



# NEICO AVIATION INC.

2244 Airport Way, Redmond, OR 97756 (541) 923-2244 Fax (541)923-2255

Service Bulletin 004-91

Subject: Mixing & shelf life of Hysol 9339 structural adhesive

Date: 3-1-91

1. First, always check your structural adhesive to verify that it is in fact, Hysol 9339. This is recommended since, from time to time as deemed useful, Neico may elect to change systems.
2. Hysol 9339 is mixed in the ratio of 100 parts A (thick light colored) to 44.5 parts B (thinner dark colored). This ratio is by WEIGHT not volume.
3. The preferred mixing method is:
  - a.) Using an accurate ounce scale, place the cup on the scale and zero it out.
  - b.) Spoon in an amount of Part A that you estimate would represent about 2/3rds of the total amount of adhesive desired.
  - c.) Weigh this amount and multiply that weight by 1.445 and note the figure.
  - d.) Add Part B to the cup until the newly arrived at figure is reached.
  - e.) Mix thoroughly for at least two to three minutes or until completely mixed. Be sure to scrape the sides, bottom corners, etc. during the mixing process.
3. Note that the shelf life of the resin is set from date of shipment (DOS) to Neico Aviation. That date is stamped on the label when Neico receives the shipment.

Shelf life is listed as one (1) year from (DOS) date of shipment.

Shelf life is NOT determined from "date of Mfg." Which could be much earlier. This is because Dexter Hysol Corp. re-qualifies their pre-made adhesive batches as they process them for shipment and thus guarantee the shelf life from that time.

Sample ratios & weights: (in ounces)

<b>Part A</b>	<b>Part B</b>	<b>Total Weight</b>
1 +	.4	= 1.445
2 +	.89	= 2.89
3 +	1.335	= 4.335
4 +	1.78	= 5.78
5 +	2.225	= 7.225
6 +	2.67	= 8.67
7 +	3.115	= 10.115
8 +	3.56	= 11.56