



Hysol® PL 795SF

Epoxy Film Adhesive

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Description

Hysol® PL 795SF is a modified epoxy film specifically formulated to improve the surface appearance on composite honeycomb structures. Hysol® PL 795SF may be cured at 250°F (121 °C) or 350°F (177 °C).

Features

- Dual cure capabilities 250°F (121 °C) or 350°F (177 °C) eliminates the need for multiple surfacing films based on processing temperatures
- Designed to reduce surface imperfections including pinholes and core mark-off on composite sandwich panels. Results in improved surface appearance, less labor-intensive finishing operations, and weight minimization by reducing/eliminating repetitive applications of pinhole filler.
- Industry accepted; provides high quality surface versus other films typically used in surfacing applications
- Non-metallic filled version of Hysol® PL 795
- Excellent out time - over 100 days @ 77°F (25 °C)
- Outstanding tack and handling characteristics: good building tack, yet repositionable on itself or pre-pregs
- Excellent hot-wet durability
- Minimizes core crush phenomenon
- Sandable and machine-able
- Minimal weight addition to composite structure

Typical Technical Data	Hysol® PL 795SF
Type:	Modified epoxy supported film
Scrim:	Non-woven polyester mat (other scrims available upon request)
Weight:	.03 ± .005 lbs/square foot (146 ± 24 g/SM)
Color:	Cream
Width:	Up to 48" wide (1.2m)
Volatiles:	<1.5% Max
Out Time:	100 + days @ 77°F (25 °C)
Shelf Life:	1 year @ 0°F (-18 °C)
Gel Time @ 250°F (121 °C):	10 - 25 minutes
Gel Time @ 350°F (177 °C):	1 - 3 minutes
% Flow @ 250°F (121 °C):	40 - 70
% Flow @ 350°F (177 °C):	40 - 70

Typical technical data and performance properties given for reference only. Not for specification purposes.

Application Method

Remove Hysol® PL 795SF from freezer storage. Allow Hysol® PL 795SF surfacing film to reach room temperature before opening poly bag to prevent moisture contamination. Bonding surface should be clean, dry and free of contamination.

Remove poly liner and apply this side of surfacing film to the treated tool surface. Remove remaining liner and continue lay-up of pre-preg on to the surfacing film in your normal manner and cure appropriately.

Curing

60 Minutes @ 350°F(177°C) and 25-100 psi (.17 - .69 MPa).

90 Minutes @ 250°F(121°C) and 25-100 psi (.17 - .69 MPa)

Clean-up

Uncured surfacing film may be removed effectively with ketone solvents in well-ventilated areas. Avoid contaminating uncured parts. Consult solvent container label/ MSDS for proper safety and handling procedures.

Storage

Hysol® PL 795SF has a shelf life of over 1 year at 0°F (-18 °C).

Hysol® PL 795SF has an out time at 77°F (25 °C) of over 100 days.

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.

Hysol® is a registered trademark of Henkel Corporation.

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Users should review the Materials Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and label are available upon request.

