

FM® 94

Epoxy; Epoxide

Cytec Industries Inc.

Message:

FM® 94 adhesive is a 220°F (104°C) service temperature, modified epoxy film adhesive designed for bonding metallic and composite structures. FM 94 adhesive offers a unique combination of high temperature performance, toughness and moisture resistance as demonstrated by its ability to bond to wet Nomex® honeycomb and retention of shear properties after pre- and post-bond humidity exposure. FM 94 adhesive is designed for applications demanding the best of both 220°F (104°C) service temperature and -67°F (-55°C) peel strength. For composite and metal bonding applications, FM 94 adhesive is formulated to exhibit superior elongation, toughness and shear strength properties. The controlled flow characteristics allow for its use in co-cured applications as well as bonding pre-cured structures. Also, FM 94 adhesive provides excellent electrical insulation between metal and graphite composites, reducing the potential for galvanic corrosion. FM 94 film adhesive is manufactured as a supported adhesive with both knit and mat carriers, or as an unsupported film. When supported with a knit carrier, optimal mechanical properties can be obtained. The random mat provides superior handling characteristics. With the mat carrier, FM 94 adhesive can be supplied in a one-side tacky (OST) version which helps reduce air entrapment when bonding large metal or composite parts.

Suggested Applications:

Bonding of metallic and composite structures

General Information			
Features	Good Corrosion Resistance		
	Good Strength		
	Good Toughness		
	High Elongation		
	High Heat Resistance		
	Humidity Resistant		
Uses	Adhesives		
	Bonding		
	Structural Parts		
Appearance	Green		
Forms	Film		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM C297
24°C	8.20	MPa	
104°C	1.72	MPa	
Shear Strength ²			ASTM D1002
24°C	46.6	MPa	
104°C	29.2	MPa	
Additional Information	Nominal Value	Unit	
Volatiles	< 1.0	%	
NOTE			
1.	Flatwise Tensile, Aluminum Substrate with BR® 6747-1 Adhesive Primer, FM 94K 0.06 psf (293 gsm)		

2.

Aluminum Substrate with BR®
6747-1 Adhesive Primer, FM 94K
0.06 psf (293 gsm)

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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

