



HexBond™ ST1150

Foaming Adhesive Film



Product Data Sheet

Description

Foaming core splice adhesive. It is especially useful in bonding sections and edge filling honeycomb. It is ideal for use in thick sections of honeycomb.

Packaging: Length/width of sections: 305mm x 610mm

Features

- Cure from 120°C/248°F to 180°C/356°F
- Low volatiles content: $\leq 1\%$ (after cure 1h at 178°C/325°F - 3°C/min)
- Shelf-life: 1 year at temperature $\leq -18^\circ\text{C}/0^\circ\text{F}$ + 15 days at room temperature ($\leq 23^\circ\text{C}/73^\circ\text{F}$)

Applications

- Core splice bonding
- Sandwich construction

Uncured Adhesive Properties

	Form	Weight (g/m ²)	Thickness (mm)	Color	Package
ST1150 25 MIL	Sheet of 305mm x 610mm	750 (± 100)	0.64	Blue	Box of 3.72m ² (20 sheets)
ST1150 50 MIL	Sheet of 305mm x 610mm	1500 (± 150)	1.27	Blue	Box of 3.72m ² (20 sheets)

Instructions For Use

Refer to the Safety Data Sheet before handling.

- To avoid any moisture, allow the adhesive to warm at room temperature before opening the waterproof polyethylene bag
- Bonding surfaces should be clean, dry and properly prepared
- Remove protective papers before bonding
- Typical cure cycles: 1h at 120°C/248°F at 175°C/347°F
Heat-up 248°F to 4°C/min



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Mechanical Properties

Test	Test Temperature (°C / °F)	Curing 1h 120°C / 248°F (3°C/min)	Curing 1h 175°C / 347°F (3°C/min)
Expansion ⁽¹⁾ (%)	23°C	120	170
Flow on vertical wall ⁽²⁾ (mm)	23°C	-	0.2
Tube shear strength ⁽³⁾ (MPa / psi)	-55 / -67	10 / 1450	10 / 1450
	23 / 73	8.0 / 1160	8.5 / 1230
	80 / 176	7.5 / 1090	8.0 / 1160
	23 / 73 WA ⁽⁴⁾	7.5 / 1090	8.0 / 1160

⁽¹⁾ According to EN 2667-3

⁽²⁾ According to EN 2667-4

⁽³⁾ According to EN2267-2, on aluminum 5052 treated with sulfo-chromic acid etch

⁽⁴⁾ Wet ageing: 70°C, 85% relative humidity, saturation

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For more information

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- HexTool® tooling materials
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- Acousti-Cap® sound attenuating honeycomb
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For US quotes, orders and product information call toll-free 1-800-688-7734. For other worldwide sales office telephone numbers and a full address list, please go to:

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