	250 °F / 121 °C or 350 °F / 177 °C	
	Cure Time	60 Minutes / 120 Minutes	60 Minutes	60 – 120 Minutes		60 – 90 Minutes	60 – 120 Minutes	
	Storage Temperature (°F / °C)	0 °F / -18 °C	0 °F / -18 °C	0 °F / -18 °C		0 °F / -18 °C	0 °F / -18 °C	
	Out-time (Days @ 77 °F / 25 °C) – FILM	30 Days	14 Days	90 Days		60 Days	30 Days	
	Out-time (Days @ 90 °F / 32 °C) – FILM	15 Days	10 Days	45 Days		30 Days	30 Days	
<b>Mechanical Properties</b>	Bell Peel 77 °F (lb / in) 25 °C (N / 25 mm)	–	87 lbs / in 387 N / 25 mm	20 lbs / in 89.6 N / 25 mm		75 lbs / in 334 N / 25 mm	20 lbs / in 89 N / 25 mm	
	T Peel 77 °F (lb / in) 25 °C (N / 25 mm)	–	–	–		–	–	
	<b>TENSILE LAP SHEAR</b>	-67 °F (psi) / -55 °C (MPa)	2,000 psi / 13.8 MPa	6,350 psi / 43.8 MPa	4,400 psi / 30.3 MPa		7,000 psi / 48.3 MPa	3,600 psi / 26.2 MPa
		77 °F (psi) / 25 °C (MPa)	2,000 psi / 13.8 MPa	6,100 psi / 42.0 MPa	5,000 psi / 34.5 MPa		6,000 psi / 41.3 MPa	4,500 psi / 31.0 MPa
	180 °F (psi) / 82 °C (MPa)	–	3,900 psi / 26.9 MPa	4,500 psi / 31.0 MPa		4,507 psi / 31.1 MPa	–	
	Elevated Temperature (psi / MPa)	350 °F / 177 °C: 2,400 psi / 16.5 MPa	250 °F / 121 °C: 2,100 psi / 14.5 MPa	300 °F / 149 °C: 3,400 psi / 23.4 MPa		250 °F / 121 °C: 2,000 psi / 12.8 MPa	270 °F / 132 °C: 1,300 psi / 9.0 MPa	
	Honeycomb Climbing Drum Peel @ 77 °F (in-lb/in) / 25° (m-N/m)	–	18 in.lb / in 80 N.m / m	18 in.lb / 3 in 82 m.N / m		78 lbs / in 116 m.N / m	27 in.lb / 3in 40 m.N / m	
	Flatwise Tension @ 77 °F / 25 °C (psi / MPa)	–	925 psi / 6.4 MPa	1,200 psi / 8.3 MPa		1298 psi / 9.0 MPa	1,070 psi / 7.4 MPa	
<b>Bulk Properties</b>	Tg Dry (°F / °C)	568 °F / 298 °C	240 °F / 115 °C	302 °F / 150 °C		253 °F / 123 °C	293 °F / 145 °C	
	Tg Wet (°F / °C)	410 °F / 210 °C	200 °F / 95 °C	203 °F / 95 °C		200 °F / 93 °C	190 °F / 88 °C	
	Tensile Strength (dogbone) @ 77 °F (psi) / 25 °C (MPa)	–	–	11,000 psi / 76 MPa		6,839 psi / 47.3 MPa	–	
	Tensile Modulus @ 77 °F (ksi) / 25 °C (MPa)	–	–	450 ksi / 3,100 MPa		277.3 ksi / 1,912 MPa	–	
	Elongation @ 77 °F / 25 °C (% at break)	–	–	3.00 – 4.00 %		16.00 %	–	
	Compressive Strength @ 77 °F (psi) / 25 °C (MPa)	–	–	–		–	–	
	Compressive Modulus @ 77 °F (ksi) / 25 °C (MPa)	–	–	–		–	–	
	<b>Product</b>	New Product Name	<b>LOCTITE EA 9673 AERO</b>	<b>LOCTITE EA 9690 AERO</b>	<b>LOCTITE EA 9695 AERO</b>		<b>LOCTITE EA 9696 AERO</b>	<b>LOCTITE EA 7000 AERO</b>
Known As		Hysol® EA 9673™ (BMI)	Hysol® EA 9690™	Hysol® EA 9695™		Hysol® EA 9696™	Hysol® PL 7000™ NEW!	
<b>Availability</b>	Packaging	Roll	Roll	Roll		Roll	Roll	
<b>Description</b>	<b>LOCTITE EA 9673 AERO</b>	<b>LOCTITE EA 9690 AERO</b>	<b>LOCTITE EA 9695 AERO</b>		<b>LOCTITE EA 9696 AERO</b>	<b>LOCTITE EA 7000 AERO</b>		
	<ul style="list-style-type: none"> <li>Service to 550 °F / 288 °C</li> <li>No Volatiles During Cure</li> <li>Bismalimide based chemistry</li> </ul>	<ul style="list-style-type: none"> <li>Low Flow</li> <li>Exceptional Peel Strength</li> <li>Available with Knit or Non-Woven Mat</li> <li>Excellent Performance with Low Pressure Cures</li> </ul>	<ul style="list-style-type: none"> <li>X-ray Opaque</li> <li>Excellent Environmental Resistance</li> <li>Reticulatable</li> <li>Good Pre and Post Bond Moisture Resistance</li> <li>Low Flow</li> <li>Allows 250 °F / 121 °C or 350 °F / 177 °C Cure</li> <li>Co-Cure with Composites</li> <li>Long Out time Facilitates Shop Floor Usage and Repair Applications</li> </ul>		<ul style="list-style-type: none"> <li>Excellent Environmental Resistance</li> <li>High Toughness Maintaining Service Temperature</li> <li>Balanced Flow</li> <li>Allows from 225 °F to 265 °F / 107 °C to 129 °C Cure</li> <li>Long Out-time Facilitates Shop Floor Usage and Repair Applications</li> <li>Reticulatable</li> </ul>	<ul style="list-style-type: none"> <li>Dual temperature cure capabilities</li> <li>Epoxy film adhesive for composite bonding applications</li> <li>Excellent performance properties in composite bonding</li> <li>Excellent results on composite surfaces</li> <li>Excellent fracture toughness (G1c)</li> </ul>		

## Clean and cost efficient surface preparation: With **LOCTITE peel plies**

### Peel ply: The ideal preparation method for treating surfaces evenly

There are two primary methods for adhesive bond preparation of the surface of a pre-cured carbon fiber composite: Surface abrasion, and the use of release ply fabric, i.e. peel ply. Of the two, peel ply is the most commonly recommended process because it creates a more uniform surface preparation than hand or machine abrasion.

### LOCTITE peel plies: The ideal method to save time and costs

Henkel's peel ply enables process efficiency by minimizing surface preparation. LOCTITE peel ply provides part longevity and reduces maintenance costs. It ensures a consistent bonding surface, with a high quality bond with tough state-of-the-art composites.

#### Why choose LOCTITE peel plies?

- › Ease of removal
- › Minimal residual polyester fibers on substrate after removal
- › Thin residual resin layer
- › Controlled failure / release path
- › Optimized interfacial strength
- › Promotes cohesive failure modes within the bondline
- › Generate more durable bonding surface than dry fabric

## LOCTITE peel plies: Facts at a glance

#### LOCTITE peel plies key features

- › Compatible with third generation composites
- › No sanding or solvent wiping required of bonding surface
- › Minimal force required to remove peel ply layer
- › Protective layer
- › Good shop life

#### Key factors to consider when choosing the right LOCTITE peel ply

- › Polyester vs. nylon peel ply
- › Cure temperature
- › Compatibility with composite prepreg resin
- › Dry or wet peel ply

## Composite Surface Preparation

<b>Application</b>	Peel Ply		
<b>Characteristics</b>	250 °F / 121 °C Service		
	300 °F / 149 °C Service		
	Cure Temperature (°F / °C)	250 °F / 121 °C	350 °F / 177 °C
	Cure Time	90 – 120 Minutes	90 – 120 Minutes
	Storage Temperature (°F / °C)	0 °F / -18 °C	0 °F / -18 °C
	Out-time (Days @ 77 °F / 25 °C) – FILM	14 Days	14 Days
Out-time (Days @ 90 °F / 32 °C) – FILM	10 Days	10 Days	
<b>Bulk Properties</b>	Tg Dry (°F / °C)	270 °F / 132 °C	228 °F / 109 °C
	Tg Wet (°F / °C)	217 °F / 103 °C	–
<b>Product</b>	New Product Name	<b>LOCTITE EA 9896 WPP AERO</b>	<b>LOCTITE EA 9895 WPP AERO</b>
	Known As	Hysol® EA 9896 WPP™ NEW!	Hysol® EA 9895 WPP™
<b>Availability</b>	Packaging	Roll	Roll
<b>Description</b>	<b>LOCTITE EA 9896 WPP AERO</b> <ul style="list-style-type: none"> <li>• Durable bond</li> <li>• Minimal residual nylon fibers left on substrate after removal</li> <li>• Minimal risk of interfacial failure in bonded structures</li> <li>• No sanding or solvent wiping required for bonding</li> <li>• Minimal force required to remove peel ply layer</li> </ul>	<b>LOCTITE EA 9895 WPP AERO</b> <ul style="list-style-type: none"> <li>• Provides: More durable bond than dry peel ply fabrics</li> <li>• Minimal residual polyester fibers left on substrate after removal</li> <li>• Promotes cohesive failure mode</li> <li>• Compatible with third generation composites</li> <li>• No sanding or solvent wiping required for bonding</li> <li>• Minimal force required to remove peel ply layer</li> </ul>	

Notes



Boosting surface quality:

# LOCTITE surfacing films for lightning strike protection

## How to benefit from the right surfacing film solution

Surfacing films are designed to improve the surface quality of honeycomb stiffened composite parts. They also provide a barrier for dissimilar materials, decrease surface preparation time and provide protection of structural fibers. But this is not all: laminated films composed of a surfacing film and a conductive metal foil protect the composite structure from damage caused by lightning strikes.

## Protect your aircraft from lightning strike damage

What are the requirements for optimum lightning strike protection of aircraft composite parts? A maximum electrical conductivity is essential. A lightweight solution is important too. And process efficiency should be maximized – including easy repair after lightning strike.

## How to gain even more benefits: LOCTITE surfacing films & lightning strike protection

With our LOCTITE portfolio, you can be sure to get the technically most advanced solution. Economically, they offer up to 30 % weight savings compared to existing surfacing films – and they lower the composite part finishing costs. Technically, they provide durable, high quality paintable surfaces and a maximum of product & shop flexibility.

### Why choose LOCTITE surfacing films & lightning strike protection?

- › Minimize core crush
- › Maximum protection against lightning strikes
- › Reduce core mark-through
- › Protect the composites
- › Excellent retention of hardness after fluid soak
- › Increased UV and paint stripper resistance
- › Out-of-autoclave capable
- › No microcracking
- › High quality paintable surfaces
- › Resistance to high thermal fatigue situations

## LOCTITE surfacing films & lightning strike protections: Facts at a glance

### LOCTITE surfacing films key features:

- › High surface quality: Low flow
- › Good paint adhesion without sanding
- › Available in lightning strike configurations
- › Reduce surface imperfections
- › Minimize pre-paint preparation

### LOCTITE lightning strike protection key features:

- › Easier handling than stand-alone expanded foil during lay-up, sand and fill operations
- › Inventory reduction from two raw materials to one
- › Process labor reduction
- › Easy repair after lightning strike

## Surfacing Film & Lightning Strike

<b>Characteristics</b>	350 °F / 177 °C Service	•	•	•	•	•	•
	Cure Temperature (°F / °C)	250 °F / 121 °C or 350 °F / 177 °C	251 °F / 121 °C or 350 °F / 177 °C	252 °F / 121 °C or 350 °F / 177 °C	252 °F / 121 °C or 350 °F / 177 °C	250 °F / 121 °C or 350 °F / 177 °C	251 °F / 121 °C or 350 °F / 177 °C
	Cure Time	60 Minutes	60 Minutes	60 Minutes	60 – 120 Minutes	60 – 120 Minutes	60 – 120 Minutes
	Storage Temperature (°F / °C)	0 °F -18 °C	0 °F -18 °C	0 °F -18 °C	0 °F -18 °C	0 °F -18 °C	0 °F -18 °C
	Out-time (Days @ 77 °F / 25 °C) – FILM	90 Days	90 Days	90 Days	45 Days	45 Days	45 Days
	Out-time (Days @ 90 °F / 32 °C) – FILM	21 Days	21 Days	21 Days	10 Days	10 Days	10 Days
<b>Mechanical Properties</b>	TENSILE LAP-SHEAR	-67 °F (psi) / -55 °C (MPa)	–	–	–	–	–
		77 °F (psi) / 25 °C (MPa)	2,990 psi 20.6 MPa	2,990 psi 20.6 MPa	–	–	–
		180 °F (psi) / 82 °C (MPa)	–	–	–	–	–
		Elevated Temperature (psi / MPa)	–	–	–	–	–
<b>Bulk Properties</b>	Tg Dry (°F / °C)	273 °F 134 °C	274 °F 134 °C	275 °F 134 °C	254 °F 122 °C	252 °F 122 °C	253 °F 122 °C
	Tg Wet (°F / °C)	228 °F 109 °C	229 °F 109 °C	230 °F 109 °C	223 °F 105 °C	221 °F 105 °C	222 °F 105 °C
<b>Product</b>	New Product Name	LOCTITE EA 9837.1 AERO	LOCTITE EA 9837.1 BLK AERO	LOCTITE EA 9837.1 LS AERO	LOCTITE EA 9845 AERO	LOCTITE EA 9845 LC AERO	LOCTITE EA 9845 LA AERO
	Known As	SynSkin® HC 9837.1™	SynSkin® HC 9837.1™ BLK	SynSkin® HC 9837.1™ LSC	Hysol® EA 9845 SF™	Hysol® EA 9845 LSC™	Hysol® EA 9845 LSA™
<b>Availability</b>	Packaging	Roll	Roll, Sheet	Roll, Sheet	Roll	–	–
<b>Description</b>	<b>LOCTITE EA 9837.1 AERO</b>	LOCTITE EA 9837.1 BLK AERO	LOCTITE EA 9837.1 LS AERO	LOCTITE EA 9845 AERO	LOCTITE EA 9845 LC AERO	LOCTITE EA 9845 LA AERO	
	is an epoxy based film with good tack properties, comparable with lightning strike foils, minimizes core crush and porosity. It offers high quality paintable surface. Available in One-Side-Tacky (OST) Configuration.	is an epoxy based film with good tack properties, compatible with lightening strike foils, minimizes core crush and porosity. It offers high quality paintable surface. Available in One-Side-Tacky (OST) Configuration.	is an epoxy based composite film containing copper screen designed to lightening strike protection.	is an epoxy-based composite surfacing film designed to improve the surface quality of honeycomb stiffened composite parts. The product is manufactured with a non-woven fabric for support.	is an epoxy-based composite surfacing film containing copper screen designed to lightning strike protection.	is an epoxy-based composite surfacing film containing aluminum screen designed to lightning strike protection.	

