

# Product Data

## Aerospace Adhesives



# Foaming Core Splice Adhesive

## ST1150 STRUCTIL



### DESCRIPTION

ST 1150 is a foaming core splice adhesive especially useful in bonding sections and edge filling of honeycomb. It is ideal for use in thick sections of honeycomb, low exotherm is required.

### FEATURES

- Cure from 120°C to 180°C
- Low volatiles content:  $\leq 1\%$  (after cure 1h at 178°C - 3°C/min)
- Length/width of sections: 610 mm x 305 mm
- Shelf life: 1 year at temperature  $\leq -18^\circ\text{C}$  + 15 days at room temperature ( $\leq 25^\circ\text{C}$ )

### VERSIONS AVAILABLE

	ST 1150 50 mil
Weight	1500 $\pm$ 100 g/m <sup>2</sup>
Thickness	1.27mm
Film Colour	Blue

### INSTRUCTIONS FOR USE

- Refer to the Material Safety Data Sheet before handling.
- Bring the film adhesive to room temperature before opening its polyethylene airtight packaging to prevent water condensation.
- Bonding surfaces should be clean, dry and properly prepared.
- Remove protective films before bonding (silicone-coated papers).
- Cure cycles examples: 1h at 120°C or 1h at 175°C, temperature ramp: 2 to 4°C/min.

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



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BOND STRENGTH PERFORMANCE AFTER CURE			
TEST	TEST TEMPERATURE (°C)	CURING 1h 120°C (3°C/min)	CURING 1h 175°C (3°C/min)
Expansion <sup>(1)</sup> (%)		120	170
Flow on vertical wall <sup>(2)</sup> (mm)			0.2
Tube shear strength <sup>(3)</sup> (MPa)	-55	10	10
	23	8.0	8.5
	80	7.5	8.0
	23 after WA <sup>(4)</sup>	7.5	8.0

<sup>(1)</sup> According to EN 2667-3

<sup>(2)</sup> According to EN 2667-4

<sup>(3)</sup> According to EN 2267-2, on aluminium 5052 glad treated with sulfo-chromic acid etch

<sup>(4)</sup> Wet ageing: 70°C, 85% relative humidity, saturation

### 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.

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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

