LOCTITE®

High Temperature Nacelle Film Adhesives

LOCTITE® EA 9658 AERO*

For excellent high temperature strength and long term thermal durability. Suitable for metal, composite and honeycomb bonding where continuous exposure to temperatures up to 350 °F / 177 °C is important.

Application:

- Nacelle metal & composite bonding

Attributes & Features:

- Film adhesive available as unsupported or supported versions
- Increased open time assembly / handling performance
- Adhesive cure 350 °F / 177 °C
- High glass transition temperature (Tg) performance
- Excellent flow control to minimize hole blockage & excess flash / flow
- Reticulation capability
- Increased toughness with high temperature performance
- Thermally stable out to 6000 hours at 350 °F / 177 °C
- Thermally compatible with LOCTITE® EA 9258.1 AERO low VOC waterbase primer
- 35% weight reduction with low weight product version

Henkel

*LOCTITE® EA 9658 AERO known as Hysol® EA 9658

LOCTITE® EA 9658 AERO • Applications

Storage Life
- Requires refrigerated storage.
- Store @ 0 °F / -18 °C or below for maximum storage life.
- Warranty life @ 0 °F / -18 °C is 9 months from date of shipment.
- Store only in sealed containers to prevent moisture contamination.
- Allow all moisture to evaporate from container before opening for use.

Applying
- Bonding surfaces should be clean, dry and properly prepared. For optimum surface preparation consult the Hysol® Surface Preparation Guide.
- The adhesive film, with one liner left on it, may be tacked to the detail part for cutting to shape and size.
- The liner should remain with the adhesive until just before assembly of the detail to the other faying surface. This will minimize contamination of the adhesive bond.
- The bonded parts should be held in contact until the adhesive has cured. Usually 25 to 50 psi / 1.2 to 2.4 kPa is sufficient to assure proper mating.

Open Assembly Time

LOCTITE® EA 9658 AERO may be used within the following schedule after removing from cold storage:
- @ 77 °F / 25 °C at least 15 days
- @ 90 °F / 32 °C at least 10 days

Curing

LOCTITE® EA 9658 AERO may be cured for 1 hour @ 350 °F / 177 °C. Heat up rate to the cure temperature is not critical, but should be between 4° and 7 °F (2.2° and 4°C) per minute. Pressure should be applied before heating the parts to be bonded and maintained until cool down of the assembly.

Cleanup
- It is important to remove excess adhesive from the part and bonding tools before it hardens. Once the adhesive is cured, it is difficult to remove except by mechanical abrasion.
- Uncured adhesive may be removed with a ketone solvent in a well-ventilated area.
- Saturate a clean cloth or industrial wiper with solvent and apply just enough to do the job.
- Be careful to prevent any solvent from entering the uncured bondline, as solvent will degrade the final bond performance.
- Consult with your supplier's information pertaining to the safe and proper use of solvents.

LOCTITE® EA 9658 AERO • Configurations

Packaging Configurations Offered	36IN X 150FT 450SF EA 9658 .060 PSF UNS EA 9658 .065 PSF NWG* EA 9658 .100 PSF NWG	**Open Time Assembly**	15 days @ 77 °F / 25 °C 10 days @ 90 °F / 32 °C
		Cured Density, g/cm³ (pcf)	0.72 (45)
Storage Temperature	≤0 °F / ≤ -18 °C	**Warranty Life**	9 months

UNS = unsupported adhesive, no fabric
NWG = supported adhesive, non-woven glass fabric

* EA 9658.065 PSF NWG is low weight version of EA 9658.100 NWG for nacelle bonding on e.g. 787-9.

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