

LOCTITE EA 9845 AERO

Composite Surfacing Film

(KNOWN AS Hysol EA 9845SF)

INTRODUCTION

LOCTITE EA 9845 AERO is a 250°F/121°C or 350°F/177°C curing epoxy-based composite surfacing film designed to improve the surface quality of honeycomb stiffened composite parts. The product is manufactured with a non-woven fabric for support. It is offered in a nominal weight of 0.020 psf (98 g/m²).

FEATURES

- Good Tack and Drape
- Co-curable with composite matrix resins at 250°F/121°C and 350°F/177°C
- Provides High Quality Paintable Surface
- Minimizes Core Crush and Porosity
- Maximum Leveling Properties
- Resistant to Microcracking
- Resistant to UV effects
- Compatible with Lightning Strike Screens and Foils

Uncured Properties / Suggested Acceptance Tests for certification

Color ¹	Blue or Black
Film Weight	0.020 - 0.045 lb/ft ² (98 - 220 g/m ²)
Gel time at 250°F/121°C	30 minutes
Gel time at 350°F/177°C	2 minutes
Flow at 350°F/177°C, 100 psi/0.69 MPa	4% for 0.020 lb/ft ² (98 g/m ²)
Volatile Content (60 min. at 250°F/121°C)	<1% Max.

¹Color Blue - Visual examination and comparison to ISCC-NBS Centroid Color Charts.

Handling

This product is supplied in roll form and is ready to use as received. The film should be removed from cold storage and allowed to warm to room temperature prior to opening sealed bag. The indicator on the desiccant should be blue. The fabric side of the film should be positioned and co-cured on the prepreg side of the part. This will allow easy repositioning of prepreg if necessary.

Application

Storage Life - This product requires refrigerated storage. Store @ 0°F/-18°C or below for maximum storage life. Warranty life @ 0°F/-18°C is 12 months from date of shipment. Store only in sealed containers to prevent moisture contamination. Allow all moisture to evaporate before opening for use.



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Open Assembly Time - This surfacing film may be used within the following schedule after removing from above recommended cold storage:
@ 77°F/25°C at least 30 days.

Lay-up - Application of the surfacing film should be with the resin side facing the tool. Tools pre-treated with LOCTITE FREKOTE® Sealer B-15 and LOCTITE FREKOTE 700 NC Release Agent are recommended.

Curing - This surfacing film may be cured at either 250°F/121°C for 2 hours or 350°F/177°C for 1.5 hours with 45 psi/0.31MPa pressure (1°F to 10°F/0.5°C to 5°C per minute heat up rate).

Surface Preparation for Painting - Light sanding (180 grit) followed by solvent wipe to remove release chemicals and some imperfections.

Cleanup - It is important to remove excess adhesive from the work area and application equipment before it hardens. Denatured alcohol and many common industrial solvents are suitable for removing uncured adhesive. Consult your supplier's information pertaining to the safe and proper use of solvents.

Handling Precautions

Do not handle or use until the Material Safety Data Sheet has been read and understood.
For industrial use only.

DISPOSAL INFORMATION

Dispose of spent remover and paint residue per local, state and regional regulations. Refer to HENKEL TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional disposal information.

PRECAUTIONARY INFORMATION

General:

As with most epoxy based systems, use this product with adequate ventilation. Do not get in eyes or on skin. Avoid breathing the vapors. Wash thoroughly with soap and water after handling.

Before using this product refer to container label and HENKEL TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional precautionary, handling and first aid information.





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