L&L Products

TECHNICAL DATA SHEET

SOLUTION
L&L Bond

VERSION
January 2022

L-9115
FST Room Temperature Cure Adhesive.

FST

PRODUCT DESCRIPTION

L&L Bond L-9115 is an FST (Fire, Smoke, and Toxicity) compliant interior adhesive and it has been developed to bond various substrates that are common to the aerospace industry.

This two-component, epoxy adhesive cures at room temperature and provides high performance bonding.

Designed for interior applications, it meets the latest FAA fire regulations (vertical burn, smoke density and toxicity).

It can be supplied in twin-barrel cartridges, pails or drums.

Key Product Attributes

- FST regulation compliant - FAR 25.853, ABD0031
- High mechanical bonding
- Can be used in a wide range of temperatures
- Capable of multi-material bonding

Typical Application Areas

- Panel assembly
- Insert bonding
- Bracket bonding

Technical Data

		L-9115	Test Method
Physical Properties	Color	Off white viscous liquid	
	Working Time	10-20 min (10 g)	
	Shore D Hardness (24 hour at 23°C) (73°F)	70	
	Cured Density	1.30 g/cc	
	Mix Ratio	1:1	
Mechanical Properties	Lap Shear Strength (cured 24 hour at 27°C) (81°F)	15 MPa [2175 psi]	
	Lap Shear Strength (cured 2 hours at 65°C) (149°F)	24 MPa [2300 psi]	
Fire Properties	Vertical Burn 60 s	Pass	FAR 25.853(a), App. F part I(a)(1)(i)
	Smoke Density	Pass	FAR 25.853(d) App. F part V(b)
	Smoke Toxicity	Pass	ABD0031

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Shelf Life & Storage Conditions

Shelf Life: 2 years from date of manufacture when stored at or below 0°C (32°F).

Long term exposure to elevated temperature can cause the material to lose performance characteristics. Keep away from direct sunlight and all sources of heat and ignition.

Best results within 1 year if stored between -10°C and 23°C (14°F and 73°F) in original packaging

Surface Preparation

The substrate must be clean, dry, and free of dust. Clean surfaces using a general purpose industrial organic solvent. It may be necessary to use an additional surface preparation product (e.g. surface sanding, acid etching for aluminum or primer for thermoplastics) for optimal adhesive behavior.

Bonding Process

Parts should be fixtured and in final position before the expiration of the gel time and should remain in position unstressed and undisturbed until the end of the fixture time has passed.

Note that working and fixture time are affected by temperature. Elevated temperatures accelerate cure and shorten working and fixture times, whereas lower temperatures slow reaction speed down and lengthen these times. The application temperature for the adhesive and parts should be between 15°C and 30°C (60°F and 85°F).

Health & Safety

Consult product specific Safety Data Sheet.

All of our products are developed with REACH compliance substances.