

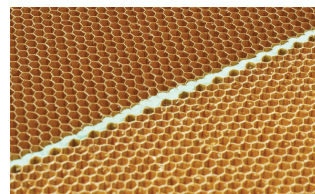
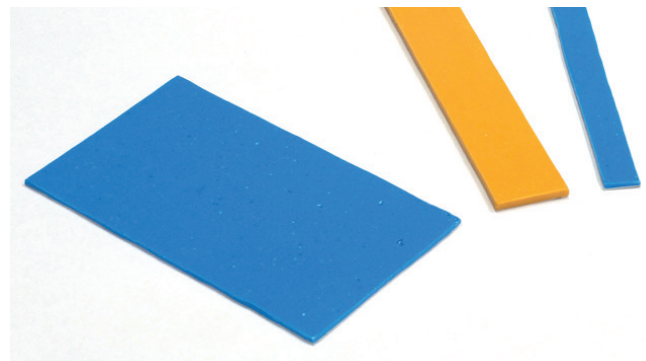
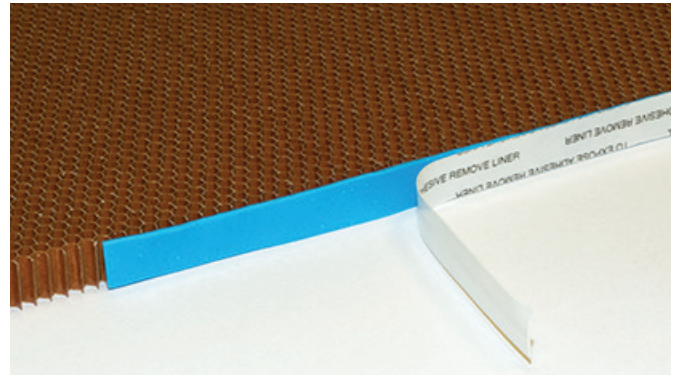
L-9009

FST Foaming Adhesive Technology

L-9009 FST (Fire, Smoke and Toxicity compliant) foaming adhesive has been developed for a range of honeycomb core finishing operations. In addition to core splicing it can be readily used for edge close out and radius enhancement.

Depending on the cure schedule chosen, L-9009 will expand up to 120%.

It can be supplied in various material shapes. The standard format is in sheets of 560mm x 300mm x 1.27mm but it can also be cut into strips.



Key Product Attributes

- Airbus qualified material (AIMS 10-02-004 and DAN 1188)
- FST regulations compliant - FAR 25,853, ABD0031
- Lightweight
- Smooth curing, reduced post process 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

Technical Data

The following information and data should be considered typical and should not be used for specification.

TYPICAL PROPERTIES				
		Curing Cycle	L-9009	Test Method
Physical Properties	Color	-	Grey/Tan	-
	Uncured Density	-	1.25 g/cc	-
	Final Density	Autoclave at 125°C [257°F] *	0.90 g/cc [56 lbs/ft ³]	-
	Final Density	12 min at 160°C [320°F] **	0.56 g/cc [36 lbs/ft ³]	77 lbs/ft ³
	Slump	Autoclave at 125°C [257°F]	0.5 mm	DIN EN 2667-4
	Volatiles	12 min at 160°C [320°F]	<1.5%	DIN EN 2558
	Expansion	Autoclave at 125°C [257°F]	70%	DIN EN 2667-3
	Expansion	12 min at 160°C [320°F]	120%	DIN EN 2667-3
Mechanical Properties	Compressive Strength at 23°C [75°F]	Autoclave at 125°C	19 MPa [2,750 psi]	ISO 604
	Compressive Modulus at 23°C [75°F]	Autoclave at 125°C	0.63 GPa [91.4 ksi]	ISO 604
	Tube Shear at 23°C [75°F]	Autoclave at 125°C	9 MPa [1,305 psi]	DIN EN2667-2
	Tube Shear at 85°C [185°F]	Autoclave at 125°C	8 MPa [1,160 psi]	DIN EN2667-2
Fire Properties	Vertical Burn 60 s (6.35mm) [1/4 in]	Autoclave at 125°C	<75 mm [3 in]	FAR 25.853 (a) App. F Part I §(b)(1)(2)(3)(4)
	Smoke Density (6.35mm) [1/4 in]	Autoclave at 125°C	< 200 DS	FAR 25.853 (d) App. F Part V
	Smoke Toxicity (6.35mm) [1/4 in]	Autoclave at 125°C	Compliant	

Optimal Curing Cycle

- * Autoclave: 125°C [257°F] for 60 min with 3°C / min ramp up
- ** Hot in / hot out: 12 min at 160°C [320°F]
- Autoclave from 121°C [250°F] up to 177°C [350°F] from 60 to 120 min with 3°C / min ramp up are also possible
- For other curing cycle, please contact L&L's technical support

Shelf Life & Storage Conditions

- Shelf Life: 2 years from date of manufacture when stored at or below -18°C (0°F)
- Shelf life at room temperature: 10 days
- 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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