

L-9115

Aircraft Interior Ambient Cure Fire Smoke Toxicity Adhesive

L&L Products has developed an epoxy-based, FST adhesive for aircraft interiors designed to bond various substrates (metal, thermoplastics and composites) that are common to the aerospace industry.

L-9115 is a two component toughened adhesive which cures at room temperature and provides high performance bonding. It is designed for interior applications and meets the latest FAA fire regulations (vertical burn, smoke density and toxicity).

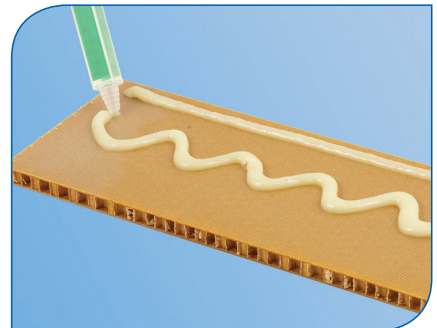
L-9115 can be supplied in twin-barrel cartridges, pails or drums.

Key Product Attributes

- FST regulation compliant - FAR 25.853, ABD0031
- High strength bonding

Typical Application Areas

- Panel assembly
- Insert bonding
- Bracket bonding



Technical Data

The following information and data should be considered typical and should not be used for specification.

TYPICAL PROPERTIES		
	Property	L-9115
Physical Properties	Appearance	Off white viscous liquid
	Working Time (10 gram sample)	10-20 minutes
	Shore D Hardness (24 hour at 23°C) (73°F)	70
	Mixed Density	1.30 g/cc
	Mix Ratio	01:01
Mechanical Properties	Tensile strength on etched Al cured 24 hours at 27°C (81°F)	15MPa (2175 psi)
	Tensile strength on etched Al cured 2 hours at 65°C (149°F)	24MPa (3500 psi)
	Tensile strength on BR-127 Primed Al cured 24 hours at 27°C (81°F)	16MPa (2300 psi)
	Tensile strength on BR-127 Primed Al cured 2 hours at 65°C (149°F)	25MPa (3600 psi)
Fire Properties	FAA Vertical Burn 12 s FAR 25.853 App. F Part I (a) (ii)	PASS
	FAA Vertical Burn 60 s FAR 25.853 App. F Part I (a) (i)	PASS
	FAA Smoke Density FAR 25.853 (d) Appendix F, Part V	PASS
	Toxicity (Flaming) ABD0031, AITM 3-005, Issue 2	PASS

Bonding Process

- Parts should be mated and in final position before the expiration of the working time and should remain in position unstressed and undisturbed until the end of the fixture time has passed.
- Note that working and fixture time are affected by temperature. Elevated temperatures accelerate cure and shorten working and fixture times, whereas lower temperatures slow reaction speed down and lengthen these times. The application temperature for the adhesive and parts should be between 15°C and 30°C (60°F and 85°F).

Shelf Life & Storage Conditions

- Best results within 1 year if stored between -10°C and 23°C (14°F and 73°F) in original packaging. Long term exposure to elevated temperature can cause the material to lose performance characteristics. Keep away from direct sunlight and all sources of heat and ignition.

Surface Preparation

- The substrate must be clean, dry, and free of dust. Clean surfaces using a general purpose industrial organic solvent. It may be necessary to use an additional surface preparation product (e.g. surface sanding, acid etching for aluminum or primer for thermoplastics) for optimal adhesive behavior.

Health & Safety

- Consult product specific Safety Data Sheet.

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