

## 3M™ Scotch-Weld™ EC-9323-2 B/A

### Two Part Structural Adhesive

#### Product Description

3M™ Scotch-Weld™ Structural Epoxy Adhesive EC-9323-2 B/A is a thixotropic, sag-resistant, two component epoxy paste adhesive which cures at room temperature or with mild heat to form a tough, impact resistant structural bond. It has an excellent adhesion to a wide variety of substrates such as metals, glass, ceramics and plastics, incl. GFRP and CFRP. Once cured it provides very high shear and peel strength over a wide temperature range, with excellent resistance to harsh environments and chemicals commonly encountered in aerospace applications. Typical applications are aircraft interior panel bonding, ditch and pot, insert, or bracket bonding. The product is available in a white and a black version.

#### Key Features

- Thixotropic, non-sag, full room temperature processable,
- Available in duo-pack cartridge for easy and best processing.
- Toughened system providing very high shear and peel strength
- Excellent environmental resistance

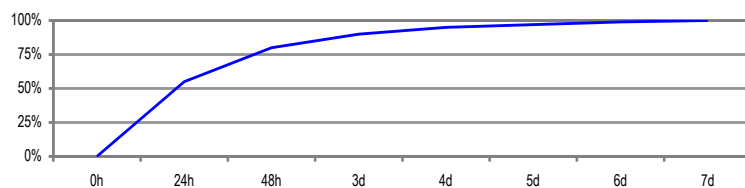


#### Product Characterization

The following technical information and data should be considered representative or typical only and should not be used for specification purpose.

General Properties		Part B	Part A
Colour	SW EC- 9323-2 B/A white SW EC- 9323-2 B/A black	White Black	Off-white Off-white
Base		Modified epoxy	Modified amine
Consistency		Thixotropic paste	Thixotropic paste
Density		1.04 g / cm <sup>3</sup>	1.03 g / cm <sup>3</sup>
Solids		100 %	100 %
Viscosity (a)		250 Pas	75 Pas
Mix ratio by weight (by volume)		100 : 50 wt. (100 : 50 vol.)	
Work life (b) and open time at 23 ± 2 °C		> 120 minutes	
Handling strength(c)		4 hours	

Strength build-up at 23 ± 2 °C



Full cure cycle 7 days at room temperature

Packaging Cans, cartridges and pails

(a) Brookfield RVF Spindle 7, 2 rpm

(b) 50 g of mixed adhesive

(c) Time to reach 1 MPa Shear Strength

## Product Performance

The following data show typical values obtained with Scotch-Weld™ EC-9323-2 B/A on unprimed, sulfochromic etched, 2024 T3 aluminium. The samples have been cured for 7 days at room temperature, if not stated otherwise. To control the bond line thickness, approximately 1 wt. % of glass beads, 90 – 150 µm diameter were added to the adhesive.

Mechanical Properties		Test Temperature	Cured for 7 days at 23 °C	Cured for 2 hours at 65 °C
<b>Overlap Shear Strength</b> EN 2243-1		-55 °C	24 MPa	26 MPa
		23 °C	29 MPa	30 MPa
		80 °C	10 MPa	12 MPa
		120 °C	3 MPa	3 MPa
		150 °C	2 MPa	-
<b>Overlap Shear Strength</b> EN 2243-1	Stainless steel	23 °C	-	26 MPa
	CFRP, GFRP epoxy matrix resin	23 °C	-	30 MPa <sup>(d)</sup>
	PMMA	23 °C	-	3 MPa <sup>(d)</sup>
	ABS	23 °C	-	4 MPa <sup>(d)</sup>
<b>Floating Roller Peel Strength</b> EN 2243-2		23 °C	219 N / 25 mm	159 N / 25 mm
		80 °C	140 N / 25 mm	-
<b>Impact Resistance AFNOR NF 76-115</b>		23 °C	22,6 kJ / m <sup>2</sup>	25,3 kJ / m <sup>2</sup>

<sup>(d)</sup> Substrate Failure

## Environmental Ageing

The following data show typical values obtained with Scotch-Weld EC-9323-2 B/A after 750 hours exposure to different media and environments to determine the aging resistance. The samples have been cured for 15 days at room temperature.

