



## **E&H LAMINATING & SLITTING COMPANY**

**For Pricing and Information**  
**please contact:**  
**KIEPURA AVIATION CORP.**  
61 Church St.  
Littleton, NH 03561  
Tel: 603-444-3459 / Fax: 603-444-0790  
Toll Free: 1-888-522-8273  
(USA/Canada)  
Email: [jane@kiepuraaviation.com](mailto:jane@kiepuraaviation.com)  
[www.kiepuraaviation.com](http://www.kiepuraaviation.com)

### **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 application (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:** 0.045 +/- 0.0005 inch

**VOLATILES CONTENTS:** 3.5 percent maximum

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

<b><u>PROPERTIES</u></b>	<b><u>MINIMUM AVERAGE</u></b>	<b><u>MAXIMUM INDIVIDUAL</u></b>
<b>A.</b> 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>B.</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
<b>C.</b> 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

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

<b><u>PROPERTIES</u></b>	<b><u>CREEP TIME HRS.</u></b>	<b><u>MINIMUM AVERAGE</u></b>	<b><u>MAXIMUM INDIVIDUAL</u></b>
A. 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
B. 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
C. Creep distance (inches per pound/inch of width) 1 day at 70°F +/- 5°F plus 6 days exposure at 160°F +/- 5°F	24	0.5	2.0

**APPLICABLE SPECIFICATIONS:** 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.

**E&H CO:** As manufacturer warrants that the products described and presented herein are of merchantable quality, but does not warrant their fitness for any particular use or make any other warranty, expressed or implied. Liability of E&H under this warranty is limited to replacement of the products found to be defective, or, at its option, a refund of the purchase price.