Notes

Light weight, high stiffness and optimum load transfer:

## LOCTITE syntactic materials for structural sandwich panel, core filling, splicing and abrasion resistance

### Want to have optimum stiffness, load transfer and easier formability?

With LOCTITE structural syntactic materials, Henkel provides the right choice for structural and low density sandwich panels. Applications include low density panel stiffening, minimum gauge stiffened panels, and sandwich panel edge build-up. They offer maximum structural performance, high impact resistance, high panel strength – and, of course, an optimum stiffness to weight. The products are non-expanding films supplied in a range of thicknesses.

### LOCTITE core splice and expanding materials meet your needs

Our high performance core splices are used to obtain a uniform load transfer from one section of core to another before being bonded on the assembly line. They enable filling the gap up to the skin surface. This process also serves as a method of preventing moisture ingress in honeycomb-stiffened parts through the core splice joint.

As foaming films, LOCTITE materials expand during heat cure up to 2 – 3 times their original size. They offer excellent slump resistance and exothermic properties, being ideal for thick splices, deep core filling or co-cure conditions – and are easier to insert into core gaps, improving productivity.

### Materials for improved abrasion resistance

Henkel's abradable materials ensure that today's aircraft engines can operate at maximum efficiency. They provide a rub strip for jet engine compressor blades combining high erosion resistance with low abrasion at low density. Materials are available for OEM installation and for repair and maintenance to ensure the fleet is always operational.

### Why choose LOCTITE syntactics, core fill and abradable materials?

- › Improved mechanical strength, toughness and energy absorption
- › Uniform expansion
- › Enable load transfer
- › Enable thick and complex sandwich structures
- › No mark-off due to bonding or honeycomb
- › Attach and bond to core walls
- › Sag resistant
- › Qualified by major OEMs
- › Panel thickness can be contoured, local build-ups can be included
- › Abrasion & erosion resistance
- › Expanding, low density
- › User-friendly processing

## LOCTITE Syntactic, Core Fill and Abradable: Facts at a glance

### Syntactic Materials: Key factors to consider when choosing the right LOCTITE structural syntactic materials

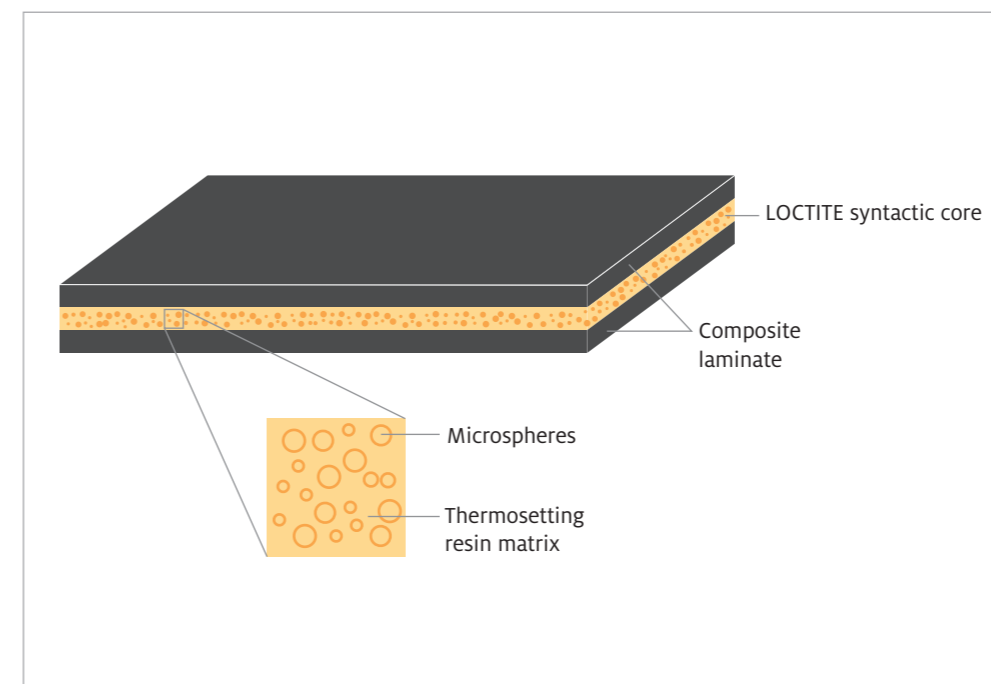
- › Service temperature
- › Compression strength
- › Application
- › Process temperature
- › Core thickness required
- › Expanding or non-expanding

### Expanding materials: Key factors to consider when choosing the right LOCTITE core fill and core splice materials

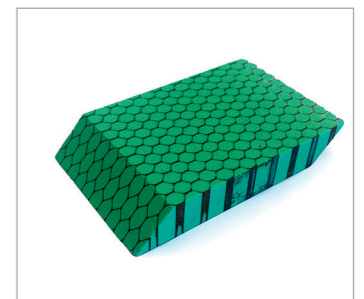
- › Cure Temperature
- › Cure Time
- › Service Temperature
- › Density
- › Mechanical properties
- › Process conditions

### Abradable materials: Key facts to consider when choosing the right LOCTITE abradable materials

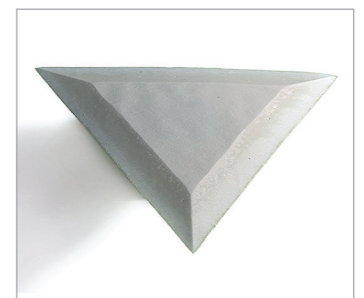
- › Abrasion resistance required
- › Service temperature
- › Toughness
- › Density
- › Process conditions
- › Repair



LOCTITE syntactic core sandwich construction



LOCTITE expanding syntactic film



LOCTITE syntactic core machined shape

## Structural Syntactic Materials: Non Expanding

<b>Application</b>	Syntactic Film Non-Expanding	•	•	•
	Syntactic Film Expanding			
	180 °F / 82 °C Service			
	250 °F / 121 °C Service	•		
	300 °F / 149 °C Service		•	•
	300 °F / 149 °C Service – High Strength			•
<b>Product Characteristics</b>	Continuous Service Temperature (°F / °C)	Maximum 250 °F / 121 °C	Maximum 350 °F / 177 °C	Maximum 350 °F / 177 °C
	Block Compressive (dry) @ 73 °F (psi) / 23 °C (MPa)	9,000 psi / 62 MPa	8,800 psi / 61 MPa	21,800 psi / 150 MPa
	Tensile Strength @ 73 °F (psi) / 23 °C (MPa)	4,700 psi / 32 MPa	4,800 psi / 33 MPa	5,000 psi / 34.5 MPa
	Tensile Modulus @ 73 °F (psi) / 23 °C (MPa)	380 ksi / 2,606 MPa	400 ksi / 2,758 MPa	580 ksi / 4,000 MPa
<b>Process &amp; Handling</b>	Cure Temperature (°F / °C)	250 °F / 121 °C	350 °F / 177 °C	350 °F / 177 °C
	Cure Time	60 Minutes	60 Minutes	120 Minutes
	Storage Temperature (°F / °C)	0 °F / -18 °C	0 °F / -18 °C	0 °F / -18 °C
	Storage Time	> 12 Months	> 12 Months	> 12 Months
	Out-time (Days @ 77 °F / 25 °C) – FILM	15 Days	15 Days	15 Days
	Out-time (Days @ 90 °F / 32 °C) – FILM	10 Days	10 Days	10 Days
<b>Bulk Properties</b>	Tensile Strength (dogbone) @ 77 °F (psi) / 25 °C (MPa)	4,700 psi / 32 MPa	4,800 psi / 33 MPa	5,000 psi / 34.5 MPa
	Tensile Modulus @ 77 °F (ksi) / 25 °C (MPa)	380 ksi / 2,606 MPa	400 ksi / 2,758 MPa	580 ksi / 4,000 MPa
	Block Compressive (dry) @ 77 °F (psi) / 25 °C (MPa)	9,000 psi / 62 MPa	8,800 psi / 61 MPa	21,800 psi / 150 MPa
<b>Products</b>	New Product Name	<b>LOCTITE HC 9823.1 AERO</b>	<b>LOCTITE HC 9872.1 AERO</b>	<b>LOCTITE HC 9875 AERO</b>
	Known As	SynCore® 9823.1™	SynCore® 9872.1™	SynCore® 9875™
<b>Availability</b>	Packaging	Roll, Sheet	Roll, Sheet	Roll
<b>Description</b>	<b>LOCTITE HC 9823.1 AERO</b>	<b>LOCTITE HC 9872.1 AERO</b>	<b>LOCTITE HC 9875 AERO</b>	
	is a structural syntactic film. Excellent moisture resistance. Lightweight syntactic core material. Modified epoxy. Co-curable with 250 °F / 121 °C prepegs.	is a structural syntactic film. Excellent moisture resistance. Lightweight syntactic core material. Modified epoxy. Co-curable with 350 °F / 177 °C prepegs.	is a structural syntactic film. High crush strength. Lightweight syntactic core material. Designed to withstand high compressive loading. Co-curable with 350 °F / 177 °C prepegs.	

## Core Fill & Abradable

<b>Application</b>	Abradable Seal			•	
	Core Splice / Filler	•	•		•
<b>Characteristics</b>	250 °F / 121 °C Service	•	•	•	
	300 °F / 149 °C Service				•
	350 °F / 177 °C Service				
	550 °F / 288 °C Service				
	Cure Temperature (°F / °C)	250 – 350 °F / 121 – 177 °C	250 – 350 °F / 121 – 177 °C	250 °F / 121 °C	250 – 350 °F / 121 – 177 °C
	Cure Time	60 Minutes	60 Minutes	120 Minutes	60 Minutes
	Storage Temperature (°F / °C)	0 °F / -18 °C	0 °F / -18 °C	0 °F / -18 °C	0 °F / -18 °C
	Out-time (Days @ 77 °F / 25 °C) – FILM	15 Days	15 Days	15 Days	10 Days
Out-time (Days @ 90 °F / 32 °C) – FILM	10 Days	10 Days	10 Days	5 Days	
<b>Mechanical Properties</b>	Tube Shears @ 77 °F (psi) / 25 °C (MPa)	–	1,300 psi / 9.0 MPa	–	940 psi / 6.5 MPa
	Tube Shears @ 250 °F (psi) / 121 °C (MPa)	–	–	–	1,063 psi / 7.3 Mpa
<b>Bulk Properties</b>	Tg Dry (°F / °C)	383 °F / 195 °C	380 °F / 193 °C	–	–
	Tensile Strength (dogbone) @ 77 °F (psi) / 25 °C (MPa)	–	–	1,100 psi / 7.6 MPa	–
	Tensile Modulus @ 77 °F (ksi) / 25 °C (MPa)	–	–	62ksi / 430 MPa	–
	Compressive Strength @ 77 °F (psi) / 25 °C (MPa)	1,500 psi / 10.3 MPa	5,425 psi / 37.4 MPa	1,440 psi / 10.0 MPa	–
	Compressive Modulus @ 77 °F (ksi) / 25 °C (MPa)	86 ksi / 585 MPa	198.2 ksi / 1,366 MPa	85 ksi / 585 MPa	–
	Flexural Strength @ 77 °F (psi) / 25 °C (MPa)	–	–	1,600 psi / 11.0 MPa	–
	Block Compressive (dry) @ 77 °F (psi) / 25 °C (MPa)	500 @ 12 pcf density 3.45 @ 0.19 g / cc	19 pcf: 1,000 psi / 6.9 MPa 26 pcf: 2,500 psi / 17.2 MPa 35 pcf: 6,500 psi / 44.8 Mpa	–	–
<b>Product</b>	New Product Name	<b>LOCTITE EF 9899 AERO</b>	<b>LOCTITE EF 9899CF AERO</b>	<b>LOCTITE EF 9890 AERO</b>	<b>LOCTITE EF 557 AERO</b>
	Known As	SynSpand® 9899™	SynSpand® 9899CF™**	SynSpand® EA 9890™ Abradable Seal	Hysol® MA 557™
<b>Availability</b>	Packaging	Roll, Sheet	Roll, Sheet	Roll	Roll, Sheet
<b>Description</b>	<b>LOCTITE EF 9899 AERO</b>	<b>LOCTITE EF 9899CF AERO</b>	<b>LOCTITE EF 9890 AERO</b>	<b>LOCTITE EF 557 AERO</b>	
	is a 250 °F / 121 °C or 350 °F / 177 °C curing expanding syntactic film. It expands using a unique closed cell process, providing for a completely homogenous cell structure. Its applications include honeycomb core stabilization, edge close out, RTM core, and many others.	is a medium density low exotherm expanding syntactic film suitable for core filling applications. Its typical cured density range is 18 – 35 pcf (0.29 – 0.56 g/cc). The low exotherm chemistry makes this product ideal for deep core fill. High compressive strength provides the potential for some structural applications.	is an expanding modified epoxy film that cures at 250 °F / 121 °C. Commonly used for abradable seals, which require high abrasion and corrosion resistance. Additional features include areal weight and width.	is a modified epoxy foaming adhesive that may be cured at 250 °F / 121 °C or 350 °F / 177 °C. It is designed to seal, splice, or reinforce honeycomb materials.	



High-end protection for sensitive surfaces:

## LOCTITE primers

### Once a surface has been etched, it needs protection

One of the main reasons for priming is to prevent corrosion of the part. The etched metal surface is “active” and ready to be bonded. The oxide layer from the cleaning and etching process is sensitive to decay. Priming protects and preserves the oxide, and allows you to store metal for later use.

### LOCTITE primers care and protect perfectly

Created for a broad application range, LOCTITE primers are designed to promote adhesion, provide corrosion protection and improve bond joint long term durability. And of course, they are available in ozone-safe (non-CFC), solvent-based and solvent-free formulations.