Mechanical Properties	Environment	Test Temperature	Results
<b>Overlap Shear Strength</b> EN 2243-1	Demineralized water at 23 ± 2 °C	23 °C	27 MPa
	Gasoline super at 23 ± 2 °C	23 °C	28 MPa
	Engine oil (20W40) 23 ± 2 °C	23 °C	30 MPa
	Hydraulic fluid skydrol 500B at 23 ± 2 °C	23 °C	29 MPa
	JP4 fluid at 23 ± 2 °C	23 °C	29 MPa
	5 % Salt spray at 23 ± 2 °C	23 °C	27 MPa
	Hot / Wet 50 °C, ≥ 95% R.H.	23 °C	23 MPa
	Dry heat at 120 ± 2 °C	23 °C	26 MPa

# Handling, Application, Storage

## Precautionary Information

Refer to product label and Material Safety Data Sheet (MSDS) for health and safety information before using this product. For MSDS visit our website [www.3M.com/msds](http://www.3M.com/msds).

## Instructions for use

While this information is provided as general application guideline based upon typical conditions, it is recognized that no two applications are identical due to, among other things, differing assemblies, methods of heat and pressure application, production equipment and other limitations. It is therefore suggested that experiments be run, within the actual constraints imposed to determine optimum conditions for your specific application and to determine suitability of product for particular intended use.

Process step	Instruction
Surface preparation	<p>The strength and durability of a bonded joint are dependent on proper treatment of the surface to be bonded. An acclimated, thoroughly cleaned, dry, grease-free surface is essential for maximum performance. Cleaning methods which will produce a break free water film on metal surfaces are generally satisfactory.</p> <p>At the very least, joint surfaces should be cleaned with a good proprietary degreasing agent and mechanically abraded, e.g. with 3M Scotch-Brite™ 7447. Abrading should be followed by a second degreasing treatment, e.g. with 3M 08984 Adhesive Cleaner.</p> <p>Optimum processing temperature for substrates and adhesive is around room temperature of 23 °C.</p>
Application	<p>This product consists of two parts. Combine Part B and Part A in a separate container just prior to application in the proportions specified <b>Note:</b> Mix ratio deviations above +/- 5 % can have significant influence on material performance. Mix both components thoroughly until a uniform colour is obtained. <b>Important:</b> Be careful when mixing larger quantities, because exothermic reaction may occur. Dual cartridge applications provide maximum accuracy and easy handling. <b>Note:</b> When using a new static mixer, purge the first ml's until a uniform colour is obtained. Apply adhesive to parts to be bonded before the work life expires. <b>Note:</b> Work life depends to some extent on mixed quantity and the shape of the container. In order to obtain optimum mechanical performance, the joint components should be assembled and clamped as soon as the adhesive has been applied and before end of the open time. A fixation of the joint and an even contact pressure throughout the joint area during cure will ensure optimum performance. Maximum shear strength is obtained with 0.10 – 0.20 mm bond line thickness. Close the containers after use to protect the material against humidity. When using a duo-pack cartridge, keep the static mixer as cap.</p>
Curing	<p>Once mixed, Scotch-Weld™ EC-9323-2 B/A will gel in 3 hours, build up handling strength in 4 hours and fully cure within 7 days at room temperature. <b>Note:</b> Lower temperature will slow down the reaction times. Curing time can be accelerated by mild heat. Following times and temperatures will result in a full cure:</p> <ul style="list-style-type: none"><li>▪ 7 days at 23 ± 2 °C</li><li>▪ 2 hours at 65 ± 2 °C</li></ul> <p><b>Note:</b> The curing temperature may have influence on the final product performance.</p>
Cleaning	<p>Excess uncured adhesive can be cleaned with ketone type solvents. After cure the adhesive can be removed mechanically. <b>Note:</b> When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and instructions for use.</p>
Storage and Handling	<p>Store the product at room temperature. Shelf life is minimum 12 months from date of shipment in the original unopened containers. The specific expiry date is mentioned on the product label.</p>

**Important notice:** All statements, technical information and recommendations in this data sheet are based on tests 3M believes to be reliable, but the accuracy or completeness of those tests is not guaranteed. All technical data and information should be considered typical or representative only and should not be used for specification purposes. Given the variety of factors that affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product before use to determine the suitability of the 3M product for the intended use and method of application. All questions of liability relating to the 3M product are governed by the terms of the sale subject to, where applicable, the prevailing law.



Automotive and Aerospace Solutions Division  
European Aerospace Laboratory

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