

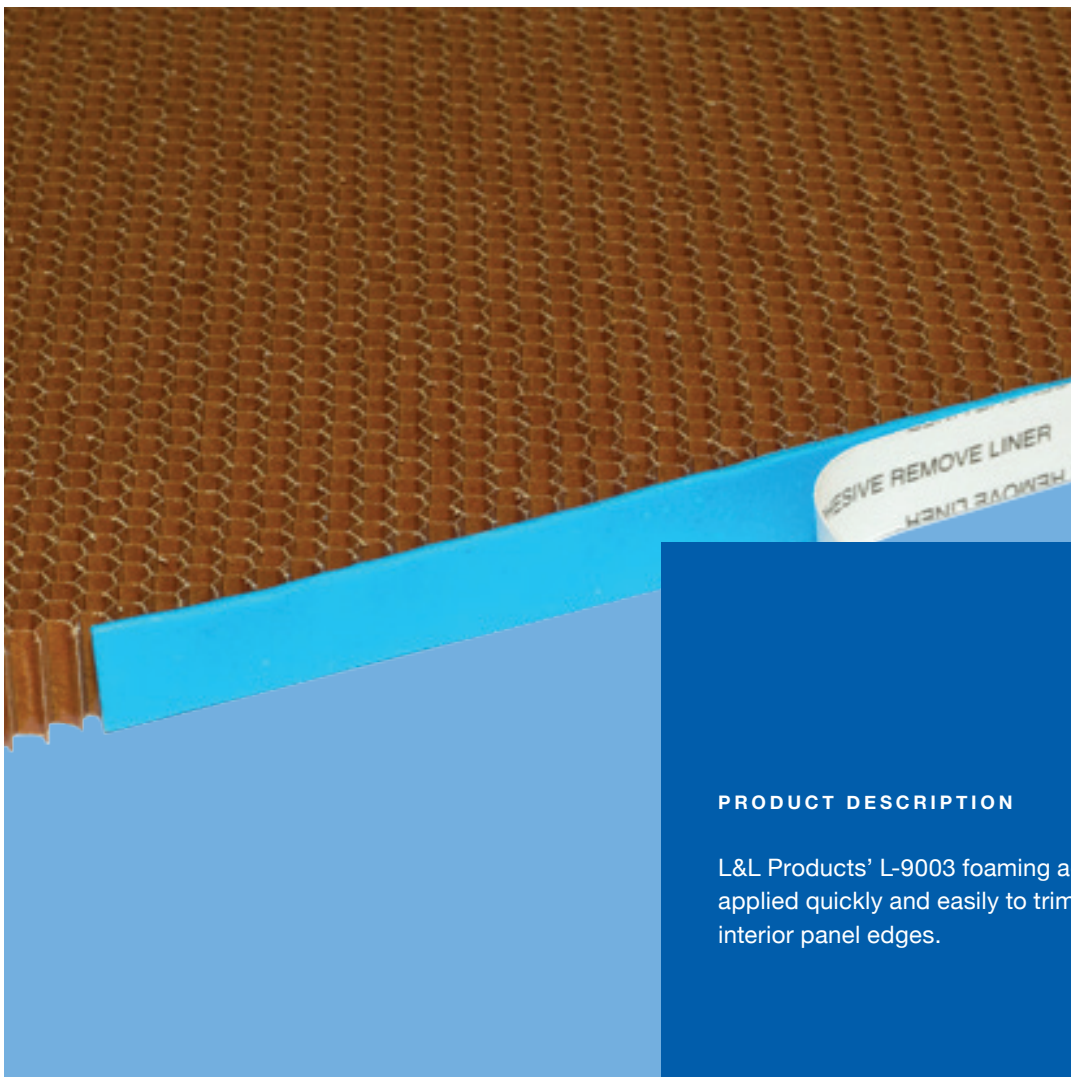


SOLUTION
L&L Bond

VERSION
January 2022

L-9003

FST Foaming Adhesive Technology.



PRODUCT DESCRIPTION

L&L Products' L-9003 foaming adhesive can be applied quickly and easily to trim honeycomb interior panel edges.

Product Description

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 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

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

	Cure Cycle	L-9003	Test Method
Physical Properties	Color	Blue	
	Uncured Density	1.2 g/cm ³ / 77 lbs/ft ³	
	Expansion	up to 450%	
Mechanical Properties	Compressive Strength (RT)	20 min @120°C / 250°F	4.8 MPa / 695 psi
	Compressive Modulus (RT)	20 min @120°C / 250°F	0.25 GPa / 36.3 Ksi
	Tube Shear (RT)	60 min @125°C / 257°F	7 MPa / 1,015 psi
Fire Properties	Vertical Burn 60 s		Pass
	Smoke Density		Pass
	Smoke Toxicity		Pass
	Qualifications		CDM212-00

Optimal Curing Cycles

Press Cure: 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 0°C (32°F) or below.

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.