Product Description Sheet

LOCTITE® EA 9432NA

Known as

Hysol® Adhesive 9432NA

September 2024

Description

Loctite® EA 9432NA is an aluminum filled, thixotropic, one component epoxy adhesive. Hysol 9432NA is formulated to provide excellent tensile shear strength over a wide range of temperatures and a high degree of impact resistance. This adhesive can bond oily and other poorly prepared surfaces and can be used to bond a wide variety of substrates. Loctite® EA 9432NA is designed to cure at moderate temperatures but has a long shelf life at room temperature. This adhesive can be easily pumped and dispensed onto parts without sagging due to its high thixotropy.

Features

One Component – No Mixing Required
Thixotropic Non Sag Paste
Excellent High Temperature Performance
Excellent Chemical Resistance
Tolerant to Poorly Prepared Surfaces

Typical Properties

Color	Gray
Viscosity, cP	150,000-300,000
Specific Gravity @ 77°F	1.38
Density lb per Gallon	11.5
Slump @ 300°F(⅜" Diameter bead on vertical)	0.3" Max

Application

Applying: *Please read and understand the Safety Data Sheet before using this product.* Allow material to come to room temperature before use. Bonding surfaces should be clean, dry and properly prepared. Apply adhesive to one or both substrates to be bonded. The parts must be held in contact until the adhesive is cured. It is important to remove uncured adhesive before curing. *See "Clean Up" below for removal of uncured adhesive.* Once cured, Loctite® EA 9432NA is very difficult to remove. Large quantities of uncured adhesive may exotherm during the cure cycle. Avoid quantities larger than 10 grams in mass. Larger quantities in a bond line are safe to cure.

Cure: Loctite® EA 9432NA can be cured for 60 minutes at 250°F. Faster cures can be achieved by using higher temperatures, for example, 30 minutes at 300°F. Cure temperatures above 350°F and below 250°F are not recommended. Cure time on your part will depend upon factors such as part geometry, materials to be bonded, bond line thickness and efficiency of the oven. Cure schedule should be confirmed with actual production parts and equipment. A clamping pressure of 15 psi is recommended to ensure that good contact in maintained during the cure cycle.

Clean Up: Uncured adhesive can be removed from the work area and application equipment by using many common solvents and citrus cleaners. Consult with your supplier's information pertaining to the safe and proper use of solvents.

GENERAL INFORMATION

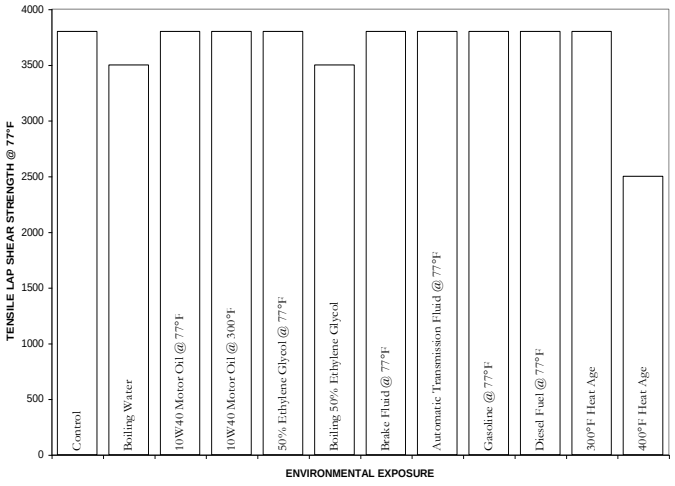
This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	**Test Temp °F**	**Typical Value**
30 mins @ 300ºF	-67	3500
	77	3800
	250	3000
	300	2400
	350	400
	400	400

Shear Strength, psi, ASTM D 1002 Cured 30 Mins @ 300ºf		
	Test Temp °F	**Typical Value**
Degreased Aluminum	77	3500
CR Steel Abraded	77	3000
CR Steel Degreased	77	2850
CR Steel Oily	77	2600
Owens Corning Fiberglas SMC	77	400
Budd Company Fiberglas SMC	77	380
Fiberglas Vinyl Ester Laminate	77	1000

Typical Properties	Typical Value
Tensile Strength, psi, ASTM D 638	7350
Modulus, psi, ASTM D 638	680,000
Elongation, %, ASTM D 638	1.2
Hardness, Shore D	90

Environmental Resistance: Reported as tensile lap shear strength tested at 77°F per ASTM D 1002 after a 30 day soak in the specified fluid. Tensile lap shear on 16 gauge sandblasted cold rolled steel with 5 mil bondline cured for 30 minutes at 300°F.



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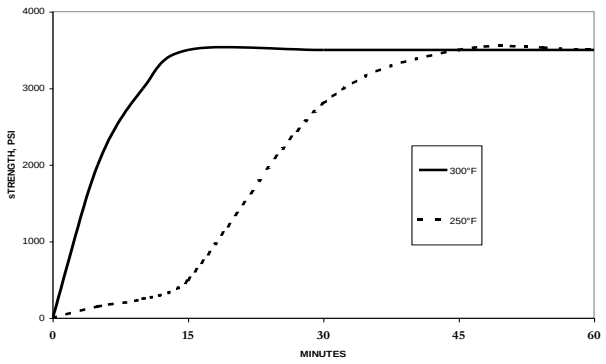
October 2015

STRENGTH DEVELPOMENT AT VARIOUS TEMPERATURES



Storage

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 2° to 8°C (36° to 46°F) unless otherwise labeled. Optimal storage conditions of this product is achieved with refrigeration: Refrigerated packages shall be allowed to return to room temperature prior to use. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact your local Technical Service Center.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

Note

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