#### Why choose LOCTITE primers?

- › Enhance adhesion
- › Excellent resistance to chemicals
- › Eliminate cobwebbing
- › Corrosion protection

## LOCTITE primers: Facts at a glance

#### LOCTITE primers key features

- › Spray or brush applications
- › Improves production rates
- › Excellent storage and out time stability
- › Primer reactivation not required for second-stage bonding

#### Key factors to consider when choosing the right LOCTITE primer

- › Temperature resistance
- › Adhesion to different substrates
- › Chemical resistance
- › Product safety of reactive hotmelts

## Primers

Application	Corrosion Protection / Enhanced Bondability	Enhanced Bondability	Enhanced Bondability	Enhanced Bondability / Corrosion Protection	
Characteristics	180 °F / 82 °C Service	•			
	350 °F / 177 °C Service		•	•	
	Form	1 Part	1 Part	1 Part	
Mechanical Properties	Bell Peel 77 °F (lb / in) / 25 °C (N / 25 mm)	-	-	0.12 mils: 13 lb / in / 58 N / 25 mm 0.24 mils: 15 lb / in / 65 N / 25 mm 0.39 mils: 14 lb / in / 62 N / 25 mm	
	TENSILE LAP SHEAR	-67 °F (psi) / -55 °C (MPa)	-	3,165 psi / 22 MPa	3,900 psi / 27 MPa
		77 °F (psi) / 25 °C (MPa)	1,000 psi / 6.9 MPa	4,200 psi / 29 MPa	4,800 psi / 33 MPa
		Elevated Temperature (psi / MPa)	-	1500psi / 10 MPa @ 250 °F / 121°C	2,800 psi / 19 MPa @ 380 °F / 177 °C
	Honeycomb Climbing Drum Peel @ 77 °F (in-lb / in) / 25 °C (m-N / m)	-	80 in-lb / in / 17.6 m-N / m	12 in-lb / in / 50 m-N / m	
	Flatwise Tension @ 77 °F / 25 °C (psi / MPa)	-	-	1000 psi / 7 MPa	
PRIMER COVERAGE	Square Foot / Gal @ 0.3 mil dry film thickness / Square Meter / Liter @ 8µm dry film thickness	1,600 SF / Gal / Mil / 39 m <sup>2</sup> / liter / 0.0254 mm	600 SF / Gal / Mil / 14.7 m <sup>2</sup> / liter / 0.0254 mm	1,200 SF / Gal / Mil / 29.3 m <sup>2</sup> / liter / 0.0254 mm	
	Handling	Cure Temperature (°F / °C)	77 °F / 23 °C	315 °F / 157 °C	350 °F / 177 °C
	Cure Time	-	90 Minutes	45 – 60 Minutes	
	Storage Temperature (°F / °C)	77 °F / 25 °C	40 °F / 5 °C	40 °F / 5 °C	
	Out-time (Days @ 77 °F / 25 °C) – FILM	365 Days	90 Days	30 Days	
	Out-time (Days @ 90 °F / 32 °C) – FILM	366 Days	30 Days	20 Days	
Product	New Product Name	LOCTITE EA 9203 AERO	LOCTITE EA 2000 AERO	LOCTITE EA 9258.1 AERO	
	Known As	Hysol® EA 9203™	Hysol® AL 2000™	Hysol® EA 9258.1	
Availability	Packaging	Gallon	Gallon	Gallon	
Description	LOCTITE EA 9203 AERO is an adhesive bonding primer which enhances adhesion on poorly prepared surfaces. Since it is a non-curing primer, it requires only a room temperature drying to be ready for bonding. It is especially well-suited for use with room temperature curing paste adhesives.	LOCTITE EA 2000 AERO is a heat curing nitrile / phenolic water based primer. When cured, it furnishes excellent resistance to chemicals and water.	LOCTITE EA 9258.1 AERO is a water-borne chromated adhesive bonding primer for 350 °F / 177 °C service. It is designed to offer at least twice the improvement in peel strength toughness over current 350 °F / 177 °C service film adhesives. It is applied with current aerospace primer spray equipment, and provides low VOCs of 142 g/liter. It may be cured 45 – 60 minutes 350 °F / 177 °C for optimum performance. The data contained herein were obtained with the companion film adhesive LOCTITE EA 9658 0.10 NWG AERO and LOCTITE EA 9658 AERO 0.060 unsupported.		



## Superior bonding performance: **LOCTITE** paste adhesives

### Paste adhesives: Keeping it all together

Paste adhesives are structural adhesives used to bond aluminum, stainless steel, titanium and composites either in rib-stiffened designs or in honeycomb designs.

### Outperforming portfolio: LOCTITE paste adhesives

As a leader in toughened paste and film adhesives, Henkel's aerospace group offers a complete line of pre-measured packages for paste adhesives ranging from a pudding cup to a two-part cartridge kit with static mixers.

In other words, Henkel provides exactly the paste adhesive solutions you need: one- and two-part epoxy paste adhesive systems for potting, bonding, fairing and repair.

### Why choose for LOCTITE paste adhesives?

- › Improve microcrack resistance
- › Reduce costs
- › Bond numerous substrates
- › Reduce weight in structural assemblies
- › Excellent thin substrates bonding
- › Provide design flexibility

## LOCTITE paste adhesives: Facts at a glance

### LOCTITE paste adhesives key features:

- › Allow use of two different materials
- › Distribute stresses in joints
- › Flexible to cure temperature
- › Absorb vibration
- › Oil and fuel resistant
- › Co-bond and co-cure

### Key factors to consider when choosing the right LOCTITE paste adhesive

- › Size and shape of part to be bonded
- › Production rates and quantities
- › Process related requirements

## If you need a metal bond or repair solution with paste adhesives **LOCTITE is for you**

### Metal and Honeycomb bonding and repair solutions require maximum flexibility

When it comes to bonding or repair of metal parts and structures of an aircraft, you will surely be looking for a solution that has high strength, chemical resistance and resists creep under sustained loads. In addition, you need a two component system with a room temperature cure. Too many requirements? Not for us.

### We combine it with efficiency: LOCTITE metal bond and repair

Henkel offers a high-performance structural adhesive portfolio in ready-to-use packaging configurations for aerospace OEM and MRO customers. LOCTITE products allow you to bond or make repairs to metallic substrates on the production line while improving your employees' productivity and safety. The down time is minimized, waste and stress on components are reduced. Finally, the efficiency is more than convincing thanks to a less time consuming, less expensive and faster through-put.

#### Why choose LOCTITE structural metal bond paste?

- › Qualified by major OEM's
- › Easy to apply
- › Ready-to-use packaging solutions
- › Superior mechanical strength
- › Create durable repairs
- › Excellent resistance to aggressive chemicals to increase part life
- › One or two component systems
- › Room temperature and elevated cure temperatures options

## LOCTITE metal bond and repair paste adhesives: Facts at a glance

#### LOCTITE structural metal bond paste solutions key features

- › Industry standard for metal bond applications
- › Out-of-Autoclave solutions
- › Easy application
- › Chemical resistance

#### Key factors to consider when choosing the right LOCTITE structural repair product

- › Metal bond or composite to repair
- › Service temperature
- › Consistency and viscosity
- › High compression loads resistance
- › High temperature resistance
- › Flexibility or toughness

## Metal, Honeycomb Bonding & Repair

<b>Characteristics</b>	180°F / 82°C Service	•	•	•	
	300°F / 149°C Service				
	350°F / 177°C Service				
	450°F / 232°C Service				
	Improved Hot / Wet Properties				
	Toughened	•	•	•	
	Consistency	Moderate Viscosity	Thixotropic	Low Viscosity	
	Form	2 Part	2 Part	2 Part	
Peel Strength	High	Low	Low		
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	35 lbs / in / 150 N / 25 mm	35 lbs / in / 150 N / 25 mm	6 lbs / in / 25 N / 25 mm	
	TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	4,900 psi / 33.8 MPa	3,000 psi / 20.7 MPa	3,000 psi / 20.7 MPa
		77°F (psi) / 25°C (Mpa)	5,000 psi / 34.5 MPa	4,000 psi / 27.6 MPa	4,000 psi / 27.6 MPa
		180°F (psi) / 82°C (Mpa)	2,300 psi / 15.9 MPa	2,900 psi / 20.0 MPa	1,200 psi / 8.3 MPa
		Elevated Temperature (psi / MPa)	-	500 psi / 3.4 MPa	600 psi / 4.1 MPa
<b>Bulk Properties</b>	Tg Dry (°F / °C)	180 °F / 82 °C	230 °F / 110 °C	207 °F / 97 °C	
	Tg Wet (°F / °C)	-	190 °F / 88 °C	157 °F / 69 °C	
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	5,000 psi / 34.5 MPa	7,100 psi / 49.0 MPa	3,500 psi / 24.1 MPa	
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	330 ksi / 2,274 MPa	42 ksi / 2.90 GPa	375 ksi / 2.58 Gpa	
	Elongation @ 77°F / 25°C (% at break)	9,00 %	6,00 %	9,00 %	
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	8,000 psi / 55.1 MPa	9,280 psi / 64.00 MPa	8,800 psi / 60.6 MPa	
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	265 ksi / 1,826 MPa	284 ksi / 1,960 MPa	375 ksi / 2.58 GPa	
	<b>Handling</b>	Mix Ratio Weight (Part A / Part B)	100 : 19	100 : 50	100 : 45
Cure Temperature (°F / °C)		> 77 – 200°F / > 25 – 93 °C	77 – 200 °F / 25 – 93 °C	> 77 – 200 °F / > 25 – 93 °C	
Cure Time		5 – 7 Days / 1 Hour	5 – 7 Days / 1 Hour	5 – 7 Days / 1 Hour	
Storage Temperature (°F / °C)		77 °F / 25 °C	40 °F / 4 °C	40 °F / 4 °C	
Pot Life (minutes / lb) / (minutes / kg)		25 Minutes / 200 Gram Mass	40 Minutes / 450 Gram Mass	30 Minutes / 450 Gram Mass	
<b>Product</b>	New Product Name	<b>LOCTITE EA 9320NA AERO</b>	<b>LOCTITE EA 9321 AERO</b>	<b>LOCTITE EA 9323 AERO</b>	
	Known As	Hysol® EA 9320NA™	Hysol® EA 9321™	Hysol® EA 9323™	
<b>Availability</b>	Packaging	Quart Kit, Gallon Kit, Injection Kit	Clip Pack, Dual Cartridge, Quart Kit	Barrier Kit, Quart Kit	
<b>Description</b>	<b>LOCTITE EA 9320NA AERO</b> is a two-component paste adhesive with good peel strength as well as elevated temperature resistance.	<b>LOCTITE EA 9321 AERO</b> is a two-component thixotropic paste adhesive, which exhibits toughness and retains strength at elevated temperatures. This product cures at room temperature and yields durable bonds over a wide temperature range.	<b>LOCTITE EA 9323 AERO</b> is a two-component paste adhesive, which is low in viscosity, possesses some toughness and maintains high temperature strength. Its room temperature cure capability makes it ideal for repair of metal and composite structure, including laminating and injection. It has no metallic fillers.		

## Metal, Honeycomb Bonding & Repair

<b>Characteristics</b>	180°F / 82°C Service	•	•	•	•	•	•	•	
	300°F / 149°C Service								
	350°F / 177°C Service								
	450°F / 232°C Service								
	Improved Hot / Wet Properties			•	•	•	•	•	
	Toughened	•	•	•	•	•	•	•	
	Consistency	Moderate Viscosity	Thixotropic	Thixotropic	Thixotropic	Thixotropic	Thixotropic	Moderate Viscosity	
	Form	2 Part	2 Part	2 Part	2 Part	2 Part	2 Part	2 Part	
	Peel Strength	High	High	High	High	High	High	High	
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	92 lbs / in / 409 N / 25 mm	93 lbs / in / 414 N / 25 mm	75 lbs / in / 335 N / 25 mm	60 lbs / in / 265 N / 25 mm	50 lbs / in / 178 N / 25 mm	40 lbs / in / 220 N / 25 mm	44 lbs / in / 196 N / 25 mm	
	TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	5,000 psi / 34.5 MPa	5,700 psi / 39.3 MPa	4,000 psi / 27.6 MPa	4,000 psi / 27.6 MPa	4,650 psi / 32.1 MPa	4,000 psi / 27.6 MPa	-
		77°F (psi) / 25°C (Mpa)	5,000 psi / 34.5 MPa	4,900 psi / 33.8 MPa	4,500 psi / 31.0 MPa	5,000 psi / 34.5 MPa	5,350 psi / 36.9 MPa	5,100 psi / 35.0 MPa	4,800 psi / 33.1 MPa
		180°F (psi) / 82°C (Mpa)	1,000 psi / 6.9 MPa	1,100 psi / 7.6 MPa	2,000 psi / 13.8 MPa	3,000 psi / 20.7 MPa	4,200 psi / 29.0 MPa	4,000 psi / 27.5 MPa	-
		Elevated Temperature (psi / MPa)	-	-	1,000 psi / 6.9 MPa	950 psi / 6.5 MPa	2,500 psi / 17.2 MPa	1,750 psi / 12 MPa	-
<b>Bulk Properties</b>	Tg Dry (°F / °C)	135 °F / 57 °C	129 °F / 54 °C	134 °F / 51 °C	151 °F / 66 °C	200 °F / 93 °C	223 °F / 106 °C	208 °F / 98 °C	
	Tg Wet (°F / °C)	-	-	150 °F / 66 °C	-	225 °F / 108 °C	192 °F / 89 °C	145 °F / 63 °C	
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	5,600 psi / 38.6 MPa	6,100 psi / 42.0 MPa	5300 psi / 36.6 MPa	-	-	-	-	
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	384 ksi / 2,646 MPa	390 ksi / 2,687 MPa	310 ksi / 2,136 MPa	487.2 ksi / 3360 MPa	-	-	-	
	Elongation @ 77°F / 25°C (% at break)	2,40 %	9,00 %	7,70 %	5,00 %	-	-	-	
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	7,700 psi / 53.1 MPa	-	7,700 psi / 53.1 MPa	9,878 psi / 68 MPa	11,300 psi / 78 MPa	-	-	
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	253 ksi / 1,743 MPa	-	-	368 ksi / 2,538 MPa	355 ksi / 2,950 MPa	-	-	
<b>Handling</b>	Mix Ratio Weight (Part A / Part B)	100 : 33	100 : 33	100 : 44	100 : 43	100 : 55	100 : 45	100 : 35	
	Cure Temperature (°F / °C)	77 – 200 °F / 25 – 93 °C	> 77 – 200 °F / > 25 – 93 °C	77 – 180 °F / 25 – 82 °C	77 – 180 °F / 25 – 82 °C	≥ 160 – 175 °F / 70 – 80 °C	180 – 220 °F / 82 – 104 °C	> 77 °F / 25 °C	
	Cure Time	5 – 7 Days / 1 Hour	5 – 7 Days / 1 Hour	5 – 7 Days /	150 °F / 66 °C				
	Storage Temperature (°F / °C)	77 °F / 25 °C	77 °F / 25 °C	77 °F / 25 °C	5 – 7 Days / 1 Hour	240 Minutes	2 hours / 1 hour	5 Days / 1 Hour	
	Pot Life (minutes / lb) / (minutes / kg)	60 Minutes / 100 Gram Mass	60 Minutes / 100 Gram Mass	60 Minutes / 100 Gram Mass	60 Minutes / 100 Gram Mass / 50 Minutes / 200 Gram Mass / 40 Minutes / 450 Gram Mass	77 °F / 25 °C	40 °F / 4 °C	40 °F / 4 °C	82 °F / 28 °C
<b>Product</b>	New Product Name	<b>LOCTITE EA 9330 AERO</b>	<b>LOCTITE EA 9330.3 AERO</b>	<b>LOCTITE EA 9359.3 AERO</b>	<b>LOCTITE EA 9360 AERO</b>	<b>LOCTITE EA 9380 AERO</b>	<b>LOCTITE EA 9380.05 AERO</b>	<b>LOCTITE EA 9345 AERO</b>	
	Known As	Hysol® EA 9330™	Hysol® EA 9330.3™	Hysol® EA 9359.3™	Hysol® EA 9360™	Hysol® EA 9380™NEW!	Hysol® EA 9380.05	Hysol® EA 9345™	
<b>Availability</b>	Packaging	Barrier Kit, Gram Kit, Gallon Kit	Quart Kit, Clip Pack	Quart Kit, Dual Cartridge, Gallon Kit	Quart Kit, Dual Cartridge, Gallon Kit	Dual Cartridge, Barrier Kit, Quart Kit	-	Gallon Kit	
<b>Description</b>	<b>LOCTITE EA 9330 AERO</b> <ul style="list-style-type: none"> <li>Two Component System</li> <li>Tolerant of Bondline Thickness Variations</li> <li>Room Temperature Cure</li> <li>High Peel Strength</li> <li>Excellent Environmental Resistance</li> </ul>	<b>LOCTITE EA 9330.3 AERO</b> <ul style="list-style-type: none"> <li>Two Component System</li> <li>Low Slump</li> <li>Room Temperature Cure</li> <li>Easy Mix</li> <li>High Peel Strength</li> </ul>	<b>LOCTITE EA 9359.3 AERO</b> <ul style="list-style-type: none"> <li>Easy Mix</li> <li>Good Environmental Resistance</li> <li>Non Sag</li> <li>High Shear Strength</li> <li>Bondline Thickness Control</li> <li>High Peel Strength</li> <li>Available in 2:1 Dual Cartridge with Static Mixer</li> </ul>	<b>LOCTITE EA 9360 AERO</b> <ul style="list-style-type: none"> <li>Available in dual cartridge packaging</li> <li>High peel strength</li> <li>Excellent static stress durability</li> <li>&gt; 225°F (107°C) service</li> <li>Easy mixing two component system</li> <li>Room temperature cure</li> <li>Low Slump</li> </ul>	<b>LOCTITE EA 9380 AERO</b> <ul style="list-style-type: none"> <li>Low temp curing two-part adhesive</li> <li>Meter mixable</li> <li>High strength, toughness and high temp resistance</li> <li>Prebond humidity resistant</li> </ul>	<b>LOCTITE EA 9380.05 AERO</b> <ul style="list-style-type: none"> <li>Low temp curing two-part adhesive</li> <li>Meter mixable</li> <li>High strength, toughness and high temp resistance</li> <li>Prebond humidity resistant</li> </ul>	<b>LOCTITE EA 9345 AERO</b> <ul style="list-style-type: none"> <li>Long Pot Life</li> <li>Non-Asbestos</li> <li>Toughened</li> </ul>		



