

# FM® 209-1

Adhesive

Cytec Industries Inc.

## Message:

FM® 209-1 is a next generation film adhesive specially formulated for out-of-autoclave bonding of both metallic and composite structures. This new adhesive provides similar performance in vacuum-only versus autoclave cure and has a unique combination of toughness and shear strength up to 121°C (250°F). FM 209-1 is designed for bonding metallic and composite substrates in monolithic and sandwich structures. It is compatible with most 121°C (250°F) and 177°C (350°F) curing epoxy-based prepreg systems for co-cure, co-bond and secondary bonding. FM 209-1 adhesive film provides minimum shop life of 30 days at 24°C (75°F). FM 209-1 adhesive has excellent resistance to both pre-bond and post-bond humidity exposures. FM 209-1 adhesive is supplied at various weights and thicknesses as an unsupported film or as a supported film with woven, knit or mat carrier. FM 209-1 film adhesive can be cured within the temperature range of 71°C to 177°C (160°F to 350°F) under vacuum-only pressure. The standard cure cycle for FM 209-1 is 121°C (250°F) for 90 minutes under full vacuum for out-of-autoclave (OOA) bonding applications or under 0.28 MPa (40 psi) pressure for autoclave cures.

### Suggested Applications:

Out-of-autoclave bonding of metal and composite monolithic and sandwich structures

Applications requiring low temperature cure

Applications requiring good serviceability at low temperature

General Information		
Features	Good Adhesion	
	Good Toughness	
	Humidity Resistant	
Uses	Adhesives	
	Bonding	
Appearance	Red	
Forms	Film	
Physical	Nominal Value	Unit
Specific Gravity	1.25	g/cm <sup>3</sup>
Thermal	Nominal Value	Unit
Glass Transition Temperature	132	°C
Additional Information	Nominal Value	Unit
Volatiles	< 1.0	%

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

## Recommended distributors for this material

### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT