

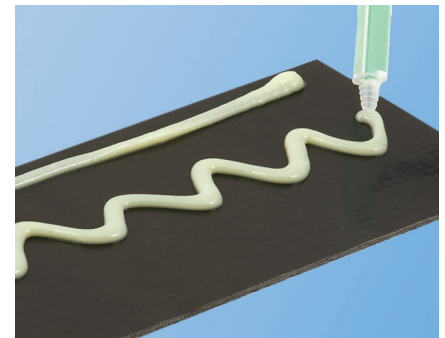
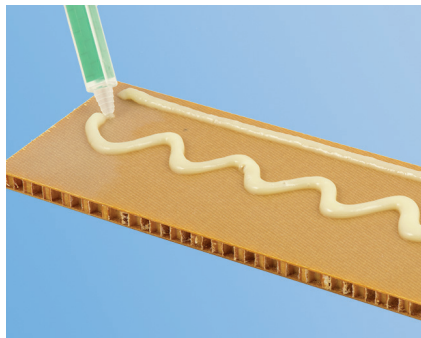
L-9150

FST Room Temperature Cure Adhesive Technology

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

L-9150 is a two component adhesive which cures at room temperature or can be accelerated with heat and provides high performance bonding. It is designed for interior applications and meets the latest FAA vertical burn regulations.

L-9150 has a convenient one to one mix ratio and can be supplied in twin-barrel cartridges, pails, or drums. The user-friendly packaging doesn't require weighing or hand mixing.



Key Product Attributes

- Vertical burn regulation compliant - FAR 25.853
- Extended work life due to delayed amine blush
- Non-slumping
- High strength bonding
 - Dissimilar substrate
 - Composite
 - Metal
 - Glass

Typical Application Areas

- Panel assembly
- Bracket bonding
- Aircraft interiors

Technical Data

TYPICAL PROPERTIES			
		L-9150	Test Methods
Physical Properties	Color	Off white	
	Work Life	35-50 min (10 g)	
	Mix Ratio	1:1	
	Cured Density	1.24 g/cc	
Mechanical Properties	Tensile strength on BR-127 Primed Al cured 24 hours at 23°C	>16 MPa (2300 psi)	
	Tensile strength on etched 2024 T3 Al cured 24 hours at 23°C	>16 MPa (2300 psi)	
	60 sec Vertical Burn 6.35 mm	PASS	FAR 25.853 App F Part 1 (a)(i)
Fire Properties	Toxicity (Flaming)	PASS	ABD0031, AITM 3-0005, Issue 2
	FAA Smoke Density	PASS	FAR 25.853 App F Part V (d)

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 and 85°F).

Shelf Life & Storage Conditions

- Shelf Life: 2 years from date of manufacture when stored at or below 0°C (32°F).
- 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 substrates 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.
- All of our products are developed with REACH compliance.