## Metal, Honeycomb Bonding & Repair

Characteristics									
180°F / 82°C Service									
300°F / 149°C Service									
350°F / 177°C Service									
450°F / 232°C Service									
Improved Hot / Wet Properties									
Toughened									
Consistency		Low Viscosity	Thixotropic	Low Viscosity	Thixotropic	Thixotropic	Thixotropic	Moderate Viscosity	Thixotropic
Form		2 Part	2 Part	2 Part	2 Part	2 Part	2 Part	2 Part	2 Part
Peel Strength		Nil	Nil	Nil	Low	Nil	Low	Low	Low
Mechanical Properties									
Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)		-	-	-	20 lbs / in / 89 N / 25 mm	20 lbs / in / 90 N / 25 mm	10 lbs / in / 45 N / 25 mm	15 lbs / in / 67 N / 25 mm	
TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	1,780 psi / 12.3 MPa	3,100 psi / 21.4 MPa	2,200 psi / 15.2 MPa	3,300 psi / 22.7 MPa	2,700 psi / 18.6 MPa	3,500 psi / 24.1 MPa	2,300 psi / 15.8 MPa	
	77°F (psi) / 25°C (Mpa)	2,300 psi / 15.8 MPa	3,700 psi / 25.5 MPa	2,600 psi / 17.9 MPa	4,200 psi / 28.9 MPa	4,910 psi / 33.9 MPa	5,000 psi / 34.5 MPa	4,300 psi / 29.7 MPa	
	180°F (psi) / 82°C (Mpa)	1,500 psi / 10.3 MPa	2,800 psi / 19.3 MPa	3,000 psi / 20.7 MPa	3,000 psi / 20.7 MPa	3,140 psi / 21.7 MPa	4,000 psi / 27.5 MPa	3,500 psi / 24.1 MPa	
	Elevated Temperature (psi / MPa)	1,000 psi / 6.9 MPa	1,200 psi / 8.3 MPa	1,700 psi / 11.7 MPa	1,200 psi / 8.3 MPa	1,640 psi / 11.3 MPa	2,500 psi / 17.2 MPa	1,200 psi / 8.3 MPa	
Bulk Properties									
Tg Dry (°F / °C)		156 °F / 69 °C	159 °F / 71 °C	345 °F / 174 °C	172 °F / 78 °C	158 °F / 70 °C	-	163 °F / 73 °C	
Tg Wet (°F / °C)		-	235 °F / 113 °C	302 °F / 150 °C	154 °F / 68 °C	196 °F / 91 °C	-	246 °F / 119 °C	
Tensile Strength @ 77°F (psi) / 25°C (MPa)		5,800 psi / 40.0 MPa	5,800 psi / 40.0 MPa	8,200 psi / 56.5 MPa	6,675 psi / 46.0 MPa	-	-	8,070 psi / 55.6 MPa	
Tensile Modulus @ 77°F (ksi) / 25°C (MPa)		370 ksi / 2,552 MPa	550 ksi / 3,792 MPa	418 ksi / 2,880 MPa	615 ksi / 4,237 MPa	-	-	717 ksi / 4,940 MPa	
Elongation @ 77°F / 25°C (% at break)		2.40 %	1.20 %	2.50 %	1.77 %	-	-	2.60%	
Compressive Strength @ 77°F (psi) / 25°C (MPa)		12,000 psi / 82.8 MPa	9,500 psi / 65.5 MPa	5,300 psi / 36.6 MPa	10,000 psi / 68.9 MPa	11,329 psi / 78.1 MPa	32,000 psi / 220.7 MPa	14,000 psi / 94.5 MPa	
Compressive Modulus @ 77°F (ksi) / 25°C (MPa)		158 ksi / 1,089 MPa	367 psi / 2,530 MPa	-	-	-	-	429 ksi / 2,956 MPa	
Handling									
Mix Ratio Weight (Part A / Part B)		100 : 58	100 : 33	100 : 56	100 : 17	100 : 27	100 : 20	100 : 17	
Cure Temperature (°F / °C)		77 - 200 °F / 25 - 93 °C	77 - 200 °F / 25 - 93 °C	200 °F / 93 °C 250 °F / 121 °C 300 °F / 149 °C	77 - 200 °F / 25 - 93 °C	77 °F / 25 °C	> 200 °F / 93 °C	77 - 150 °F / 25 - 66 °C	
Cure Time		5 - 7 Days / 1 Hour	5 - 7 Days / 1 Hour	220 Minutes 150 Minutes 130 Minutes	3 - 5 Days / 1 Hour	24 Hours	1 Hour	5 Days / 1 Hour	
Storage Temperature (°F / °C)		40 °F / 4 °C	40 °F / 4 °C	40 °F / 4 °C	77 °F / 25 °C	77 °F / 25 °C	77 °F / 25 °C	77 °F / 25 °C	
Pot Life (minutes / lb) / (minutes / kg)		> 30 minutes / 450 Gram Mass	40 - 50 minutes / 450 Gram Mass	120 Minutes / 250 Gram Mass	90 Minutes / 450 Gram Mass	20 - 30 Minutes / 100 Gram Mass	7 Hours / 450 Gram Mass	95 - 100 Minutes / 450 Gram Mass	
Product									
New Product Name		<b>LOCTITE EA 956 AERO</b>	<b>LOCTITE EA 934NA AERO</b>	<b>LOCTITE EA 9390 AERO</b>	<b>LOCTITE EA 9394 AERO</b>	<b>LOCTITE EA 9394.2 AERO</b>	<b>LOCTITE EA 9394/C-2 AERO</b>	<b>LOCTITE EA 9395 AERO</b>	
Known As		Hysol® EA 956™	Hysol® EA 934NA™	Hysol® EA 9390™	Hysol® EA 9394™	Hysol® EA 9394.2™	Hysol® EA 9394™ / C-2™	Hysol® EA 9395™	
Availability									
Packaging		Clip Pack, Gallon Kit, Gram Kit, Pint Kit, Quart Kit	Barrier Kit, Clip Pack, Gallon Kit, Gram Kit, Pint Kit, Quart Kit	Quart Kit, Gram Kit, Clip Pack, Barrier Kit	55-Gallon Kit, 5-Gallon Kit, Clip Pack, Dual Cartridge, Gram Kit, Pint Kit, Quart Kit	Dual Cartridge, Pint Kit, Quart Kit, Clip Pack, Gallon Kit, 5-Gallon Kit	Quart Kit, Injection Kit, Clip Pack	Quart Kit, Injection Kit, Clip Pack, 5-Gallon Kit, Gallon Kit	
Description									
<b>LOCTITE EA 956 AERO</b> is a two-component, adhesive, which has excellent elevated temperature strength. Its room temperature cure capability and low viscosity make it ideal for repair applications, including laminating, injection, and coating.		<b>LOCTITE EA 934NA AERO</b> is a two-component thixotropic paste adhesive, which cures at room temperature and possesses superior strength to 300 °F / 149 °C and higher. Its thixotropic nature and good compressive strength make it ideal for potting, filling, and fairing, as well as for shim applications.	<b>LOCTITE EA 9390 AERO</b> <ul style="list-style-type: none"><li>• Good Hot/Wet Strength</li><li>• Good Wetting</li><li>• High Shear Modulus</li></ul>		<b>LOCTITE EA 9394 AERO</b> <ul style="list-style-type: none"><li>• Good Gap Filling Capabilities</li><li>• Potting Material</li><li>• Room Temperature Storage</li><li>• Outstanding Mechanical Properties</li><li>• Long Pot Life</li><li>• Low Toxicity</li></ul>	<b>LOCTITE EA 9394.2 AERO</b> is a fast curing two-part structural paste adhesive, which cures at room temperature. Its thixotropic nature makes it ideal for potting, filling, and liquid shim applications.	<b>LOCTITE EA 9394/C-2 AERO</b> is an elevated temperature curing, high service temperature structural paste adhesive. It uses a non-aromatic amine curing agent that retains many of the excellent properties offered by aromatic amine cured systems, high temperature service with a long pot life.	<b>LOCTITE EA 9395 AERO</b> <ul style="list-style-type: none"><li>• Non-Metallic Filler</li><li>• Cures at Ambient Temperature</li><li>• Thixotropic</li><li>• Excellent Mechanical Properties</li><li>• Good Compressive Strength</li></ul>	

## Metal, Honeycomb Bonding & Repair

<b>Characteristics</b>	180°F / 82°C Service									
	300°F / 149°C Service	•	•						•	
	350°F / 177°C Service			•		•		•		
	450°F / 232°C Service									
	Improved Hot / Wet Properties	•	•							
	Toughened	•		•		•			•	
	Consistency	Low Viscosity	Low Viscosity	Moderate Viscosity		Thixotropic	Thixotropic	Thixotropic	Moderate Viscosity	
	Form	2 Part	2 Part	2 Part		2 Part	2 Part	2 Part	2 Part	
	Peel Strength	Moderate	Low	High		High	Low	Nil	High	
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	25 lbs / in / 111 N / 25 mm	15 lbs / in / 67 N / 25 mm	25 lbs / in / 111 N / 25 mm		40 lbs / in / 178 N / 25 mm	20 lbs / in / 90 N / 25 mm	-	40 lbs / in / 178 N / 25 mm	
	TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	3,300 psi / 22.8 MPa	2,500 psi / 17.2 MPa	6,700 psi / 46.2 MPa		3,500 psi / 24.1 MPa	3,300 psi / 22.7 MPa	-	4600 psi / 31.7 Mpa
		77°F (psi) / 25°C (Mpa)	3,500 psi / 24.1 MPa	4,600 psi / 31.7 MPa	6,100 psi / 42.1 MPa		4,300 psi / 29.6 MPa	4,200 psi / 28.9 MPa	1,650 psi / 11.4 MPa	5400 psi / 37.2 Mpa
		180°F (psi) / 82°C (Mpa)	3,200 psi / 22.0 MPa	4,100 psi / 28.3 MPa	1,300 psi / 9.0 MPa		2,500 psi / 17.2 MPa	3,000 psi / 20.7 MPa	525 psi / 3.6 MPa	1000 psi / 6.9 Mpa
		Elevated Temperature (psi / MPa)	1,250 psi / 8.6 MPa	2,500 psi / 17.2 MPa	-		1,000 psi / 6.9 MPa	600 psi / 4.1 MPa	-	-
<b>Bulk Properties</b>	Tg Dry (°F / °C)	208 °F / 98 °C	226°F / 108°C	127 °F / 53 °C		164 °F / 73 °C	172 °F / 78 °C	248 °F / 120 °C	174°F / 79°C	
	Tg Wet (°F / °C)	145 °F / 63 °C	232°F / 111°C	147 °F / 64 °C		144 °F / 62 °C	154 °F / 68 °C	-	138°F / 59°C	
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	8,000 psi / 55.2 MPa	-	4,500 psi / 31 MPa		6,000 psi / 41.3 MPa	6,675 psi / 46.0 MPa	-	5400 psi / 37.2 Mpa	
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	400 ksi / 2,750 MPa	-	338 ksi / 2,331 MPa		475 ksi / 3,273 MPa	615 ksi / 4,237 MPa	-	-	
	Elongation @ 77°F / 25°C (% at break)	3,40 %	-	10,00 %		4,00 %	1,70 %	-	4,80%	
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	70,000 psi / 482.8 MPa	14,000 psi / 96.6 MPa	7,000 psi / 48.2 MPa		9,300 psi / 64.1 MPa	10,000 psi / 68.9 MPa	3,270 psi / 22.5 MPa	7700 psi / 53 MPa	
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	8,000 psi / 55,150 MPa	-	249 ksi / 1,716 MPa		-	-	172.5 ksi / 1,188 MPa	218 Ksi / 1502 MPa	
<b>Handling</b>	Mix Ratio Weight (PartA / Part B)	100 : 30	100 : 36	100 : 30		100 : 32	-	100 : 40	100 : 22	
	Cure Temperature (°F / °C)	77 - 150 °F / 25 - 66 °C	200 °F / 93 °C	77 °F / 25 °C / 150 °F / 66 °C		77 °F / 25 °C / 180 °F / 82 °C	77 - 200 °F / 25 - 93 °C	77 °F / 25 °C	77 - 200 °F / 25 - 93°C	
	Cure Time	3 - 5 Days / 1 Hour	1 Hour	3 - 5 Days / 1 Hour		5 - 7 Day / 1 Hour	3 - 5 Days / 1 Hour	24 Hours	5 Days	
	Storage Temperature (°F / °C)	77 °F / 25 °C	77 °F / 25 °C	77 °F / 25 °C		82 °F / 28 °C	82 °F / 28 °C	82 °F / 28 °C	82 °F / 28°C	
	Pot Life (minutes / lb) / (minutes / kg)	120 Minutes / 100 Gram Mass	7 Hours / 450 Gram Mass	120 Minutes / 100 Gram Mass		75 Minutes / 100 Gram Mass	90 Minutes / 450 Gram Mass	20 Minutes / 400 Gram Mass	30 Minutes / 450 Gram Mass	
<b>Product</b>	New Product Name	<b>LOCTITE EA 9396 AERO</b>	<b>LOCTITE EA 9396/C-2 AERO</b>	<b>LOCTITE EA 9309NA AERO</b>		<b>LOCTITE EA 9392 AERO</b>	<b>LOCTITE EA 9394S AERO</b>	<b>LOCTITE EA 9891RP AERO</b>	<b>LOCTITE EA 9309.2 AERO</b>	
	Known As	Hysol® EA 9396™	Hysol® EA 9396™ / C-2™	Hysol® EA 9309NA™		Hysol® EA 9392™	Hysol® EA 9394S™	Hysol® EA 9891RP™	Hysol® EA 9309.2™	
<b>Availability</b>	Packaging	50-Gram Kit, 5-Gallon Kit, Barrier Kit, Clip Pack, Gallon Kit, Gram Kit, Injection Kit, Pint Kit, Quart Kit	Quart Kit	Pint Kit, Quart Kit, Gallon Kit, Clip Pack, Injection Kit		Quart Kit	Injection Kit	Barrier Kit, Quart Kit	Pudding Cup, Quart Kit	
<b>Description</b>	<b>LOCTITE EA 9396 AERO</b> is a two-component, adhesive, which has excellent elevated temperature strength. Its room temperature cure capability and low viscosity make it ideal for repair applications, including laminating, injection, and coating.	<b>LOCTITE EA 9396/C-2 AERO</b> is a two-component thixotropic paste adhesive, which cures at room temperature and possesses superior strength to 300 °F / 149 °C and higher. Its thixotropic nature and good compressive strength make it ideal for potting, filling, and fairing, as well as for shim applications.	<b>LOCTITE EA 9309NA AERO</b> • High Peel Strength • Bonds Many Surfaces		<b>LOCTITE EA 9392 AERO</b> is a paste adhesive, which possesses excellent shear strength at high temperatures. This product exhibits excellent toughness and yields durable bonds over a wide temperature range.	<b>Loctite EA 9394S AERO</b> is a two-part structural paste adhesive, which possesses excellent strength at high temperatures. Its thixotropic nature and excellent high temperature compressive strength also make it ideal for potting, filling and liquid shim applications.	<b>LOCTITE EA 9891RP AERO</b> is a two-component room temperature curing, abrasion resistant repair paste adhesive suitable for repairing LOCTITE EF 9890 AERO abrasable seal.	<b>LOCTITE EA 9309.2 AERO</b> is a two part epoxy sytem bonds metal skins and honeycomb core to yield tough permanently flexible joints that resist humidity, water and most common fluids. Its outstanding feature is high shear and peel strength on aluminum bonds at moderate temperatures.		

