



Hysol® PL 777-1FR

Epoxy Film Adhesive

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Description

Hysol® PL 777-1FR is a flame retardant version of Hysol® PL 777-1 epoxy film adhesive. The properties of Hysol® PL 777-1FR are similar to those of Hysol® PL 777-1.

Features

- Good tack and drape
- Long out-time life at room temperature.
- 250°F (121°C)/ 350°F (178°C) Cure Capability
- Excellent adhesion to aluminum and composite substrates
- Hysol® PL 777-1FR is flame retardant as measured by the average post burn time on a sixty second vertical ignition test.

Uses

For metal bond applications; however it is suitable with many thermoplastic substrates.

Typical Technical Data	Hysol® PL 777-1FR
Type:	Modified Epoxy Film Adhesive available supported or unsupported
Scrim:	Nylon Tricot, Non-Woven Polyester
Weight:	.03 - .08 psf (146-390 g/m ²)
Width:	48" (122 cm)
Volatiles:	<1%
Out Time:	20 days @ 77°F (25°C)
T _g (DSC):	260°F (127°C)
Color:	White
Tack:	Medium-High
Gel Time:	8-12 minutes at 250°F (121°C)
Shelf Life	12 mos. at 0°F (-18°C)

Performance Properties

Hysol® PL 777-1FR, .060 psf (290 g/m²), knit supported, cured 1 hr at 250°F (121°C) over 2024-T3 bare Al substrates, FPL and PAA etched and primed with BR127.

Lap Shear Strength	75°F (24°C)	5000 psi	(34.5 MPa)
	250°F (121°C)	2900 psi	(20.0 MPa)

Floating Roller Peel	75°F (24°C)	30 in. lb/in.	(133 Nm/m)
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Typical technical data and performance properties given for reference only. Not for specification purposes.

Application Method

Allow adhesive film to reach room temperature before opening poly bag to prevent moisture contamination. Bonding surfaces should be clean, dry and free of contamination. Remove poly liner and apply adhesive to one surface to be bonded. Just prior to bonding, remove remaining liner. The bonded parts should be held in contact until the adhesive is cured.

Curing Conditions

90 minutes @ 250°F (120°C) @ 40 psi (.28MPa)

60 minutes @ 350°F (180°C) @ 30 psi (.2 MPa)

Clean-up

Uncured adhesive may be removed effectively with ketone solvents in well-ventilated areas. Avoid contaminating uncured parts. Consult solvent container label and MSDS for proper safety and handling procedures.

Storage

Hysol® PL 777-1FR has a shelf life of 1 year at 0°F (-18°C). The adhesive has an out time of 20 days at 77°F (25°C).

Handling Precautions

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

For industrial use only.

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. Empty containers retain product residue and vapors so obey all precautions when handling empty containers.

ONE PART

CAUTION! This material may cause eye and skin irritation or allergic dermatitis. It contains epoxy resins.

Hysol® is a registered trademark of Henkel Corporation.

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Users should review the Materials Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and label are available upon request.

