EA 9685-1 Epoxy Fillet

**DESCRIPTION**

EA9685-1 Epoxy fillet is a profile of semi-solid resin designed to be used in self-stiffened composite panels manufacturing. Its function is to fill the cavity between the panel and the stiffener.

EA9685-1 is a 180°C cure epoxy resin. When curing, due to its rheology, the resin fills the cavity without excess flow or air trap.

Example of configuration:

![EA 9685-1 Epoxy Fillet](image)

- EA 9685-1 Epoxy Fillet is pre-shaped with an equilateral triangle section.
- EA 9685-1 Epoxy Fillet is pre-shaped with an isosceles right-angled triangle section.

**BENEFITS**

- EA 9685-1 Epoxy Fillet spares the use of rolled resin film or UD tape. It enables savings on work time and assures good reproducibility of structures.
- EA 9685-1 Epoxy Fillet is co-curable with most 180°C cure prepreg systems.
- Several shapes are available.
- The product is qualified by Airbus.

**PACKAGING**

The length of a fillet is 1 meter; it is supplied on a PVC support. The colour of the support varies according to the reference.

EA 9685-1 Epoxy Fillet is available in sets of 35 profiles of 1m.

**HANDLING**

Before use: the set should be removed from the freezer and stored at 20-25°C in its original packaging until warming to room temperature.

**CURING**

The standard cure cycle is 1 hours at 180°C.

All values are nominal.

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**Important notice**

All statements, technical information and recommendations offered are only for consideration and evaluation. Whilst they are believed to be accurate they are not guaranteed and are provided without warranty of any kind. No undertaking is given that the goods/products supplied are fit for any particular purpose and the buyer/user should rely upon its own tests to establish suitability of the goods/products for its particular purpose. The buyer/user shall assume all risks and liabilities in connection therewith.

PRF Composite Materials
3 Upton Road, Poole, Dorset BH17 7AA, England
Tel: +44 (0)1202 680022 Fax: +44 (0)1202 680077
www.prfcomposites.com
CHARACTERISTICS

Available shapes:

<table>
<thead>
<tr>
<th>Pre-shaped section</th>
<th>Equilateral triangle</th>
<th>Isosceles right-angled triangle</th>
</tr>
</thead>
<tbody>
<tr>
<td>Indicative dimensions</td>
<td>5 mm</td>
<td>6.4 mm</td>
</tr>
<tr>
<td></td>
<td>4.5 mm</td>
<td>7.5 mm</td>
</tr>
<tr>
<td>Linear mass</td>
<td>15.5 ± 3 g/m</td>
<td>12.5 ± 2 g/m</td>
</tr>
<tr>
<td>AirBus Specification</td>
<td>ASNA 5052</td>
<td>IPS 10-17-002-01</td>
</tr>
<tr>
<td>Support colour</td>
<td>White</td>
<td>Yellow</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Blue</td>
</tr>
</tbody>
</table>

SHELF LIFE

Product shelf life from date of manufacturing is 2 years at -18°C and 3 weeks at ambient temperature (≤ 25°C).

HANDLING PRECAUTIONS

Usual precautions necessary when handling synthetic resins should be observed.

Material Safety Data Sheet is available on request.

In case of several fillets laid up in the same cavity, the exothermic risk when curing has to be considered.

All values are nominal.

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