When structural integrity matters:

## LOCTITE composite bonding and repair adhesives

### Concerning critical aircraft components, some questions might come up

In order to preserve the structural integrity of critical aircraft components, manufacturers need the right adhesives to bond or join composite sub-components with excellent chemical resistance, variable viscosity and extraordinary mechanical performance.

### Henkel gives a strong answer: LOCTITE composite bonding adhesives

LOCTITE products for composite bonding fulfill all these requirements and allow engineers to create efficient structures. No fasteners are needed. They offer lower adherent thickness, let you take advantage of stiffness properties of composites and provide a separation of dissimilar materials.

#### Why choose LOCTITE composite bonding adhesives?

- › Easy to mix
- › Good environmental resistance
- › Sag resistant
- › High shear & peel strength
- › Bond line thickness control

## LOCTITE composite bonding adhesives: Facts at a glance

#### LOCTITE composite bonding adhesives key features:

- › High service temperature
- › Prepreg
- › Compatibility with aerospace systems
- › Good wetting of metallic and composite surfaces
- › High mechanical performance
- › Toughness tailorable to requirements
- › Variations in form: One or two part
- › Variable viscosity to fit application requirements
- › Excellent chemical resistance vs. solvents and water

#### Key factors to consider when choosing the right LOCTITE composite bonding adhesive

- › Viscosity
- › Shelf life / out-time
- › Cure temperature
- › Glass transition temperature (Tg)

## Composite Bonding and Repair

<b>Characteristics</b>	180°F / 82°C Service	•	•	•	
	300°F / 149°C Service				
	350°F / 177°C Service				
	450°F / 232°C Service				
	Improved Hot / Wet Properties	•			
	Toughened	•	•	•	
	Consistency	Moderate Viscosity	Moderate Viscosity	Thixotropic	
	Form	2 Part	2 Part	2 Part	
Peel Strength	High	High	High		
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	94 lbs / in / 418 N / 25mm	92 lbs / in / 409 N / 25 mm	93 lbs / in / 414 N / 25 mm	
	TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	5,500 psi / 38.0 MPa	5,000 psi / 34.5 MPa	5,700 psi / 39.3 MPa
		77°F (psi) / 25°C (Mpa)	5,000 psi / 34.5 MPa	5,000 psi / 34.5 MPa	4,900 psi / 33.8 MPa
		180°F (psi) / 82°C (Mpa)	750 psi / 5.2 MPa	1,000 psi / 6.9 MPa	1,100 psi / 7.6 MPa
		Elevated Temperature (psi / MPa)	-	-	-
<b>Bulk Properties</b>	Tg Dry (°F / °C)	142 °F / 61 °C	135 °F / 57 °C	129 °F / 54 °C	
	Tg Wet (°F / °C)	147 °F / 64 °C	-	-	
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	4,670 psi / 32.2 MPa	5,600 psi / 38.6 MPa	6,100 psi / 42.0 MPa	
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	334 ksi / 2,303 MPa	384 ksi / 2,646 MPa	390 ksi / 2,687 MPa	
	Elongation @ 77°F / 25°C (% at break)	10,00 %	2,40 %	9,00 %	
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	7,500 psi / 51.7 MPa	7,700 psi / 53.1 MPa	-	
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	245 ksi / 1,688 MPa	253 ksi / 1,743 MPa	-	
	<b>Handling</b>	Mix Ratio Weight (Part A / Part B)	100 : 22	100 : 33	100 : 33
Cure Temperature (°F / °C)		77 °F / 25 °C 180 °F / 82 °C	77 – 200 °F / 25 – 93 °C	> 77 – 200 °F / > 25 – 93 °C	
Cure Time		3 – 5 Days / 1 Hour	5 – 7 Days / 1 Hour	5 – 7 Days / 1 Hour	
Storage Temperature (°F / °C)		77 °F / 25 °C	77 °F / 25 °C	77 °F / 25 °C	
Pot Life (minutes / lb) / (minutes / kg)		35 minutes / 450 Mram Mass	60 Minutes / 100 Gram Mass	60 Minutes / 100 Gram Mass	
<b>Product</b>	New Product Name	<b>LOCTITE EA 9309.3NA AERO</b>	<b>LOCTITE EA 9330 AERO</b>	<b>LOCTITE EA 9330.3 AERO</b>	
	Known As	Hysol® EA 9309.3NA™	Hysol® EA 9330™	Hysol® EA 9330.3™	
<b>Availability</b>	Packaging	Clip Pack, Gallon Kit, Gram Kit, Injection Kit, Quart Kit	Barrier Kit, Gram Kit, Gallon Kit	Quart Kit, Clip Pack	
<b>Description</b>	<b>LOCTITE EA 9309.3NA AERO</b>	<b>LOCTITE EA 9330 AERO</b>	<b>LOCTITE EA 9330.3 AERO</b>		
	<ul style="list-style-type: none"> <li>• High Shear Strength</li> <li>• High Peel Strength</li> <li>• Bondline Thickness Control</li> <li>• Good Environmental Resistance</li> </ul>	<ul style="list-style-type: none"> <li>• Two Component System</li> <li>• Tolerant of Bondline Thickness Variations</li> <li>• Room Temperature Cure</li> <li>• High Peel Strength</li> <li>• Excellent Environmental Resistance</li> </ul>	<ul style="list-style-type: none"> <li>• Two Component System</li> <li>• Low Slump</li> <li>• Room Temperature Cure</li> <li>• Easy Mix</li> <li>• High Peel Strength</li> </ul>		

# Composite Bonding and Repair

<b>Characteristics</b>	180°F / 82°C Service	•	•	•	•	•	•	•		
	300°F/149°C Service							•		
	350°F / 177°C Service									
	450°F / 232°C Service									
	Improved Hot / Wet Properties	•	•	•	•	•	•	•		
	Toughened	•	•	•	•	•	•	•		
	Consistency	Thixotropic	Thixotropic	Thixotropic	Thixotropic	Moderate Viscosity	Low Viscosity	Thixotropic		
	Form	2 Part	2 Part	2 Part	2 Part	2 Part	2 Part	2 Part		
	Peel Strength	High	High	High	High	Low	Nil	Low		
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	75 lbs / in / 335 N / 25 mm	60 lbs / in / 265 N / 25 mm	50 lbs / in / 178 N / 25 mm		40 lbs / in / 220 N / 25 mm	20 lbs / in / 89 N / 25 mm	-	20 lbs / in / 89 N / 25 mm	
	TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	4,000 psi / 27.6 MPa	4,000 psi / 27.6 MPa	4,650 psi / 32.1 MPa		4,000 psi / 27.6 MPa	-	2,200 psi / 15.2 MPa	3,300 psi / 22.7 MPa
		77°F (psi) / 25°C (Mpa)	4,500 psi / 31.0 MPa	5,000 psi / 34.5 MPa	5,350 psi / 36.9 MPa		5,100 psi / 35.0 MPa	4,370 psi / 30.1 MPa	2,600 psi / 17.9 MPa	4,200 psi / 28.9 MPa
		180°F (psi) / 82°C (Mpa)	2,000 psi / 13.8 MPa	3,000 psi / 20.7 MPa	4,200 psi / 29.0 MPa		4,000 psi / 27.5 MPa	-	3,000 psi / 20.7 MPa	3,000 psi / 20.7 MPa
		Elevated Temperature (psi / MPa)	1,000 psi / 6.9 MPa	950 psi / 6.5 Mpa	2,500 psi / 17.2 MPa		1,750 psi / 12 MPa	-	1,700 psi / 11.7 MPa	1,200 psi / 8.3 MPa
<b>Bulk Properties</b>	Tg Dry (°F / °C)	134°F / 51°C	151 °F / 66 °C	200 °F / 93 °C		223 °F / 106 °C	-	345 °F / 174 °C	172 °F / 78 °C	
	Tg Wet (°F / °C)	150 °F / 66 °C	-	225 °F / 108 °C		192 °F / 89 °C	-	302 °F / 150 °C	154 °F / 68 °C	
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	5300 psi / 36.6 MPa	-	-		-	-	8,200 psi / 56.5 MPa	6,675 psi / 46.0 MPa	
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	310 ksi / 2,136 MPa	487.2 ksi / 3360 MPa	-		-	-	418 ksi / 2,880 MPa	615 ksi / 4,237 MPa	
	Elongation @ 77°F / 25°C (% at break)	7,70 %	5,00 %	-		-	-	2,50 %	1,77%	
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	7,700 psi / 53.1 MPa	9,878 psi / 68 MPa	11,300 psi / 78 MPa		-	-	5,300 psi / 36.6 MPa	10,000 psi / 68.9 MPa	
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	-	368 ksi / 2,538 MPa	355 ksi / 2,950 MPa		-	-	-	-	
<b>Handling</b>	Mix Ratio Weight (PartA / Part B)	100 : 44	100 : 43	100 : 55		100 : 45	100 : 42.4	100 : 56	100 : 17	
	Cure Temperature (°F / °C)	77-- 180 °F / 25 - 82 °C	77 - 180 °F / 25 - 82 °C	≥ 160 - 175 °F / 70 - 80 °C		180 - 220 °F / 82 - 104 °C	> 77 °F / 25 °C / 180 °F / 83 °C"	200 °F / 93 °C / 250 °F / 121 °C / 300 °F / 149 °C"	77 - 200 °F / 25 - 93 °C	
	Cure Time	5 - 7 Days / 1 Hour	5 - 7 Days/ 1 Hour	240 Minutes		2 hours / 1 hour	5 - 7 Days / 1 Hour	220 Minutes / 150 Minutes / 130 Minutes	3 - 5 Days / 1 Hour	
	Storage Temperature (°F / °C)	77 °F / 25 °C	77 °F / 25 °C	40 °F / 4 °C		40 °F / 4 °C	77 °F / 25 °C	40 °F / 4 °C	77 °F / 25 °C	
	Pot Life (minutes / lb) / (minutes / kg)	60 Minutes / 100 Gram Mass / 50 Minutes / 200 Gram Mass / 40 Minutes / 450 Gram Mass	50 Minutes / 200 Gram Mass	180 Minutes / 500 Gram Mass		300 Minutes / 500 Gram Mass	60 Minutes / 20 Gram Mass	120 Minutes / 250 Gram Mass	90 Minutes / 450 Gram Mass	
<b>Product</b>	New Product Name	<b>LOCTITE EA 9359.3 AERO</b>	<b>LOCTITE EA 9360 AERO</b>	<b>LOCTITE EA 9380 AERO</b>		<b>LOCTITE EA 9380.05 AERO</b>	<b>LOCTITE EA 9364FR AERO</b>	<b>LOCTITE EA 9390 AERO</b>	<b>LOCTITE EA 9394 AERO</b>	
	Known As	Hysol® EA 9359.3™	Hysol® EA 9360™	Hysol® EA 9380™NEW!		Hysol® EA 9380.05	Hysol® EA 9364FR™	Hysol® EA 9390™	Hysol® EA 9394™	
<b>Availability</b>	Packaging	Quart Kit, Dual Cartridge, Gallon Kit"	Quart Kit, Dual Cartridge, Gallon Kit	Dual Cartridge, Barrier Kit, Quart Kit		-	-	Quart Kit, Gram Kit, Clip Pack, Barrier Kit	55-Gallon Kit, 5-Gallon Kit, Clip Pack, Dual Cartridge, Gram Kit, Pint Kit, Quart Kit	
<b>Description</b>		<b>LOCTITE EA 9359.3 AERO</b> • Easy Mix • Good Environmental Resistance • Non Sag • High Shear Strength • Bondline Thickness Control • High Peel Strength • Available in 2:1 Dual Cartridge with Static Mixer	<b>LOCTITE EA 9360 AERO</b> • Available in dual cartridge packaging • High peel strength • Excellent static stress durability • > 225°F (107°C) service • Easy mixing two component system • Room temperature cure • Low Slump	<b>LOCTITE EA 9380 AERO</b> • Low temp curing two-part adhesive • Meter mixable • High strength, toughness and high temp resistance • Prebond humidity resistant		<b>LOCTITE EA 9380.05 AERO</b> • Low temp curing two-part adhesive • Meter mixable • High strength, toughness and high temp resistance • Prebond humidity resistant	<b>LOCTITE EA 9364FR AERO</b> is a two-component flame retardant toughened paste adhesive, with excellent mechanical performance. It contains no halogenated resins common in many other flame retardant products.	<b>LOCTITE EA 9390 AERO</b> • Good Hot/Wet Strength • Good Wetting • High Shear Modulus	<b>LOCTITE EA 9394 AERO</b> • Good Gap Filling Capabilities • Potting Material • Room Temperature Storage • Outstanding Mechanical Properties • Long Pot Life • Low Toxicity	

