HYSOL EA9845SF

Composite Surfacing Film

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Description

HYSOL EA9845SF is a 250°F/121°C or 350°F/177°C curing epoxy-based composite surfacing film designed to improve the surface quality of honeycomb stiffened composite parts. The product is manufactured with a non-woven fabric for support. It is offered in a nominal weight of 0.020 psf (100 g/sq m).

Features

Good Tack
Co-curable
Provides High Quality Paintable Surface
Minimizes Core Crush and Porosity
Maximum Leveling Properties
Resistant to Microcracking
Resistant to UV effects
Compatible with Lightning Strike Screens and Foils

Uncured Properties / Suggested Acceptance Tests for certification

Color[1]	Blue
Available Weights	0.020 lb/ft² (100 g/m²)
	0.030 lb/ft² (150 g/m²)
Gel time @ 250°F/121°C, minutes	30
Gel time @ 350°F/177°C, minutes	2
Flow (%)	2
Volatiles, % - max[2]	1

[1]Color - Visual examination and comparison to ISCC-NBS Centroid Color Charts.

[2]Volatiles - Volatile content by oven drying @ 250°F/121°C for 60 minutes.

Handling

This product is supplied in roll form and is ready to use as received. The film should be removed from cold storage and allowed to warm to room temperature prior to opening sealed bag. The indicator on the desiccant should be blue. The fabric side of the film should be positioned and co-cured on the prepreg side of the part. This will allow easy repositioning of prepreg if necessary.

Henkel QC Acceptance Testing

This data sheet provides users with typical properties obtained from this adhesive. These values are not meant to be used to develop aerospace QC acceptance testing. Users interested in establishing values and tests for routine QC acceptance should request our internal specification (HYSOL) which provides detail test methods and values used to certify this adhesive.

Application

Storage - HYSOL EA9845SF should be stored @ 40°F/4°C or below for maximum storage life. Warranty life @ 10°F/-12°C or below is 12 months. Store only in sealed desiccated polyethylene bag provided. Allow adequate time for the container to warm to room temperature before opening for use.

Open Assembly Time - This surfacing film may be used within the following schedule after removing from above recommended cold storage:

@ 77°F/25°C at least 45 days.

Lay-up - Application of the surfacing film should be with the resin side facing the tool. Tools pre-treated with Frekote® Sealer B-15 and Frekote 700 NC Release Agent are recommended.

Curing - This surfacing film may be cured at either 250°F/121°C for 2 hours or 350°F/177°C for 1.5 hours with 45 psi/0.31MPa pressure (1°F to 10°F/0.5°C to 5°C per minute heat up rate).

Surface Preparation for Painting - Light sanding (180 grit) followed by solvent wipe to remove release chemicals and some imperfections. 28C1 Static Conditioner[1] or other suitable pinhole filler may be applied to fill minor surface imperfections.

Cleanup - It is important to remove excess adhesive from the work area and application equipment before it hardens. Denatured alcohol and many common industrial solvents are suitable for removing uncured adhesive. Consult your supplier's information pertaining to the safe and proper use of solvents.

[1]Static Conditioner available from Akzo Nobel Aerospace Coatings, East Water Street, Waukegan, IL, USA. Tel: (847) 623-4200, Fax: (847) 625-3332.

Handling Precautions

Do not handle or use until the Material Safety Data Sheet has been read and understood.
For industrial use only.

General:

As with most epoxy based systems, use this product with adequate ventilation. Do not get in eyes or on skin. Avoid breathing the vapors. Wash thoroughly with soap and water after handling. Empty containers retain product residue and vapors, so obey all precautions when handling empty containers.
ONE PART

CAUTION! This material may cause eye and skin irritation or allergic dermatitis. It contains epoxy resins

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