



Redux® 319

Modified epoxy film adhesive

Product Data

Description

The Redux 319 series consists of film adhesives curing at 175°C. They are available in both supported and unsupported versions at areal weights between 180 and 400 g/m². The supported versions contain a woven nylon carrier for peel enhancement and glueline thickness control.

Features

- Cures in 60 minutes at 175°C
- Good performance at temperatures ranging from -55°C to 150°C
- Good short-term exposure performance at 175°C
- Excellent peel properties
- Good drape at ambient temperatures
- Less than 1% volatile content

Applications

- Aluminium to aluminium bonding
- Fibre-reinforced composite to composite bonding
- Aluminium honeycomb sandwich bonding
- Aramid honeycomb sandwich bonding

Forms

Grey flexible film adhesive, available unsupported (319 and 319L) or with a woven nylon carrier (319A series).

Product Description	Areal Weights g/m ²	Roll Width mm	Standard Roll m ²
Redux 319	367	533	40
Redux 319L	180	533	50
Redux 319A	240	533	40
Redux 319A	300	533	40
Redux 319A	400	533	40

Instructions For Use

Pretreatment

It is essential that all substrates to be used are free of contamination and are in as ideal a state for bonding as possible. As pretreatment varies significantly depending on the substrates being used, please refer to the Hexcel Composites publication Redux Bonding Technology for optimum procedures.



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If there is to be a delay between the pretreatment and bonding of aluminium, the pretreated surface should be protected with Redux 119 or Redux 140 surface pretreatment protection solution to conserve the optimum bonding surface. This will enable bonding to be delayed for up to 2 weeks without deterioration of the pretreated surface. The correct application of Redux 119 or Redux 140 should not alter the bonding performance of Redux 319 (for full application details consult the relevant data sheet).

Application

1. Allow sufficient time for the adhesive to warm to room temperature (15 - 27°C) before removing the protective polythene.
2. Cut the film to the shape and size required.
3. Remove the release paper and position the adhesive on the prepared bonding surface.
4. Remove the polythene backing sheet.
5. Complete the joint assembly and apply pressure while the adhesive is being cured. For sandwich structures the pressure application should be selected to suit the type of core used.

Curing

Redux 319 adhesives should be cured at $175 \pm 5^\circ\text{C}$ for 60 minutes to obtain optimum properties. Enough time should be allowed for heat to penetrate through the assembled parts to ensure that the adhesive reaches that temperature before timing starts. A cure pressure of around 350 kPa and heat up rate of approximately 5°C per minute is recommended during cure. After curing it is recommended that components are cooled to below 70°C before releasing the pressure.

Mechanical Properties

All the performance values given in this data sheet are based on experimental, routine Quality Control and Specification testing results obtained under laboratory conditions. They are typical values expected for the Redux 319 series prepared and cured as recommended and under the conditions indicated. They do not and should not constitute specification minima.

Metal Bonding Strengths

Redux 319 series adhesives were used to bond Alclad 2024-T3 aluminium test specimens; the aluminium was pretreated (chromated/sulphuric acid pickling) in accordance with Method O of BSI Code of Practice CP 3012 (Method O of DEF Standard 03-2/1). (Figures in brackets refer to results on substrates primed with Redux 119).

The honeycomb tests used Hexcel's 7.9-1/4-40 (5052) T aluminium honeycomb.

Test	Test Temperature °C	Redux 319L 180g/m ²	Redux 319 367g/m ²	Redux 319A 240g/m ²	Redux 319A 300g/m ²	Redux 319A 400g/m ²
Lap Shear Strength MPa	22 150	42 22	44 (45) 24 (26)	31	33 (36) 16	36 (38) (16)
Bell Peel N/25mm	22	175	180 (190)	140	170	170 (175)
Climbing Drum Peel N/76mm	22	270	600 (620)	200	330	460 (480)
Flatwise Tensile MPa	22		8.9 (9.3)			8.9 (9.0)

Environmental Resistance

Redux 319A - 400 gsm was used to prepare lap-shear specimens which were then exposed to a variety of "harsh" environments in accordance with DTD 5577 (Type 4 Class 4PH) and MMM-A-132, respectively. The specimens were subsequently tested and single overlap shear results in MPa were as follows:

Conditioning	Test Temp. °C	Redux 319 400 gsm
None	22	44 (45)
None	150	23 (23)
12 months at 150°C	22 150	30 22
1000 hrs in Silcodyne 'H' at 22°C	22	43 (45)
1000 hrs in synthetic esters at 22°C	22	44 (44)
1000 hrs in Skydrol 500A at 22°C	22	42 (44)
1000 hrs in Kerosene fuel at 22°C	22	45 (45)
1000 hrs in distilled water at 22°C	22	42 (43)
1000 hrs in anti-icing fluid at 22°C	22	44 (46)
1000 hrs in hydraulic oil at 22°C	22	43 (46)
1000 hrs in water/methanol at 22°C	22	42 (43)

Storage

Redux 319 adhesives have been formulated for maximum storage life consistent with their high performance. Certain precautions, however, will help to enhance that storage life as follows:

1. When stored at room temperature (less than 27°C) the adhesive should be kept on a horizontal mandrel passed through the tube core on which the roll is wound. This avoids the risk of local thinning of the film under the weight of the roll.
2. When storing under refrigeration the original packaging should be retained if possible. When returning to the refrigerator after use it is essential to protect the film with a water vapour barrier packaging material such as polythene.
3. On withdrawal from the refrigerator the water vapour barrier packaging should not be removed until the roll of adhesive has reached room temperature. This may take up to 24 hours depending on the size of the roll and the temperature involved (failure to observe this will result in the film becoming damp).
4. The film should be handled with care whilst in the frozen state since it will be brittle and easily cracked.

On receipt, Redux 319 adhesives will have a storage life of at least 12 months at -18°C plus an additional shop life of 4 months at below 27°C.



Volatile Content

Redux 319 adhesives have a very low volatile content, usually well below 1%. In practice, the loss in weight when cured is negligible and emission of volatile products is not of practical significance.

Associated products

Redux 119 and Redux 140 surface pretreatment protection solutions (primer)
Redux 219/2-NA and 219/3-NA foaming film adhesives

Handling and safety precautions

In common with all Redux adhesives in film form, Redux 319 is particularly free from handling hazards for the following reasons:

- Film is covered on both sides by protective release paper and polythene sheet which are not removed until final component assembly. It should be cut to shape before removing the protective coverings and virtually no handling of the film is necessary.
- Virtually tack-free (dry) at normal room temperature. The film is dependent on elevated temperature for wetting-out the adherend surfaces.
- Volatile-free at normal room temperature.
- Splash-free, leak-free, spillage-free.

However, the usual precautions necessary when handling synthetic resins should be observed. A Material Safety Data Sheet for Redux 319 is available on request.

Release Certification

The Quality System at Hexcel Composites Duxford has been certified to ISO 9001 by Lloyd's Register Quality Assurance, and is approved by the UK Civil Aviation Authority and Ministry of Defence. Certificates of Conformity and Test Reports can be issued for batches of Redux 319 on request.

Important

All information is believed to be accurate but is given without acceptance of liability. Users should make their own assessment of the suitability of any product for the purposes required. All sales are made subject to our standard terms of sale which include limitations on liability and other important terms.

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| ■ Honeycomb Cores | ■ Special Process Honeycombs |
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