# Composite Bonding and Repair

Characteristics									
180°F / 82°C Service									
300°F/149°C Service									
350°F / 177°C Service									
450°F / 232°C Service									
Improved Hot / Wet Properties									
Toughened									
Consistency		Thixotropic	Moderate Viscosity	Moderate Viscosity		Moderate Viscosity	Thixotropic	Low Viscosity	Low Viscosity
Form		2 Part	2 Part	2 Part		2 Part	2 Part	2 Part	2 Part
Peel Strength		Nil	High	High		Low	Low	Moderate	Low
Mechanical Properties									
Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)		20 lbs / in / 90 N / 25 mm	44 lbs / in / 196 N / 25 mm	65 lbs / in / 289 N / 25 mm		10 lbs / in / 45 N / 25 mm	15 lbs / in / 67 N / 25 mm	25 lbs / in / 111 N / 25 mm	15 lbs / in / 67 N / 25 mm
TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	2,700 psi / 18.6 MPa	-	6,525 psi / 45 MPa		3,500 psi / 24.1 MPa	2,300 psi / 15.8 MPa	3,300 psi / 22.8 MPa	2,500 psi / 17.2 MPa
	77°F (psi) / 25°C (Mpa)	4,910 psi / 33.9 MPa	4,800 psi / 33.1 MPa	6,525 psi / 45 MPa		5,000 psi / 34.5 MPa	4,300 psi / 29.7 MPa	3,500 psi / 24.1 MPa	4,600 psi / 31.7 MPa
	180°F (psi) / 82°C (Mpa)	3,140 psi / 21.7 MPa	-	3,625 psi / 25 MPa		4,000 psi / 27.5 MPa	3,500 psi / 24.1 MPa	3,200 psi / 22.0 MPa	4,100 psi / 28.3 MPa
	Elevated Temperature (psi / MPa)	1,640 psi / 11.3 MPa	-	-		2,500 psi / 17.2 MPa	1,200 psi / 8.3 MPa	1,250 psi / 8.6 MPa	2,500 psi / 17.2 MPa
Bulk Properties									
Tg Dry (°F / °C)		158 °F / 70 °C	208 °F / 98 °C	-		-	163 °F / 73 °C	208 °F / 98 °C	226°F / 108°C
Tg Wet (°F / °C)		196 °F / 91 °C	145 °F / 63 °C	-		-	246 °F / 119 °C	145 °F / 63 °C	232°F / 111°C
Tensile Strength @ 77°F (psi) / 25°C (MPa)		-	-	-		-	8,070 psi / 55.6 MPa	8,000 psi / 55.2 MPa	-
Tensile Modulus @ 77°F (ksi) / 25°C (MPa)		-	-	-		-	717 ksi / 4,940 MPa	400 ksi / 2,750 MPa	-
Elongation @ 77°F / 25°C (% at break)		-	-	-		-	2,60 %	3,40 %	-
Compressive Strength @ 77°F (psi) / 25°C (MPa)		11,329 psi / 78.1 MPa	-	-		32,000 psi / 220.7 MPa	14,000 psi / 94.5 MPa	70,000 psi / 482.8 MPa	14,000 psi / 96.6 MPa
Compressive Modulus @ 77°F (ksi) / 25°C (MPa)		-	-	-		-	429 ksi / 2.956 MPa	8,000 psi / 55,150 MPa	-
Handling									
Mix Ratio Weight (PartA / Part B)		100 : 27	100 : 35	100 : 43		100 : 20	100 : 17	100 : 30	100 : 36
Cure Temperature (°F / °C)		77 °F / 25 °C	> 77 °F / 25 °C / 150 °F / 66 °C	> 77 °F / 25 °C / 150 °F / 66 °C		> 200 °F / 93 °C	77 – 150 °F / 25 - 66 °C	77 – 150 °F / 25 - 66 °C	200 °F / 93 °C
Cure Time		24 Hours	5 Days / 1 Hour	5 – 7 Days / 2 Hours		1 Hour	5 Days / 1 Hour	3 – 5 Days / 1 Hour	1 Hour
Storage Temperature (°F / °C)		77 °F / 25 °C	82 °F / 28 °C	82 °F / 28 °C		77 °F / 25 °C	77 °F / 25 °C	77 °F / 25 °C	77 °F / 25 °C
Pot Life (minutes / lb) / (minutes / kg)		20 – 30 Minutes / 100 Gram Mass	90 Minutes / 400 Gram Mass	30 Minutes / 100 Gram Mass		7 Hours / 450 Gram Mass	95 – 100 Minutes / 450 Gram Mass	120 Minutes / 100 Gram Mass	7 Hours / 450 Gram Mass
Product									
New Product Name		<b>LOCTITE EA 9394.2 AERO</b>	<b>LOCTITE EA 9345 AERO</b>	<b>LOCTITE EA 9363 AERO</b>		<b>LOCTITE EA 9394/C-2 AERO</b>	<b>LOCTITE EA 9395 AERO</b>	<b>LOCTITE EA 9396 AERO</b>	<b>LOCTITE EA 9396/C-2 AERO</b>
Known As		Hysol® EA 9394.2™	Hysol® EA 9345™	Hysol® EA 9363™		Hysol® EA 9394™ / C-2™	Hysol® EA 9395™	Hysol® EA 9396™	Hysol® EA 9396™ / C-2™
Availability									
Packaging		Dual Cartridge, Pint Kit, Quart Kit, Clip Pack, Gallon Kit, 5-Gallon Kit	Gallon Kit	5-Gallon Kit, Gallon Kit		Quart Kit, Injection Kit, Clip Pack	Quart Kit, Injection Kit, Clip Pack, 5-Gallon Kit, Gallon Kit	50-Gram Kit, 5-Gallon Kit, Barrier Kit, Clip Pack, Gallon Kit, Gram Kit, Injection Kit, Pint Kit, Quart Kit	Quart Kit
Description									
<b>LOCTITE EA 9394.2 AERO</b> is a fast curing two-part structural paste adhesive, which cures at room temperature. Its thixotropic nature makes it ideal for potting, filling, and liquid shim applications.		<b>LOCTITE EA 9345 AERO</b> • Long Pot Life • Non-Asbestos • Toughened	<b>LOCTITE EA 9363 AERO</b> is a two-component toughened paste adhesive, which combines high peel strength at room temperature with tensile lap shear strength at 200 °F / 93 °C.		<b>LOCTITE EA 9394/C-2 AERO</b> is an elevated temperature curing, high service temperature structural paste adhesive. It uses a non-aromatic amine curing agent that retains many of the excellent properties offered by aromatic amine cured systems, high temperature service with a long pot life.	<b>LOCTITE EA 9395 AERO</b> • Non-Metallic Filler • Cures at Ambient Temperature • Thixotropic • Excellent Mechanical Properties • Good Compressive Strength	<b>LOCTITE EA 9396 AERO</b> • Low Viscosity • Room Temperature Cure • Room Temperature Storage • High Strength at Low and High Temperatures	<b>LOCTITE EA 9396/C-2 AERO</b> • Low Viscosity • Long Work Life • Non-MDA Curing Agent • Ideal for use as Neat Lay-up Resin	

# Composite Bonding and Repair

Characteristics								
180°F / 82°C Service								
300°F/149°C Service								
350°F / 177°C Service		•	•	•				
450°F / 232°C Service								
Improved Hot / Wet Properties								
Toughened		•	•		•			•
Consistency		Moderate Viscosity	Thixotropic	Thixotropic		Moderate Viscosity	Thixotropic	Moderate Viscosity
Form		2 Part	2 Part	2 Part		2 Part	2 Part	2 Part
Peel Strength		High	High	Low		High	Nil	High
Mechanical Properties								
Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)		25 lbs / in / 111 N / 25 mm	40 lbs / in / 178 N / 25 mm	20 lbs / in / 90 N / 25 mm		35 lbs / in / 150 N / 25 mm	-	40 lbs / in / 178 N / 25 mm
TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	6,700 psi / 46.2 MPa	3,500 psi / 24.1 MPa	3,300 psi / 22.7 MPa		4,900 psi / 33.8 MPa	2,000 psi / 13.8 MPa	4600 psi / 31.7 Mpa
	77°F (psi) / 25°C (Mpa)	6,100 psi / 42.1 MPa	4,300 psi / 29.6 MPa	4,200 psi / 28.9 MPa		5,000 psi / 34.5 MPa	2,200 psi / 15.2 MPa	5400 psi / 37.2 Mpa
	180°F (psi) / 82°C (Mpa)	1,300 psi / 9.0 MPa	2,500 psi / 17.2 MPa	3,000 psi / 20.7 MPa		2,300 psi / 15.9 MPa	700 psi / 4.8 MPa	1000 psi / 6.9 Mpa
	Elevated Temperature (psi / MPa)	-	1,000 psi / 6.9 MPa	600 psi / 4.1 MPa		-	-	-
Bulk Properties								
Tg Dry (°F / °C)		127 °F / 53 °C	164 °F / 73 °C	172 °F / 78 °C		180 °F / 82 °C	150 °F / 66 °C	174°F / 79°C
Tg Wet (°F / °C)		147 °F / 64 °C	144 °F / 62 °C	154 °F / 68 °C		-	175 °F / 79 °C	138°F / 59°C
Tensile Strength @ 77°F (psi) / 25°C (MPa)		4,500 psi / 31 MPa	6,000 psi / 41.3 MPa	6,675 psi / 46.0 MPa		5,000 psi / 34.5 MPa	2200 psi / 15.2 MPA	5400 psi / 37.2 Mpa
Tensile Modulus @ 77°F (ksi) / 25°C (MPa)		338 ksi / 2,331 MPa	475 ksi / 3,273 MPa	615 ksi / 4,237 MPa		330 ksi / 2,274 MPa	-	-
Elongation @ 77°F / 25°C (% at break)		10,00 %	4,00 %	1,70 %		9,00 %	-	4,80%
Compressive Strength @ 77°F (psi) / 25°C (MPa)		7,000 psi / 48.2 MPa	9,300 psi / 64.1 MPa	10,000 psi / 68.9 MPa		8,000 psi / 55.1 MPa	-	7700 psi / 53 MPa
Compressive Modulus @ 77°F (ksi) / 25°C (MPa)		249 ksi / 1,716 MPa	-	-		265 ksi / 1,826 MPa	-	218 Ksi / 1502 MPa
Handling								
Mix Ratio Weight (PartA / Part B)		100 : 23	100 : 32	-		100 : 19	100 : 50	100 : 22
Cure Temperature (°F / °C)		77 °F / 25 °C / 150 °F / 66 °C"	77 °F / 25 °C / 180 °F / 82 °C"	77 - 200 °F / 25 - 93 °C"		> 77 - 200°F / > 25 - 93°C	77 - 160 °F / 25 - 71 °C	77 - 200 °F / 25 - 93°C
Cure Time		3 - 5 Days / 1 Hour	5 - 7 Day / 1 Hour	3 - 5 Days / 1 Hour		5 - 7 Days / 1 Hour	24 Hours / 1 Hour	5 Days
Storage Temperature (°F / °C)		77 °F / 25 °C	82 °F / 28 °C	82 °F / 28 °C		77 °F / 25 °C	77 °F / 25 °C	82 °F / 28°C
Pot Life (minutes / lb) / (minutes / kg)		120 Minutes / 100 Gram Mass	75 Minutes / 100 Gram Mass	90 Minutes / 450 Gram Mass		25 Minutes / 200 Gram Mass	30 minutes / 100 Gram Mass	30 Minutes / 450 Gram Mass
Product								
New Product Name		<b>LOCTITE EA 9309NA AERO</b>	<b>LOCTITE EA 9392 AERO</b>	<b>LOCTITE EA 9394S AERO</b>		<b>LOCTITE EA 9320NA AERO</b>	<b>LOCTITE EA 960F AERO</b>	<b>LOCTITE EA 9309.2 AERO</b>
Known As		Hysol® EA 9309NA™	Hysol® EA 9392™	Hysol® EA 9394S™		Hysol® EA 9320NA™	Hysol® EA 960F™	Hysol® EA 9309.2™
Availability								
Packaging		Pint Kit, Quart Kit, Gallon Kit, Clip Pack, Injection Kit	Quart Kit	Injection Kit		Quart Kit, Gallon Kit, Injection Kit	50-Gram Kit, 5-Gallon Kit, Clip Pack, Gallon Kit, Quart Kit	Puttying Cup, Quart Kit
Description								
		<b>LOCTITE EA 9309NA AERO</b> • High Peel Strength • Bonds Many Surfaces	<b>LOCTITE EA 9392 AERO</b> is a paste adhesive, which possesses excellent shear strength at high temperatures. This product exhibits excellent toughness and yields durable bonds over a wide temperature range.	<b>Loctite EA 9394S AERO</b> is a two-part structural paste adhesive, which possesses excellent strength at high temperatures. Its thixotropic nature and excellent high temperature compressive strength also make it ideal for potting, filling and liquid shim applications.		<b>LOCTITE EA 9320NA AERO</b> is a two-component paste adhesive with good peel strength as well as elevated temperature resistance.	<b>LOCTITE 960F AERO</b> is a fairing and smoothing compound for exterior aircraft surfaces. It is a two-component system, which cures rapidly at room temperature. It is color coded to identify when fully mixed.	<b>LOCTITE EA 9309.2 AERO</b> is a two part epoxy sytem bonds metal skins and honeycomb core to yield tough permanently flexible joints that resist humidity, water and most common fluids. Its outstanding feature is high shear and peel strength on aluminum bonds at moderate temperatures.



## We mind the gaps for you with LOCTITE liquid shims

### The way to eliminate small gaps

Whenever gaps and differences between two composite parts occur, shims both in solid and liquid form are used to eliminate them. For gaps less than 3 millimeters or for wide area fit up, liquid shims are employed. They are spread on one side of the rib, squeezed together and bolted. This forces any excess shim material to be squeezed out leaving just the necessary amount of shim to bridge any gaps occurring in the manufacturing process.

### Guaranteeing a perfect result: LOCTITE liquid shims

LOCTITE liquid shims are epoxy-based materials that provide not only high compressive strength, but also a balance between open assembly time and strength. They operate as both, an adhesive and shim, offer good compressive strength across a wide temperature range and allow a long out time to facilitate larger parts.

