

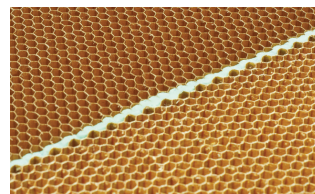
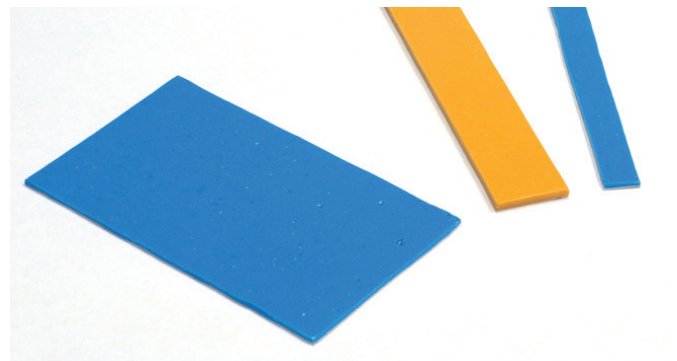
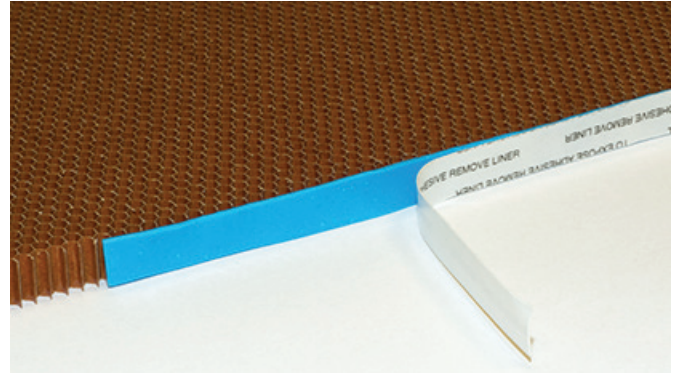
L-9003

FST Foaming Adhesive Technology

L&L Products' foaming adhesives have been developed for a range of honeycomb core finishing operations. In addition to core splicing they can be readily used for edge close out and radius enhancement. Different formulations are available to provide full compatibility with the processing methods (autoclave, oven and press) and the cure cycles used in the manufacture of aircraft interiors.

Depending on the cure schedule chosen, L-9003 will expand up to 450%.

L&L's foaming adhesives are available in both sheet form and as extruded beads. The sheet material can be supplied in thicknesses from 1 to 10 mm (0.05 in. – 0.4 in.). The extruded material is available in round or square cross sections in order to more accurately meet any specific geometry parameters. Their tacky nature means that no additional adhesive is required to pre-bond to the honeycomb.



Key Product Attributes

- FST regulations compliant - FAR 25,853, ABD0031
- Lightweight
- Smooth curing, reduced post processing machining
- Thermo-foaming materials
- Multiple final densities available
- Compatible with a broad range of honeycombs, phenolic and epoxy prepregs
- Pressure sensitive adhesive

Typical Application Areas

- Core splicing
- Edge close out
- Local edge reinforcement
- Radius enhancement
- Void filling

Technical Data

TYPICAL PROPERTIES				
		Cure Cycle	L-9003	Test Method
Physical Properties	Color	—	Blue	
	Uncured Density	—	1.2 g/cm ³	
		—	77 lbs/ft ³	
Mechanical Properties	Expansion	120°C - 175°C (250°F - 350°F)	up to 450%	
	Compressive Strength (RT)	20 min@120°C	4.8 MPa	ASTM D695
		20 min@250°F	695 psi	
	Compressive Modulus (RT)	20 min@120°C	0.25 GPa	ASTM D695
		20 min@250°F	36.3 Ksi	
	Tube Shear (RT)	60 min@125°C	7 MPa	DIN EN2667-2
60 min@257°F		1,015 psi		
Fire Properties	Vertical Burn 60 s	60 min@125°C	Pass	FAR 25.853 App F Part 1 (a)(i)
		60 min@257°F	Pass	
	Smoke Density	60 min@125°C	Pass	FAR 25.853 App F part V (b)
		60 min@257°F	Pass	
	Smoke Toxicity	60 min@125°C	Pass	AITM 3.0005
		60 min@257°F	Pass	
Qualifications	—	—	CDM212-00	-

Optimal Curing Cycles

- Autoclave: 140°C (280° F) for 60 min with 3°C / min ramp up.
- Crush Core: 160°C (320° F) for 15 min.
- Other curing cycles: please contact us (expansion rate can vary depending curing cycle).

Shelf Life & Storage Conditions

- Shelf Life: 2 years from date of manufacture when stored at or below -6°C (21°F).
- Handle with care at low temperature as the material can be brittle.
- Before use, let the material reach room temperature in its sealed packaging to avoid moisture uptake.
- Best handling around room temperature.

Health & Safety

- Consult product specific Safety Data Sheet.
- All of our products are developed with REACH compliance.

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