



HBF EY2536

EY2536 is a very lightweight, easily spread epoxy compound for edge filling sandwich panels for aircraft interiors. It wipes in cleanly and can be sanded smooth after overnight cure at room temperature. EY2536 is self-extinguishing when tested per FAR 25.853, Appendix F.

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

Features and Benefits

- Excellent Sag Resistance
- Extremely Light Weight
- Excellent Chemical Resistance
- Self Extinguishing
- Excellent Bonding to Metals, Composites, Coatings, and Most Plastics
- Excellent Chemical Resistance
- Excellent Thermal Performance
- 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

DPM 5357-1, DPS 1.901 REV. M TYPE 1

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	2,750,000 cPs	at 25°C
Viscosity - Part B	1,657,000 cPs	at 25°C
Viscosity - Mixed		
Density		
Specific Gravity	0.51	
Uncured Material Characteristics		
Volume Mix Ratio	100 to 61	
Weight Mix Ratio	100 to 50	
Pot Life		100 gram
Gel Time	45 to 65 min	at 25°C 100 gram
Handling Time		
Full Cure @ 23°C	24 hours	
Full Cure @ 66°C	2 hours	
Shelf Life	12 months unopened	
Cured Mechanical Properties		
Hardness	62 Shore D	ASTM D2240
Tensile Strength		
Elongation at Break		
Overlap Shear Strength		
Aluminum, Acid Etched		
Operating Temperature		

Safety and Disposal

See SDS for safety and disposal information.

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