



Date: 6-25-93
ORIGINAL

E & H #775 **STANDARD BONDING FILM**

DESCRIPTION:

E&H #775 is a non-supported acrylic based film adhesive which is cast on a release liner designed for interior non-structural bonding applications (vinyl, cork, foam, tedlar, etc.)

PHYSICAL PROPERTIES:

APPEARANCE:

Pale amber, free from wrinkles, air pockets, pinholes, lumps or foreign matter.

WEIGHT:

0.028 ± 0.006 lbs./sq.ft.

THICKNESS:

.0045 ± 0.0005 inch

VOLATILES CONTENTS:

3.5 percent maximum

PEEL STRENGTH PER ASTM D903 (AL FOIL TO AL PLATE)

	<u>PROPERTIES</u>	<u>MINIMUM AVERAGE</u>	<u>MAXIMUM INDIVIDUAL</u>
A.	Peel strength (P.I.W.) at 70°F ± 5°F Plus 7 days after 7 days aging at 70°F ± 5°F	10	9
B.	Peel strength (P.I.W.) 1 day at 70°F ± 5°F plus 6 days at 95 to 100% relative humidity at 120°F ± 5° F.	15	14
C.	Peel strength (P.I.W.) 1 day at 70°F ± 5°F plus 6 days exposure at 160°F ± 5°F.	18.5	17.5

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STATIC LOAD CREEP PER ASTM D903 (AL FOIL AT AL PLATE)

<u>PROPERTIES</u>	<u>CREEP TIME HRS.</u>	<u>MINIMUM AVERAGE</u>	<u>MAXIMUM INDIVIDUAL</u>
Creep distance (inches per pound/inch of width) at 70°F ± 5°F plus 7 days after 7 days aging at 70°F ± 5°F.	24	1.0	2.0
Creep distance (inches per pound/inch of width) 1 day At 70°F ± 5°F plus 6 days at 95 to 100% relative humidity at 120°F ± 5°F.	24	1.0	2.0
Creep distance (inches per pound/inch of width) at 1 day at 70°F ± 5°F plus 6 days exposure at 160°F ± 5°F.	24	0.5	2.0

APPLICABLE SPECIFICATION: BOEING BMS 5-91 TYPE II

APPLICATION:

INITIAL BOND is achieved by mounting the roll of adhesive on a rotary nip laminator and passing the adhesive film and primary substrate through the rollers with approximately 40 PSI at the nip.

FINAL BOND is accomplished by removing the release paper from the surface of the adhesive coated primary substrate and bringing this into contact with the secondary substrate, exercising care not to entrap air between them. Use of a rotary nip laminator is recommended here, also if practicable, use of a hand roller or hand pressure is the secondary choice. Heat of approximately 150°F may be applied if necessary.

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