#### Why choose LOCTITE liquid shims?

- › Good gap filling capabilities
- › Fast cure time
- › Tough – resistance to microcracking
- › Qualified at most commercial aircraft OEMs
- › Optimized to match CTE difference on composite substrates

## LOCTITE liquid shims: Facts at a glance

#### LOCTITE liquid shims key features:

- › Two-part custom filled epoxy-based materials
- › Ambient temperature storage
- › Extremely high compressive strength
- › Ambient & elevated temperature cure

#### Key factors to consider when choosing the right LOCTITE liquid shim

- › Good compression properties
- › Temperature performance
- › Fluid resistance: fuel, water ingress
- › Low slump: low flow on vertical surfaces
- › Adhesion properties: must bond well to substrate

## Liquid Shim

<b>Characteristics</b>	180°F / 82°C Service				
	300°F / 149°C Service				
	350°F / 177°C Service				
	Improved Hot / Wet Properties				
	Toughened				
	Consistency	Thixotropic	Thixotropic	Thixotropic	
	Form	2 Part	2 Part	2 Part	
Peel Strength	Low	High	High		
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	20 lbs / in / 89 N / 25 mm	50 lbs / in / 178 N / 25 mm	60 lbs / in / 265 N / 25 mm	
	TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	3,300 psi / 22.7 MPa	4,650 psi / 32.1 MPa	4,000 psi / 27.6 MPa
		77°F (psi) / 25°C (Mpa)	4,200 psi / 28.9 MPa	5,350 psi / 36.9 MPa	5,000 psi / 34.5 MPa
		180°F (psi) / 82°C (Mpa)	3,000 psi / 20.7 MPa	4,200 psi / 29.0 MPa	3,000 psi / 20.7 MPa
		Elevated Temperature (psi / MPa)	1,200 psi / 8.3 MPa	2,500 psi / 17.2 MPa	950 psi / 6.5 MPa
<b>Bulk Properties</b>	Tg Dry (°F / °C)	172 °F / 78 °C	153 °F / 67 °C	151 °F / 66 °C	
	Tg Wet (°F / °C)	154 °F / 68 °C	-	-	
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	6,675 psi / 46.0 MPa	-	-	
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	615 ksi / 4,237 MPa	-	487.2 ksi / 3360 MPa	
	Elongation @ 77°F / 25°C (% at break)	1,77 %	-	5,00 %	
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	10,000 psi / 68.9 MPa	11,300 psi / 78 MPa	9,878 psi / 68 MPa	
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	-	355 ksi / 2,950 MPa	368 ksi / 2,538 MPa	
<b>Handling</b>	Mix Ratio Weight (Part A / Part B)	100 : 17	100 : 55	100 : 43	
	Cure Temperature (°F / °C)	77 – 200 °F / 25 – 93 °C	≥ 160 – 175 °F / 70 – 80 °C	77 – 180 °F / 25 – 82 °C	
	Cure Time	3 – 5 Days / 1 Hour	240 Minutes	5 – 7 Days / 1 Hour	
	Storage Temperature (°F / °C)	77 °F / 25 °C	40 °F / 4 °C	77 °F / 25 °C	
	Pot Life (minutes / lb) / (minutes / kg)	90 Minutes / 450 Gram Mass	180 Minutes / 500 Gram Mass	50 Minutes / 200 Gram Mass	
<b>Product</b>	New Product Name	LOCTITE EA 9394 AERO	LOCTITE EA 9377 AERO	LOCTITE EA 9360 AERO	
	Known As	Hysol® EA 9394™	Hysol® EA 9377™	Hysol® EA 9360™	
<b>Availability</b>	Packaging	55-Gallon Kit, 5-Gallon Kit, Clip Pack, Dual Cartridge, Gram Kit, Pint Kit, Quart Kit	Barrier Kit, Clip Pack, Quart Kit, Injection Kit, Gram Kit	Quart Kit, Dual Cartridge, Gallon Kit	
	<b>Description</b>	<b>LOCTITE EA 9394 AERO</b> <ul style="list-style-type: none"> <li>• Good Gap Filling Capabilities</li> <li>• Potting Material</li> <li>• Room Temperature Storage</li> <li>• Outstanding Mechanical Properties</li> <li>• Long Pot Life</li> <li>• Low Toxicity</li> </ul>	<b>LOCTITE EA 9377 AERO</b> <p>is a two-component moldable plastic shim with excellent microcrack resistance under thermal cycling and high compressive strength</p>	<b>LOCTITE EA 9360 AERO</b> <ul style="list-style-type: none"> <li>• Available in dual cartridge packaging</li> <li>• High peel strength</li> <li>• Excellent static stress durability</li> <li>• &gt; 225°F (107°C) service</li> <li>• Easy mixing two component system</li> <li>• Room temperature cure</li> <li>• Low Slump</li> </ul>	





Low viscosity, high quality:

## LOCTITE laminate and wet lay-up resins

### For high temperature applications ...

A low viscosity system is needed for high temperature wet lay-up composite construction or repairs. It should allow wet lamination processes as well as out-of-autoclave curing processes to be employed.

### ... and perfect surface preparation: LOCTITE low viscosity wet lay-up.

With more than 50 years experience, Henkel offers the right solution for this challenge: LOCTITE low viscosity wet lay-up solutions. Curing very fast under heat, they provide an optimal adhering surface for subsequent painting and coating.

### Why choose LOCTITE low viscosity wet lay-up products?

- › High-temperature applications
- › Long open life up to eight hours
- › Enhanced occupational safety during employee exposure times

## LOCTITE laminate and wet lay up resins: Facts at a glance

### LOCTITE low viscosity wet lay-up key features:

- › Two-component system
- › Low viscosity
- › Room temperature or elevated cure
- › Ideal for OEM assembly or repair

### Key factors to consider when choosing the right LOCTITE low viscosity wet lay-up solution

- › Fiber volume ratio (55 %)
- › Porosity level (<1 %)
- › Cure temperature
- › Fabric alignment
- › Resin physical-chemical properties (viscosity)
- › Pot life

## Laminate and Wet Lay-up Resins

	300°F/149°C Service			
	Improved Hot / Wet Properties			
	Toughened			
	Consistency	Low Viscosity	Low Viscosity	Low Viscosity
	Form	2 Part	2 Part	2 Part
	Peel Strength	High	Nil	Moderate

<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	60 lbs / in / 267 N / 25 mm	-	25 lbs / in / 111 N / 25 mm	
	<b>TENSILE LAP SHEAR</b>	-67°F (psi) / -55°C (Mpa)	4,200 psi / 28.9 MPa	1,780 psi / 12.3 MPa	3,300 psi / 22.8 MPa
		77°F (psi) / 25°C (Mpa)	4,500 psi / 31.0 MPa	2,300 psi / 15.8 MPa	3,500 psi / 24.1 MPa
		180°F (psi) / 82°C (Mpa)	500 psi / 3.5 Mpa	1,500 psi / 10.3 MPa	3,200 psi / 22.0 MPa
		Elevated Temperature (psi / MPa)	-	1,000 psi / 6.9 MPa	1,250 psi / 8.6 MPa

<b>Bulk Properties</b>	Tg Dry (°F / °C)	120 °F / 49 °C	156 °F / 69 °C	208 °F / 98 °C
	Tg Wet (°F / °C)	-	-	145 °F / 63 °C
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	6,300 psi / 45 MPa	5,800 psi / 40.0 MPa	8,000 psi / 55.2 MPa
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	330 ksi / 2,274 MPa	370 ksi / 2,552 MPa	400 ksi / 2,750 MPa
	Elongation @ 77°F / 25°C (% at break)	8,00 %	2,40 %	3,40 %
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	9,040 psi / 62.3 MPa	12,000 psi / 82.8 MPa	70,000 psi / 482.8 MPa
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	263 ksi / 1,812 MPa	158 ksi / 1,089 MPa	8,000 psi / 55,150 MPa

<b>Handling</b>	Mix Ratio Weight (Part A / Part B)	100 : 25	100 : 58	100 : 30
	Cure Temperature (°F / °C)	77 °F / 25 °C 100 °F / 38 °C 140 °F / 60 °C 200 °F / 93 °C	77 – 200 °F / 25 - 93 °C	77 – 150 °F / 25 – 66 °C
	Cure Time	8 Hours / 75 Minutes / 30 Minutes / 5 Minutes	5 – 7 Days / 1 Hour	3 – 5 Days / 1 Hour
	Storage Temperature (°F / °C)	77 °F / 25 °C	40 °F / 4 °C	77 °F / 25 °C
	Pot Life (minutes / lb) / (minutes / kg)	60 Minutes / 200 Gram Mass	> 30 minutes / 450 Gram Mass	120 Minutes / 100 Gram Mass

<b>Product</b>	New Product Name	<b>LOCTITE EA 9313 AERO</b>	<b>LOCTITE EA 956 AERO</b>	<b>LOCTITE EA 9396 AERO</b>
	Known As	Hysol® EA 9313™	Hysol® EA 956™	Hysol® EA 9396™

<b>Availability</b>	Packaging	Quart Kit	Clip Pack, Gallon Kit, Gram Kit, Pint Kit, Quart Kit	50-Gram Kit, 5-Gallon Kit, Barrier Kit, Clip Pack, Gallon Kit, Gram Kit, Injection Kit, Pint Kit, Quart Kit
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<b>Description</b>	<b>LOCTITE EA 9313 AERO</b> is a low viscosity, two component paste adhesive designed for bonds requiring flexibility. The low viscosity of the mixed system allows it to be injected into pre-assembled parts. The flexibility of the cured adhesive makes it useful for bonding dissimilar substrates. It can also be used as a laminating resin and for potting small assemblies.	<b>LOCTITE EA 956 AERO</b> is a two-component, adhesive, which has excellent elevated temperature strength. Its room temperature cure capability and low viscosity make it ideal for repair applications, including laminating, injection, and coating.	<b>LOCTITE EA 9396 AERO</b> • Low Viscosity • Room Temperature Cure • Room Temperature Storage • High Strength at Low and High Temperatures
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Gives you strength:

## LOCTITE potting and edge compounds

### What potting and edge fill compounds can do for you

Potting and Edge Fill and encapsulation compounds provide mechanical reinforcement to housed assemblies, fill voids, and protect devices from the effects of exposure to chemicals, moisture, mechanical shock and vibration. High-quality potting and edge fill products effectively prevent corrosion and ensure the long-term integrity of your device.

### And why LOCTITE potting and edge fill compounds do it best

LOCTITE offers a broad variety of potting and edge fill and encapsulating compounds to use with various substrates, operating temperatures and other environmental factors. All of them improve the mechanical strength as well as the resistance to vibration, shock and thermal stress.

At the same time, they protect against corrosion, dust and chemicals and provide electrical insulation. Because of their thermal properties they are ideally suited for aerospace temperature requirements.

### Why choose LOCTITE potting and edge Fill compounds?

- › Significantly improved shelf life
- › Easy to apply
- › Improves mechanical strength
- › Provide insulation
- › Enhances resistance to vibration and shock
- › Prevents corrosion from moisture, thermal cycling, dust and chemicals
- › Broad selection of product chemistries allows use with different substrates, operating temperatures and other environmental factors
- › Reduces open time in dispensing, assembling and testing

## LOCTITE potting and edge Fill compounds: Facts at a glance

### LOCTITE potting and edge Fill compounds key features:

- › Suitable packaging configurations for application
- › No sag for vertical applications
- › Co-curable with sandwich assembly
- › Adhesive can be drilled and sanded without damage
- › Dual cure or step cure processing capability
- › Products available in low to medium densities

## Potting and Edge Fill

<b>Characteristics</b>	180°F / 82°C Service	•		•	
	300°F/149°C Service				
	350°F / 177°C Service				
	450°F / 232°C Service		•		
	Cured Density (g / cc)	1.3		0.48	
	Improved Hot / Wet Properties				
	Toughened	•			
	Consistency	Thixotropic	Moderate Viscosity	Syntactic	
	Form	2 Part	2 Part	2 Part	
	Peel Strength	Low	Low	Nil	
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	6 lbs / in / 25 N / 25 mm"	10 lbs / in / 45 N / 25 mm"	–	
	TENSILE LAP SHEAR	-67°F (psi) / -55°C (Mpa)	3,000 psi / 20.7 MPa	3,500 psi / 24.1 MPa	–
		77°F (psi) / 25°C (Mpa)	4,000 psi / 27.6 MPa	5,000 psi / 34.5 MPa	1,300 psi / 9.0 MPa
		180°F (psi) / 82°C (Mpa)	2,900 psi / 20.0 MPa	4,000 psi / 27.5 MPa	–
		Elevated Temperature (psi / MPa)	500 psi / 3.4 MPa	2,500 psi / 17.2 MPa	–
<b>Bulk Properties</b>	Tg Dry (°F / °C)	230 °F / 110 °C	–	248 °F / 120 °C	
	Tg Wet (°F / °C)	190 °F / 88 °C	–	–	
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	7,100 psi / 49.0 MPa	–	–	
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	42 ksi / 2.90 MPa	–	–	
	Elongation @ 77°F / 25°C (% at break)	6.00 %	–	–	
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	9,280 psi / 64.00 MPa	32,000 psi / 220.7 MPa	2,500 psi / 17.2 MPa	
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	284 ksi / 1,960 MPa	–	110 ksi / 758 MPa	
	<b>Handling</b>	Mix Ratio Weight (PartA / Part B)	100 :50	100 :20	100 :34.2
Cure Temperature (°F / °C)		77 – 200 °F / 25 - 93 °C	> 200 °F / 93 °C	77 °F / 25 °C	
Cure Time		5 – 7 Days / 1 Hour	1 Hour	5 – 7 Days	
Storage Temperature (°F / °C)		40 °F / 4 °C	77 °F / 25 °C	82 °F / 28 °C	
Pot Life (minutes / lb) / (minutes / kg)		40 Minutes / 450 Gram Mass	7 Hours / 450 Gram Mass	60 Minutes / 70 Gram Mass	
<b>Product</b>	New Product Name	<b>LOCTITE EA 9321 AERO</b>	<b>LOCTITE EA 9394/C-2 AERO</b>	<b>LOCTITE HC 3056 AERO</b>	
	Known As	Hysol® EA 9321™	Hysol® EA 9394™ / C-2™	SynSkin® HC 3056™	
<b>Availability</b>	Packaging	Clip Pack, Dual Cartridge, Quart Kit	Quart Kit, Injection Kit, Clip Pack	Gallon Kit	
<b>Description</b>	<b>LOCTITE EA 9321 AERO</b> is a two-component thixotropic paste adhesive, which exhibits toughness and retains strength at elevated temperatures. This product cures at room temperature and yields durable bonds over a wide temperature range.	<b>LOCTITE EA 9394/C-2 AERO</b> is an elevated temperature curing, high service temperature structural paste adhesive. It uses a non-aromatic amine curing agent that retains many of the excellent properties offered by aromatic amine cured systems, high temperature service with a long pot life.	<b>LOCTITE HC 3056 AERO</b> is a two-component low-density potting compound. It is self-extinguishing and its thixotropic characteristics make it ideal for use in honeycomb panels for edge close out, insert potting, and smoothing. It is a closed cell structure with minimum moisture penetration. although it is epoxy chemistry, clean up is with hot, soapy water rather than solvents.		

