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Product Description Sheet

Hysol® Product 9430

Industrial Products, October 2001

Description

Loctite® Hysol® 9430 is a modified epoxy adhesive that attains structural properties after room temperature cure. This two-part adhesive is formulated to give very high peel strength coupled with excellent shear strength. Hysol 9430 bonds are resistant to water, salt spray and many common industrial fluids. The tough, flexible nature of this adhesive makes it useful for bonding dissimilar substrates and for assemblies requiring bondline thickness up to one-tenth inch.

Features

- High peel and high shear strength
- Room temperature cure
- Bonds variety of substrates
- Long pot life
- Excellent low temperature properties

Peel Strength ASTM D 3167	Etched Aluminum, pli
3 Days @ 77°F	60

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Application

Mixing Combine Part A and Part B in the correct ratio and mix thoroughly. **THIS IS IMPORTANT!** Heat buildup during or after mixing is normal. Do not mix quantities greater than ten pounds (10 lb.), as excessive heat buildup can occur. Mixing smaller quantities will minimize the heat buildup.

Applying Bonding surfaces should be clean and dry. Hysol 9430 can be applied with a spatula, brush or dispensing machine. Once the adhesive is dispensed, the bonded parts should be held in contact until the part has developed handling strength. Fixturing can be removed at this point. Since full bond strength has not yet been attained, load application should be small at this time.

Curing Hysol 9430 will cure to ultimate properties in 5 days at room temperature. Curing temperatures up to 180°F can be used to reduce cure time. For example, 1 hour at 180°F will give complete cure.

Cleanup It is important to remove excess adhesive from the work area and application equipment before it hardens. Denatured alcohol and many common solvents are suitable for removing uncured adhesive. Consult with your supplier's information pertaining to the safe and proper use of solvents.

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 250 grams mins	--	--	50
Color	Cream	Clear	Off White
Viscosity, cP	200,000 to 400,000	40	12,000
Specific Gravity	1.15	1.00	1.12
Mix Ratio			
By weight	100	23	--
By volume	3.78	1	--
Density, lbs/Gal	9.64	8.35	9.3

Typical Properties	Typical Value
Tensile Strength, psi, ASTM D 638	5300
Modulus, psi, ASTM D 638	380,000
Elongation, %, ASTM D 638	6.0
Hardness, Shore D	75

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
5 Days @ 77°F	-67	5000
	77	4700
	140	1700
	180	750

Shear Strength, ASTM D 1002 Cured 5 Days @ 77°F		
	Test Temp °F	Typical Value, psi
Degreased Aluminum	77	3500
FRP	77	1400
Bonderized Steel	77	2400
Mineral Filled PET	77	850
30 Day Salt Spray	77	4000
30 Day @ 120 °F/100% RH	77	3700

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PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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Note

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