

**PRODUCT DATA SHEET
TOUGHENED SEPTUM FILM,
SOUND APPLICATIONS
EPOXY
PLASTILOCK® 707-1**

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Last updated: 02/26/03

DESCRIPTION

PLASTILOCK® 707-1 is a toughened, epoxy film adhesive. It is designed as a laser drillable septum film for use in sandwich panel constructions for sound attenuation applications. PL 707-1 gels at 200°F (93°C) in less than 2 hours.

FEATURES & BENEFITS

- Non-Asbestos
- Translucent - enables visual inspections to ensure proper laminations between glyconol and adhesive films
- Excellent gauge control; " 2 mil (.05mm) capabilities
- Laser drillable
- Low flow
- Available in sheet or roll form up to 48" (1.2 meters) wide

USES

Septum film in sandwich panel construction.

TYPICAL TECHNICAL DATA:	PLASTILOCK® 707-1
Type:	Modified epoxy film - unsupported
Thickness:	17 ± 2 mils (.43 ± .05mm) and 30 ± 2 mils (.76 ± .05 mm) - others available upon request
Density:	76.4 lbs/ft ³ (1.22 g/m ³)
Color:	Amber
Volatiles:	<1%
Form:	2' x 3' (.61m x .91m) sheets or roll form 36" (1.2m) wide - others available upon request
Out Time:	5 days at 92°F (33°C)
Shelf Life:	6 months at 0°F (-18°C)
Cure Conditions:	120 minutes @ 200°F (93°C) 60 minutes + @ 250°F (121°C) 90 minutes + @ 350°F (177°C)

PERFORMANCE PROPERTIES

SINGLE OVERLAP SHEAR (BAR ALUMINUM)		PSI	MPa
°F	°C		
-67	-55	2560	17.6
75	24	3400	23.4
300	149	3105	21.4

PUSH OUT STRENGTH	17 MIL	0.43mm	30 MIL	0.76mm
	LBS	NEWTONS	LBS	NEWTONS
77°F (25°C)	10.6	47.2	17.7	78.7
300°F (149°C)	6.8	30.2	11.7	52.0

TYPICAL TECHNICAL DATA AND PERFORMANCE PROPERTIES GIVEN FOR REFERENCE ONLY. NOT FOR SPECIFICATION PURPOSES.

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APPLICATION METHOD

Allow adhesive film to reach room temperature prior to opening shipping container or polybag. This will prevent material from breaking or becoming contaminated with moisture caused by condensation.

Remove one of the protective release liners from the adhesive and laminate on to contaminant free glyconal wax film. Remove the second protective release liner from the adhesive and push honeycomb assembly into the adhesive/glyconal laminate.

CURING CONDITIONS

120 minutes @ 200°F (93°C)
plus
60 minutes + @ 250°F (121°C)
plus
90 minutes + @ 350°F (177°C)

CLEAN UP

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

STORAGE

PL 707-1 has a shelf life of 6 months at 0°F (-18°C)
This product has an out time of 5 days @ 92°F (33°C)

CAUTION

PL 707-1 may cause skin irritations. Prevent contact with skin. If contact occurs, wash with soap and water. Consult Material Safety Data Sheet before using or storing this product.

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FILM NON-FLAMMABLE SAFETY SHEET

Read Material Safety Data Sheet before using, handling or storing this product.

Use only in a well ventilated area. Avoid prolonged or repeated breathing of vapor - excessive exposure may cause serious personal injury. If dizziness or nausea occur, obtain fresh air. Avoid contact with skin or eyes. If contact with skin occurs, wash thoroughly with soap and water. ***If swallowed, do not induce vomiting. See a physician immediately.*** Store in cool, well ventilated placed. **KEEP OUT OF REACH OF CHILDREN.** Avoid eye contact.

DISPOSAL

Scrap must be stored in an isolated and segregated area while awaiting disposal and should, in no event, be mixed with other types of scrap. We recommend disposal by an industrial waste firm, which is qualified to handle hazardous materials. Disposal should be either by controlled burning or by burial and must be in accordance with state and local regulations.

Observe all of the above warnings and instructions with scrap material and with empty containers. Empty containers may contain product residue or vapors.

LIMITED WARRANTY

Except as provided below, we warrant our products to be free of defects and manufactured to meet published physical properties when cured and tested according to applicable specifications and SIA Adhesives, Inc. standards. Under this warranty, we will provide, at no charge, product in containers to replace any product proved to be defective when applied in accordance with our written instructions, and in applications recommended by us as suitable for this product. All claims must be in writing and must be made within 30 days of shipment. The absence of claims during this period will constitute a waiver of all claims with respect to claims with respect to such product. This warranty is IN LIEU OF any and all other warranties, expressed or implied, including but not limited, any implied warranty of MERCHANTABILITY or fitness for a particular purpose.

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