## Potting and Edge Fill

<b>Characteristics</b>	180°F / 82°C Service	•							
	300°F / 149°C Service	•	•	•		•	•		
	350°F / 177°C Service							•	•
	450°F / 232°C Service								
	Cured Density (g / cc)	1.38	1.37				0.60	0.87	0.72
	Improved Hot / Wet Properties		•			•			
	Toughened		•	•		•			
	Consistency	Thixotropic	Thixotropic	Thixotropic		Thixotropic	Syntactic	Thixotropic	Thixotropic
	Form	2 Part	2 Part	2 Part		2 Part	2 Part	1 Part	1 Part
Peel Strength	Nil	Low	Nil		Low	Nil	Nil	Nil	
<b>Mechanical Properties</b>	Bell Peel 77°F (lb / in) / 25°C (N / 25 mm)	–	20 lbs / in / 89 N / 25 mm"	20 lbs / in / 90 N / 25 mm"		15 lbs / in / 67 N / 25 mm"	–	–	–
	TENSILE LAB SHEAR -67°F (psi) / -55°C (Mpa)	3,100 psi / 21.4 MPa	3,300 psi / 22.7 MPa	2,700 psi / 18.6 MPa		2,300 psi / 15.8 MPa	2,000 psi / 13.8 MPa	–	–
	77°F (psi) / 25°C (Mpa)	3,700 psi / 25.5 MPa	4,200 psi / 28.9 MPa	4,910 psi / 33.9 MPa		4,300 psi / 29.7 MPa	2,700 psi / 18.6 MPa	–	2,000 psi / 13.8 MPa
	180°F (psi) / 82°C (Mpa)	2,800 psi / 19.3 MPa	3,000 psi / 20.7 MPa	3,140 psi / 21.7 MPa		3,500 psi / 24.1 MPa	1,500 psi / 10.3 MPa	–	–
	Elevated Temperature (psi / MPa)	1,200 psi / 8.3 MPa	1,200 psi / 8.3 MPa	1,640 psi / 11.3 MPa		1,200 psi / 8.3 MPa	1,400 psi / 9.7 MPa	–	–
<b>Bulk Properties</b>	Tg Dry (°F / °C)	159 °F / 71 °C	172 °F / 78 °C	158 °F / 70 °C		163 °F / 73 °C	147 °F / 64 °C	–	–
	Tg Wet (°F / °C)	235 °F / 113 °C	154 °F / 68 °C	196 °F / 91 °C		246 °F / 119 °C	–	–	–
	Tensile Strength @ 77°F (psi) / 25°C (MPa)	5,800 psi / 40.0 MPa	6,675 psi / 46.0 MPa	–		8,070 psi / 55.6 MPa	3,000 psi / 20.7 MPa	–	–
	Tensile Modulus @ 77°F (ksi) / 25°C (MPa)	550 ksi / 3,792 MPa	615 ksi / 4,237 MPa	–		717 ksi / 4,940 MPa	290 ksi / 2,000 MPa	–	–
	Elongation @ 77°F / 25°C (% at break)	1,20 %	1,77 %	–		2,60 %	2 – 3 %	–	–
	Compressive Strength @ 77°F (psi) / 25°C (MPa)	9,500 psi / 65.5 MPa	10,000 psi / 68.9 MPa	11,329 psi / 78.1 MPa		14,000 psi / 94.5 MPa	6,500 psi / 44.8 MPa	22,800 psi / 157 MPa	12,232 psi / 84 MPa
	Compressive Modulus @ 77°F (ksi) / 25°C (MPa)	367 psi / 2,530 MPa	–	–		429 ksi / 2,956 MPa	–	–	–
<b>Handling</b>	Mix Ratio Weight (Part A / Part B)	100 :33	100 :17	100 :27		100 :17	100 :31	–	–
	Cure Temperature (°F / °C)	77 – 200 °F / 25 – 93 °C	77 – 200 °F / 25 – 93 °C	77 °F / 25 °C		77 – 150 °F / 25 – 66 °C	77 – 200 °F / 25 – 93 °C	250 °F / 121 °C / 350 °F / 177 °C"	250 °F / 121 °C / 350 °F / 177 °C"
	Cure Time	5 – 7 Days / 1 Hour	3 – 5 Days / 1 Hour	24 Hours		5 Days / 1 Hour	5 – 7 Days / 1 Hour	90 – 100 Minutes / 60 – 70 Minutes	90 – 100 Minutes / 60 – 70 Minutes
	Storage Temperature (°F / °C)	40 °F / 4 °C	77 °F / 25 °C	77 °F / 25 °C		77 °F / 25 °C	40 °F / 4 °C	0 °F / -18 °C	0 °F / -18 °C
	Pot Life (minutes / lb) / (minutes / kg)	40 – 50 minutes / 450 Gram Mass	90 Minutes / 450 Gram Mass	20 – 30 Minutes / 100 Gram Mass		95 – 100 Minutes / 450 Gram Mass	120 Minutes / 100 Gram Mass	> 8 Hours	> 8 Hours
<b>Product</b>	New Product Name	<b>LOCTITE EA 934NA AERO</b>	<b>LOCTITE EA 9394 AERO</b>	<b>LOCTITE EA 9394.2 AERO</b>		<b>LOCTITE EA 9395 AERO</b>	<b>LOCTITE EA 9396.6MD AERO</b>	<b>LOCTITE EA 9820 AERO</b>	<b>LOCTITE EA 9825 AERO</b>
	Known As	Hysol® EA 934NA™	Hysol® EA 9394™	Hysol® EA 9394.2™		Hysol® EA 9395™	Hysol® EA 9396.6MD™	Hysol® EA 9820™	Hysol® EA 9825™
<b>Availability</b>	Packaging	Barrier Kit, Clip Pack, Gallon Kit, Gram Kit, Pint Kit, Quart Kit	55-Gallon Kit, 5-Gallon Kit, Clip Pack, Dual Cartridge, Gram Kit, Pint Kit, Quart Kit	Dual Cartridge, Pint Kit, Quart Kit, Clip Pack, Gallon Kit, 5-Gallon Kit		Quart Kit, Injection Kit, Clip Pack, 5-Gallon Kit, Gallon Kit"	Gallon Kit, Barrier Kit	Cartridge Gallon Kit	Dual Cartridge
<b>Description</b>		<b>LOCTITE EA 934NA AERO</b> is a two-component thixotropic paste adhesive, which cures at room temperature and possesses superior strength to 300 °F / 149 °C and higher. Its thixotropic nature and good compressive strength make it ideal for potting, filling, and fairing, as well as for shim applications.	<b>LOCTITE EA 9394 AERO</b> • Good Gap Filling Capabilities • Potting Material • Room Temperature Storage • Outstanding Mechanical Properties • Long Pot Life • Low Toxicity	<b>LOCTITE EA 9394.2 AERO</b> is a fast curing two-part structural paste adhesive, which cures at room temperature. Its thixotropic nature makes it ideal for potting, filling, and liquid shim applications.		<b>LOCTITE EA 9395 AERO</b> • Non-Metallic Filler • Cures at Ambient Temperature • Thixotropic • Excellent Mechanical Properties • Good Compressive Strength	<b>LOCTITE EA 9396.6MD AERO</b> is an easy mixing, two-part syntactic epoxy adhesive with good compressive strength at higher temperatures.	<b>LOCTITE EA 9820 AERO</b> is an intermediate density, one-component epoxy syntactic for use on honeycomb composite parts requiring high compressive strength at temperatures up to 350 °F (177 °C). It may also be used for fastener or attachment potting and panel edge reinforcing.	<b>LOCTITE EA 9825 AERO</b> is a low-density, one-component epoxy syntactic for use on honeycomb composite parts requiring high compressive strength at temperatures up to 350 °F (177 °C). It may also be used for fastener or attachment potting and panel edge reinforcing.

Aerospace industry has many standards:  
**LOCTITE FREKOTE is the one for release materials**

**Choosing the right release material is not as easy as you might think ...**

Aircraft manufacturers' demands on professional release materials are high: They require a wide range of mold releases with different characteristics to meet all needs. They want to be sure to apply a sustainable solution. And last but not least, they only accept materials that comply with the most rigorous requirements – their own ones.

**... unless you discover LOCTITE FREKOTE.**

Henkel's LOCTITE FREKOTE release agents, sealers and cleaners are based on over 50 years of technical experience and are the most trusted for consistent release of composite parts from tools. These wax- and silicone-free release agents polymerize to create a low surface energy film which is durable, chemically resistant and thermally stable. A minimal transfer to molded components, minimized fouling, easy application and the highest number of releases possible per application are guaranteed.

**Why choose LOCTITE FREKOTE mold release materials?**

- › Semi-permanent mold release bonds to mold surface for consistent release
- › Higher productivity and profitability through reduced downtime
- › Low reject rates
- › Available with no volatile organic compounds (VOCs) and CFCs for improved sustainability
- › Dispensing equipment available

**LOCTITE FREKOTE mold release materials:  
 All facts at a glance**

**Key factors to consider when choosing the right LOCTITE mold release**

- › Water-based vs. solvent-based
- › Slip / release characteristics
- › Service temperature
- › Transfer characteristics

**LOCTITE FREKOTE mold releases can be used with following materials:**

- › Thermoset epoxies, phenolics and BMIs
- › Natural & synthetic rubbers
- › Silicones
- › Urethanes
- › Thermoplastic polymers
- › Thermoset prepregs
- › Thermoplastic prepregs
- › Polyester resins
- › Vinyl ester resins
- › MRO & repair

**LOCTITE FREKOTE mold releases can be used in all composite manufacturing processes:**

- › Hand lay-up
- › Automated fiber placement & tape laying
- › Autoclave molding
- › Vacuum bag only molding
- › Resin transfer molding
- › Vacuum infusion processes
- › Resin film infusion
- › Filament winding
- › Injection molding
- › Compression molding
- › Pultrusion
- › Rotational molding
- › Metallic, ceramic and composite tooling
- › Automated spray application

With support from its authorized aerospace distribution network, Henkel delivers LOCTITE FREKOTE mold release agents for aerospace customers throughout the globe.



## Mold Release

<b>Applications</b>	Mold Cleaning	•	•											
	Mold Sealing			•										
	Composites Molding						•	•	•	•	•	•	•	•
	Compression Molding						•	•	•	•	•	•	•	•
	Casting						•	•	•	•	•	•	•	•
	Vacuum Bagging						•	•	•	•	•	•	•	•
	High Release								•	•	•	•	•	•
	Filament Winding										•			
<b>Mechanical Properties</b>	Appearance	Clear liquid	Beige-Pasty liquid	Clear liquid		Clear Liquid	Clear Liquid	Clear Liquid	Clear Liquid	Clear Liquid	Clear Liquid	Milky White Emulsion		
	Finish	-	-	Gloss		Matte	Satin	Gloss	Gloss	Gloss	Gloss	Matte		
	Density at 77 °F / 25°C (g / ml)	0.821 to 0.854 LMS	0.97 to 0.99 LMS	0.745 to 0.775 LMS		0.76 to 0.782 LMS	0.715 to 0.725 LMS	0.755 to 0.764 LMS	0.715 to 0.725 LMS	0.755 to 0.764 LMS	0.715 to 0.725 LMS	0.98 to 1.02 LMS		
<b>Handling</b>	Cure Temperature (°F / °C)	Ambient	Ambient	Ambient	210 – 300 °F 100 – 150 °C	Ambient	210 – 300 °F 100 – 150 °C	Ambient	210 – 300 °F 100 – 150 °C	Ambient	210 – 300 °F 100 – 150 °C	Ambient	Ambient	210 – 300 °F 100 – 150 °C
	Cure Time	-	-	24 Hours	60 Minutes	3 Hours	15 Minutes	30 Minutes	5 Minutes	10 minutes	5 Minutes	5 – 10 Minutes	3 Hours	12 Minutes
	Storage Temperature (°F / °C)	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	46 – 70 °F 8 – 21 °C	37 – 68 °F 3 – 20 °C	37 – 68 °F 3 – 20 °C
	Storage Time	24 Months	24 Months	12 Months		12 Months	12 Months	12 Months	12 Months	12 Months	12 Months	12 Months	9 Months	9 Months
<b>Product</b>	New Product Name	<b>LOCTITE FREKOTE PMC AERO</b>	<b>LOCTITE FREKOTE PMC 915WB AERO</b>	<b>LOCTITE FREKOTE B-15 AERO</b>		<b>LOCTITE FREKOTE 44-NC AERO</b>	<b>LOCTITE FREKOTE 55-NC AERO</b>	<b>LOCTITE FREKOTE 700-NC AERO</b>	<b>LOCTITE FREKOTE 770-NC AERO</b>	<b>LOCTITE FREKOTE C-800 AERO</b>				
	Known As	Frekote® PMC™	Frekote® 915WB™	Frekote® B-15™		Frekote® 44-NC™	Frekote® 55-NC™	Frekote® 700-NC™	Frekote® 770-NC™	Frekote® Aqualine® C-800™				
<b>Availability</b>	Packaging	Can, Pail	Can	Can, Pail		Can, Pail, Drum, Aerosol	Can, Pail, Drum, Aerosol	Can, Pail, Drum, Aerosol	Can, Pail, Drum, Aerosol	Can, Pail				
<b>Description</b>	<b>LOCTITE FREKOTE PMC AERO</b> <ul style="list-style-type: none"> <li>• Easy to use</li> <li>• Eliminates contaminants</li> <li>• Enhances release effectiveness</li> </ul>	<b>LOCTITE FREKOTE PMC 915WB AERO</b> <ul style="list-style-type: none"> <li>• Water based polisher</li> <li>• Polishing liquid</li> <li>• Removes cured films</li> </ul>	<b>LOCTITE FREKOTE B-15 AERO</b> <ul style="list-style-type: none"> <li>• Seals mold porosity, scratches, or imperfections</li> <li>• No contaminating transfer</li> <li>• High thermal stability</li> </ul>		<b>LOCTITE FREKOTE 44-NC AERO</b> <ul style="list-style-type: none"> <li>• Better mold utilisation</li> <li>• Non contaminating transfer</li> <li>• No mold build up</li> <li>• Significantly lower mold maintenance costs</li> </ul>	<b>LOCTITE FREKOTE 55-NC AERO</b> <ul style="list-style-type: none"> <li>• Fast drying</li> <li>• Non contaminating transfer</li> <li>• High thermal stability</li> <li>• Non-CFC</li> <li>• No mold build-up</li> </ul>	<b>LOCTITE FREKOTE 700-NC AERO</b> <ul style="list-style-type: none"> <li>• No chlorinated solvents</li> <li>• High gloss finish</li> <li>• High slip</li> <li>• No contaminating transfer</li> <li>• No mold build-up</li> </ul>	<b>LOCTITE FREKOTE 770-NC AERO</b> <ul style="list-style-type: none"> <li>• No contaminating transfer</li> <li>• High gloss finish</li> <li>• High slip</li> <li>• No mold build-up</li> <li>• Low odor</li> </ul>	<b>LOCTITE FREKOTE C-800 AERO</b> <ul style="list-style-type: none"> <li>• High slip</li> <li>• Easy application</li> <li>• Multiple releases</li> <li>• Low transfer</li> <li>• No corrosion / oxidation of the mold surface</li> <li>• Minimal mold build-up</li> </ul>					





**LOCTITE®**  
**BONDERITE®**  
**TECHNOMELT®**  
**TEROSON®**  
**AQUENCE®**

AT5003015 V3

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