

# Technical Data Sheet: AEROK 9110

## Product Description

**Aerok 9110** is a two component low density adhesive/filler developed for bonding composite and aluminium honeycomb panels. Suitable for filling/bonding internal or external kerf cuts in curved panels. Used widely for "ditch and pot/cut and fold" applications and as an adhesive and edge filler. Due to its high FST performance Aerok 9110R is used as an adhesive to bond insert blocks and to full surface bond decorative finishes. Will meet the requirements of FAR/JAR/CS 25.853 (a) - 60 second vertical burn, ABD 0031/D6-51377 Toxic gas emission, and many other standards - depending on substrates and substrate combinations



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Typical Physical Properties

Aerok 9110

(\*) These values may vary depending on environmental factors such as: temperature, moisture and type of substrates.

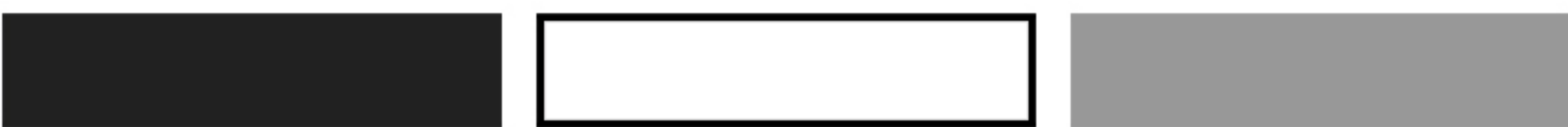
Values will also vary due to volume of material mixed/used due to exothermic reaction

| Properties                              | Aerok 9110                         |
|-----------------------------------------|------------------------------------|
| Base                                    | Epoxy Resin                        |
| Density - g/cm³                         | 0.70                               |
| Viscosity                               | Soft Paste                         |
| Thixotropic                             | Yes                                |
| Rate of Extrusion at 20°C / 68°F        | 400ml/min                          |
| Rate of Extrusion at 38°C / 100°F       | N/A                                |
| Usable Life*                            | 25 minutes                         |
| Setting Time at 25°C / 68°F             | 2 hours                            |
| Setting Time at 60°C / 140°F            | 20 minutes                         |
| Compressive Strength                    | >35MPa / >5000 PSI                 |
| Lap Sheer Strength                      | >19MPa / >2750 PSI                 |
| Temperature Resistance                  | - 40°C to +70°C / - 40°F to +158°F |
| Temperature Resistance - Ground Soak    | - 55°C to +90°C / - 67°F to +194°F |
| Thermal Expansion                       | 73.3 x 10 -6 m/m/°C                |
| Water Absorption (% increase in weight) | <0.1                               |
| Mix Ratio (by volume)                   | 1 : 1                              |

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## Colours

Black, White or Grey.



## Shelf Life

12 months in unopened packaging in a cool and dry storage place at temperatures between +15°C and +25°C / +59°F and +77°F

## Application Instructions

Weigh out A and B components in correct proportions. Mix components together with hands (wear disposable gloves - talc free) thoroughly and ensure no streaking in product is evident. Fill edges/voids, etc. Product can be tooled with spatula/tooling ball dipped in water. Repair with Aerok 9110. We recommend preliminary compatibility tests prior to application.

## Volumes Available.

Cartridges  
50ml  
200ml  
400ml



Bulk



## Health and Safety Recommendations

As with all epoxy products, avoid skin and eye contact and apply the usual industrial hygiene.

Check the packaging for more information or see MSDS

### Remarks, Disclaimer & Health and Safety

**Disclaimer** - The variability of materials, substrates and conditions of use is such that no warranty of their functionality for a specific application can be deducted from this information, written recommendation or any other type of suggestion offered. Each user has the responsibility to complete adequate evaluations on the efficacy of the materials offered by Forgeway, of its products, services, recommendations and suggestions for the specific application need, and must accomplish sufficient testing to ascertain that the final product will be safe and sound for the final intent of the end user.

**Health and safety** - Refer to Safety Data Sheet (SDS) for further information. Apply the usual industrial hygiene.

Reviewed July 2023