

# Product Data

## Aerospace Adhesives



## Film Adhesive

### EA 9674 STRUCTIL



#### DESCRIPTION

EA 9674 is an epoxy/bismaleimide film adhesive designed for high temperature bonding applications. It is specially recommended for metal/metal or composite/metal bonding and for co-curing of sandwich structures.

#### FEATURES

- Outstanding mechanical properties over a wide range of temperature (-55°C to 210°C)
- Can be reticulate on acoustic panel
- Storage life: 1 year at or below -18°C + 2 weeks at room temperature ( $\leq 25^{\circ}\text{C}$ )
- Available in 50m long rolls, 500mm wide.

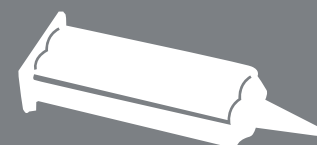
#### AVAILABLE FORMS

	<b>EA 9674.06 UNS</b>
Weight	300g/m <sup>2</sup>
Carrier	-
Colour	Orange

#### INSTRUCTIONS FOR USE

- Refer to the Material Safety Data Sheet before handling.
- To avoid any moisture, allow the adhesive to warm at room temperature before opening the waterproof polyethylene bag.
- Bonding surfaces should be clean, dry and properly prepared.
- Remove protective liners before bonding (release paper and polyethylene film).
- Typical cure cycles:  
1h at 180°C under pressure + 6h at 230°C without pressure.  
Heat up rate: 1 to 4°C/min  
Pressure: 1.5 to 3.5 bar

PRF Composite Materials  
3 Upton Road, Poole, Dorset BH17 7AA, England  
• t: +44 (0) 1202 680022 • f: +44 (0) 1202 680077  
• e: orders@prfcomposites.com  
www.prfcomposites.com



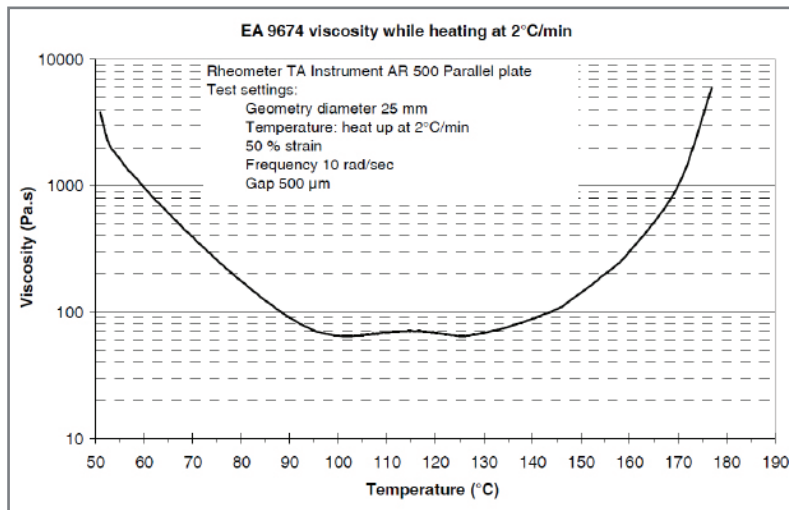
# Product Data

## Aerospace Adhesives



## Film Adhesive

### EA 9674 STRUCTIL



### MECHANICAL PROPERTIES

TEST	TEST TEMPERATURE (°C)	EA 9674.06 UNS
Simple Lap shear strength <sup>(1)</sup> (MPa)	23	31.4
	180	30.5
Honeycomb climbing drum peel torque <sup>(2)</sup> (mN/m)	23	23.9
Flatwise tension strength <sup>(3)</sup> (MPa)	23	7.7

Cure 1h at 140°C + 3h at 190°C under 2.5 bar + post cure: 8h at 230°C without pressure  
 Heat up / cool down rate: 1.5°C/min

<sup>(1)</sup> According to EN 2243-1, on aluminium 2024T3 clad treated with sulfo-chromic acid etch

<sup>(2)</sup> According to EN 2243-3, on aluminium 2024T3 clad treated with sulfo-chromic acid etch, honeycomb core aluminium PAA 5052 N 6.0 ¼, 16mm high, unslotted

<sup>(3)</sup> According to EN 2243-4, on aluminium 2024T3 clad treated with sulfo-chromic acid etch, honeycomb core aluminium PAA 5052 N 6.0 ¼, 16mm high, unslotted

#### All values are nominal.

#### 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.

EA 9674 STRUCTIL ed. 1.2 Jul 2015

Plastic Reinforcement  
 Fabrics Ltd



PRF Composite Materials  
 3 Upton Road, Poole, Dorset BH17 7AA, England  
 • t: +44 (0) 1202 680022 • f: +44 (0) 1202 680077  
 • e: orders@prfcomposites.com  
 www.prfcomposites.com

