



HBF EY3010

Two part, thixotropic epoxy compounds designed for use with Shur-Lok fasteners to achieve high strength and dependable bonded inserts in honeycomb panels. The handling properties of these products are similar. However, EY3010 is designed for lowest weight. EY3010 is available within NASA limits for low Volatile content required for space application. EY3010 A/B is qualified to LAC 30-8036A.

Technology / Base	Epoxy
Type of Product	Structural Adhesive
Components	Two Component
Curing	Room Temperature (secondary thermal cure)
Appearance / Color	Light Blue
Consistency	Thixotropic Liquid

Features and Benefits

- Excellent Sag Resistance Even Through Powder Coating Processes
- Extremely Light Weight
- Self Extinguishing
- Excellent Bonding to Metals, Composites, Coatings, and Most Plastics
- Excellent Chemical Resistance
- Excellent Thermal Performance
- Meets NASA limits for Low Volatile Content Required for Space Applications
- Room Temperature Cure

General Instructions

Surfaces must be clean, dry and free from grease, oil, paint, wax and weak oxide films and other surface contaminants. Chemical etching, sanding or grit blasting often gives the best results. Bring both components to room temperature prior to mixing. Just prior to using, blend the two components, Part A and Part B, in the ratio above. Mechanical mixing is preferable, but should be carried out at slow speeds (<300 rpm), taking as little air as possible into the adhesive batch. Spread a thin layer of the mixed adhesive on one or both of the parts to be bonded. Once the adhesive is applied, no open time is necessary. The surfaces can be assembled immediately. Parts should be assembled while the adhesive is still wet to the touch before it sets. The individual parts, the ambient temperature and the adhesive itself will dictate the open time permitted.

Specifications and Approvals

LAC 30-8036 A, COMS-0006 REV.B, CASA I+D-N-200 Z-18.167/1 REV.3

Handling and Clean-Up

See SDS for handling and clean-up information.

Storage

Product should be stored in a cool dry place out of direct sunlight. The shelf life is from date of manufacture. Shelf life is based on the products being stored properly at temperatures between 12°C and 25°C. Exposure to temperatures above 25°C will reduce the shelf life. This product should not be frozen.

Use Note



Technical Data

Rheology	Value	Condition/Method
Viscosity - Part A Viscosity - Part B Viscosity - Mixed	Soft Paste	
Density Specific Gravity	0.58	
Uncured Material Characteristics Volume Mix Ratio Weight Mix Ratio Pot Life Gel Time Handling Time Full Cure @ 23°C Full Cure @ 66°C Shelf Life	100 to 8 20 to 25 min 7 days 3 hours 12 months unopened	at 25°C
Cured Mechanical Properties Hardness Tensile Strength Elongation at Break Overlap Shear Strength Aluminum, Acid Etched Operating Temperature	68 Shore D 11.0 MPa (1600 psi) -55°C to 150°C (-67°F to 300°F)	ASTM D2240 ASTM D1002, 25°C 50% RH

Safety and Disposal

See SDS for safety and disposal information.

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