



Henkel

Hysol®

Hysol® EA 9895™ Wet Peel Ply
Hysol® EA 9896™ Wet Peel Ply



Henkel

**FOR THE ULTIMATE STRENGTH COMPOSITE BOND –
PEEL THE DIFFERENCE**



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Hysol® EA 9895™ Wet Peel Ply

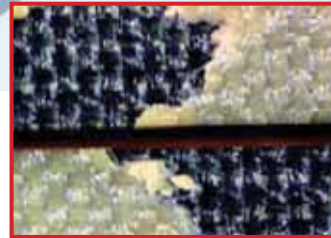
Hysol® EA 9895™ .033 PSF WPP has been proven to increase bond durability and optimize bond surfaces in a variety of aerospace applications. Supplied in film form, this pre-impregnated polyester peel-ply cures at 350°F/177°C. It is compatible with state-of-the-art composite prepreg resin systems and provides minimal residual peel ply fibers at the bond surface.

FEATURES AND BENEFITS

- Easy removal – fabric strips easily in one piece, reducing shop time
- No contamination – Once removed, the residual polyester fibers left are so minimal they eliminate any potential contamination of the bonding surface
- Good bonding surface – imparts the scrim surface and fractures evenly to allow for a clean bonding surface with little or no residual fiber contamination
- No sanding or solvent wiping – requires no further processing steps
- Allows productivity on large parts – improved translation of strength in final part

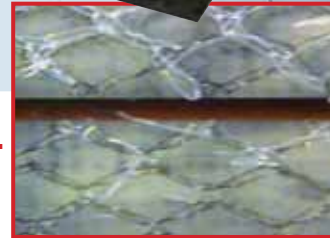
STRUCTURAL AEROSPACE APPLICATIONS

- Composite bonding
- Qualified to Airbus® IPS 12-01-002, Goodrich RIMS 1036, and Boeing®'s BMS 8-403



DRY PEEL PLY

POLYESTER DRY PEEL PLY,
TOUGHENED FILM ADHESIVE



VS.

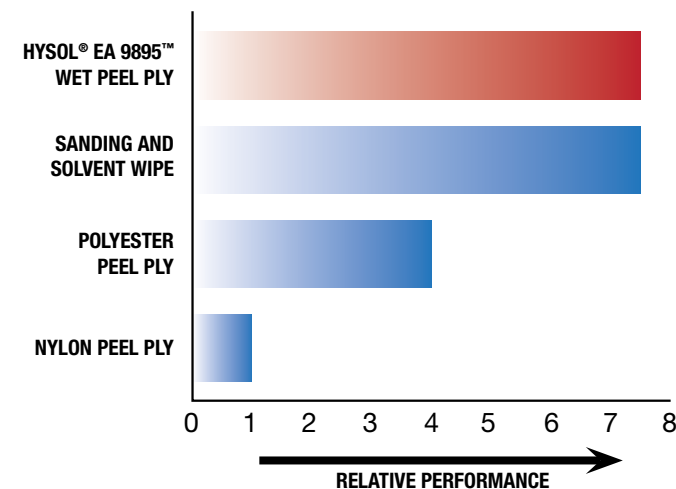
HYSOL® EA 9895™ WET PEEL PLY

HYSOL® EA 9895™ WET PEEL PLY,
TOUGHENED FILM ADHESIVE

HYSOL® EA 9895™ WET PEEL PLY PRODUCT DETAILS

| | |
|--------------------|--------------------------------------------------------------------------------------------------------------------------------------|
| Product Form | One-Part Film |
| Color | Neutral/Off-white |
| Areal Weight | 161 g/m ² (0.033 PSF) |
| Support Carrier | Polyester Peel Ply |
| Roll Dimensions | Nominal 1 m wide by 50.9 m long (3 feet wide by 167 lineal feet) |
| Resin Content | 48% nominal |
| Storage Life | 0°F/-18°C or below |
| Open Assembly Line | After Removing from Cold Storage: @ 25°C/77°F at least 14 days (actual time TBD) @ 32°C/90°F at least 7 days (actual time TBD) |
| Curing | 90 to 120 minutes at 177°C (350°F) Heat up to cure (between 0.6° and 5.6°C [1° and 10°F] per minute) |

BOND COMPARISON



Hysol® EA 9896™ Wet Peel Ply

Hysol® EA 9896™ .025 PSF WPP is a resin-impregnated nylon peel ply adhesive used for the surface preparation of composite substrates and designed to eliminate sanding and grit blasting processes.

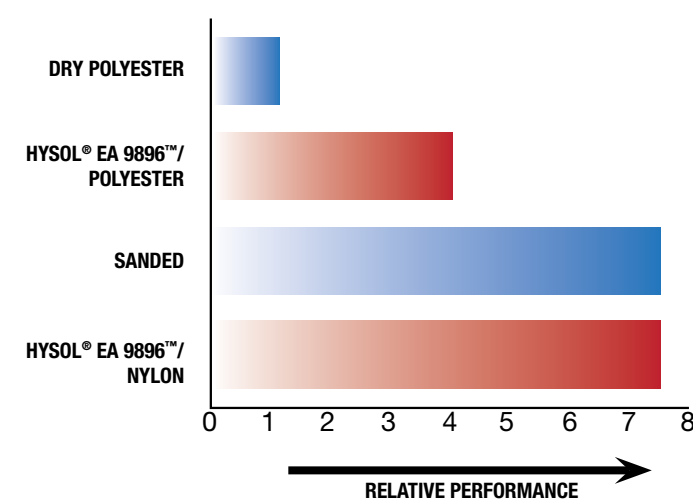
FEATURES AND BENEFITS

- Provides a consistent bonding surface
- Strips cleanly from bonding surface
- Eliminates sanding or grit blasting of composites
- Mechanical performance equivalent to carefully sanded surfaces
- Reduced cost of use
- Increased process efficiency
- Cleaner bonding surface
- Low curing temperature

STRUCTURAL AEROSPACE APPLICATIONS

- Secondary bond
- Interior paint applications

BOND COMPARISON



HYSOL® EA 9896™ WET PEEL PLY PRODUCT DETAILS

| | |
|-----------------|------------------------------------------------------------------|
| Product Form | One-part film |
| Color | Neutral/Off-white |
| Areal Weight | 122 g/m ² (0.025 PSF) |
| Support Carrier | Nylon peel ply |
| Roll Dimensions | Nominal 1 m wide by 50.9 m long (3 feet wide by 167 lineal feet) |
| Resin Content | 45% nominal |
| Cure Time | 90 to 120 minutes at 250°F/121°C |

BOND STRENGTH PERFORMANCE

Relative bond strength is indicated below for the various surface preparations methods. Hysol® EA 9896™ prepared surfaces produce equivalent bond strengths to sanding and solvent wiped surfaces without their additional processing steps. The following table shows the performance of a paste adhesive Hysol® EA 9360™ over a composite made from 250°F curing prepreg with Hysol® EA 9896™.

| Peel Ply | Hysol® EA 9896™ | Sanded |
|------------------------------------------|-----------------|----------|
| Prepreg | 250°F | 250°F |
| Adhesive | EA 9360™ | EA 9360™ |
| Prepreg Cure Temp. (°F) | 250 | 250 |
| Adhesive Cure Temp. (°F) | 180 | 180 |
| Lap Shear (psi) | 4150 | 4080 |
| G _{1c} (in-lb/in ²) | 11 | 12 |
| Failure | Laminate | Laminate |