AMBERCOMPOSITES

EF72 ADHESIVE FILM

A 120°C (248°F) Curing Modified Epoxy Structural Adhesive Film

EF72 adhesive film is a high strength epoxy adhesive formulation supplied in the form of a light weight flexible film. It is intended for metal to metal or sandwich core to skin bonds and has a strong self-filleting action in honeycomb-to-skin bonds. The film is protected on one side by a release paper and on the other by a polythene separator. A lightweight polyester net is incorporated into the adhesive film to ensure easy handling whilst cutting and positioning.

EF72 is compatible for co-cure with Amber composites MULTIPREG E700 series

CHARACTERISTICS:

- **Availbale in a range of surface weights (100g/m^2, 200g/m^2 and 300g/m^2)**
- **High performance bonding in both metallic and composite structures**
- **Accurate control of adhesive distribution, reduced wastage**
- **Medium tack level, clean and easy to apply**
- **Excellent filleting to honeycomb, ideal for honeycomb sandwich construction**
- **Suitable for press moulding, autoclave and vac bag cure**
- **No solvents, low volatile content**
- **Long shelf life at ambient temperature**

RESIN PROPERTIES	
Density	1.20 g/cc at 23°C (73°F)
Tg (DSC)	112°C(233°F) (DSC)

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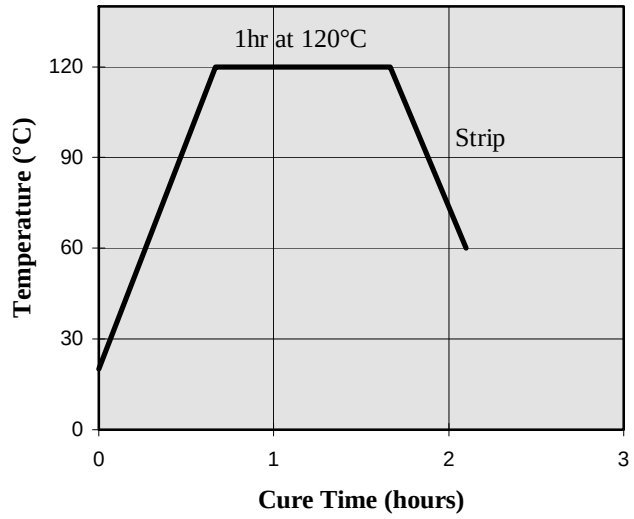
PROCESSING

It is important that all substrates to be adhered are de-greased and free from contamination before use.

Following removal from refrigerated storage, allow resin film to reach room temperature before opening the polythene bag, to avoid moisture condensation.

CURING CYCLES



Cure for 60 mins at 120°C (248°F). It is recommended that heat up rates of 2°C (3.6 °F) to 5°C (9°F)/min are employed. Allow to cool to 60°C prior to releasing vacuum and removal from mould.

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TYPICAL ADHESIVE PROPERTIES (at Room Temperature)

EF72 Resin Film Weight (g/m^2)	Climbing Drum Peel Strength (N/75mm)	Tensile Lap Shear Strength (MPa)
300	550	36

Climbing drum sandwich peel strength and tensile lap shear strength at 20°C (68ºF) according to DTD 5577.

Moulding conditions for the test samples were as follows:
Heated 1hr at 120°C (248°F).
25 P.S.I. pressure applied

STANDARD ROLL QUANTITIES

Resin Film Weight Include. Polyester Net (g/m^2)	Roll Length (linear m)	Width (m)
100	20.5	1.22
200	20.5	1.22
300	20.5	1.22

Other roll lengths are available on request.

The film is supplied on rolls with a polyester net carrier.
The film is protected by release paper on one side and polythene separator on the other.

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STORAGE

Shelf life is at least 1 month at ambient temperature 20ºC (68ºF)

Refrigerated storage life is 12 months at –18ºC (0ºF)

HANDLING SAFETY

Observe established precautions for handling epoxy resins and fibrous materials.

For further information refer to Material Safety Data Sheet.

FURTHER INFORMATION

Please contact Amber Composites for additional information.