

Product Data

Aerospace Adhesives



Core Splice Adhesive

EA 9833.1 STRUCTIL



DESCRIPTION

EA 9833.1 50 MIL is a 180°C cure modified bismaleimide foaming core splice adhesive.

FEATURES

- High Service Temperature
- Expansion: 100% to 150%
- Storage life: 1 year minimum at or below -18°C + 3 weeks at room temperature ($\leq 25^{\circ}\text{C}$)

AVAILABLE FORMS

Form	Sheet of 305 x 610 mm ²
Weight	1655 g/m ² (± 200)
Thickness	1.27mm
Colour	Green
Package	Box of 3.72 m ² (20 sheet)

INSTRUCTIONS FOR USE

- Refer to the Material Safety Data Sheet before handling.
- To avoid any moisture, allow the product to warm at room temperature before opening the waterproof polyethylene bag.
- Bonding surfaces should be clean, dry and properly prepared.
- Remove protective release papers before bonding.
- Typical cure cycles: 1h at 177°C, heat up rate: 0.5 to 2.5°C/min
Post cure: 2h to 6h at 204°C to 246°C for optimum properties.

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



Core Splice Adhesive

EA 9833.1 STRUCTIL

MECHANICAL PROPERTIES		
TEST	TEST TEMPERATURE (°C/°F)	EA 9833.1 50 MIL Typical result (MPa)
Tube shear strength ⁽¹⁾	-55	14.5
	23	12.5
	150	10.5
	210	10.0
	23 after WA ⁽³⁾	14.5
	150 after WA ⁽³⁾	11.0
	210 after WA ⁽³⁾	6.0
TEST	CONDITIONING	EA 9833.1 50 MIL Tg onset storage modulus (°C)
Glass transition temperature by DMA ⁽²⁾	Initial	293
	WA ⁽³⁾	280

⁽¹⁾ According to PR EN 2667-2, on aluminium 5052 treated with sulfo-chromic acid etch, cure⁽⁴⁾

⁽²⁾ According to PR EN 6032, cure⁽⁴⁾

⁽³⁾ Wet Ageing: 1000 hours at 70°C and 85% relative humidity

⁽⁴⁾ Cure cycle: 2.5°C/min from ambient to 177°C + 1 hour at 177°C + 2.2°C/min from 177°C to 225°C + 2 hours at 225°C (post cure) - 1.7°C/min from 225°C to ambient

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 9833.1 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

