Achieving New Heights
SMART ADHESIVES FOR AIRCRAFT INTERIORS
ADHESIVE ADDITIVES

Bostik is committed to helping aerospace manufacturers achieve the perfect bond for all interior and exterior applications. Our proprietary technologies represent 30 years of research and testing, offering high-performance solutions for most situations. Where the context demands, Bostik will consider using adhesive additives to make customized formulation adjustments to existing technology.

The Bostik Difference

Bostik engineers aerospace adhesives to be strong, safe and reliable.

Many Bostik adhesives are resilient to fire where the application demands. Bostik is world-renowned in aerospace for our fire retardant adhesives. We have worked diligently to create fire resistant adhesives that ensure a higher level of safety in dangerous situations.

Our products are used regularly in aircraft construction, mostly in nonstructural applications: interior wall panels, floors, doors, seats and even in decorative fixtures and laminates. Flame retardant film adhesives and heat-seal coatings are used to produce decorative laminates for aircraft interiors, as well as thermal and acoustical insulation systems. Bostik manufactures film adhesives using a broad range of raw materials.

Our liquid adhesives are applied as primers and sealants throughout the plane. Many interior plane applications use Bostik adhesives, so we have gone to great lengths to design our adhesives with excellent flame retardancy.

Bostik’s solvent-based, liquid adhesives are designed for use in aerospace interior applications such as vacuum form bonding of PVC films to wood, fiberboards, and most porous substrates. In addition to securing strong resilient anchorage to PVC, Bostik’s liquid adhesives bond all types of polyolefin foams, polyester films, most plastic laminating films, foils, sheet metal surfaces and cellulosic. These adhesives can be provided with fire retardant packages to meet the most demanding aircraft and industrial requirements.

Bostik adhesives help aircraft manufacturers to achieve new heights in strength, safety and reliability.

Smart Solutions
THROUGH CUSTOM FORMULATION

ADHESIVE ADDITIVES

Bostik is committed to helping aerospace manufacturers achieve the perfect bond for all interior and exterior applications. Our proprietary technologies represent 30 years of research and testing, offering high-performance solutions for most situations. Where the context demands, Bostik will consider using adhesive additives to make customized formulation adjustments to existing technology.
Adhesive Options

What are **FILM ADHESIVES**?
Film adhesives are adhesives that form a thin flexible layer, which can be heat activated or pressure sensitive for various applications. Bostik has 30 years of experience with solvent cast films for aerospace applications. Our products help control consistency in applications from usage variance to repeatable performance characteristics.

What are **LIQUID ADHESIVES**?
Bostik produces a wide range of liquid adhesives, from water-based technologies to solvent-based flame retardant systems. Bostik liquid adhesive systems lead the Aerospace Industry in interior adhesives, offering versatility and scale for any size application.

What are **WEB ADHESIVES**?
Web adhesives are hot melt adhesives converted into a web-like film that handles like fabric. Web adhesives from Bostik can increase productivity, offer low environmental impact, make better utilization of plant space, increase product shelf life and save on energy and operating costs. Webs offer consistent usage control while optimizing weight to performance criteria. All Bostik web adhesives are VOC free, simplifying processes and providing a safer alternative for adhesion.
**What is ELASTIC BONDING?**

Elastic bonding adhesives provide a flexible joint or seal that bonds individual components to a structural frame, allowing a dynamic attachment, which allows expansion and contraction while maintaining bond integrity. Elastic bonds are extremely durable, making them ideal for applications where a higher-temperature structural bond would break under continuous movement and stress.

**What is FLAME RETARDANCY?**

Flame retardant adhesives inhibit the spread of flame. They aid aerospace occupant safety by reducing fire, smoke and toxic fumes, allowing aerospace passengers a greater span of time to exit a high-danger situation.

**What is PRESSURE SENSITIVE ADHESION?**

Commonly known as a PSA, pressure sensitive adhesives offer a wide range of adhesion on many different substrates. From permanent bonds to removable adhesion, PSAs are a great choice for bonding panels, fabrics, foam and other interior products.

**What are LIGHTWEIGHT SOLUTIONS?**

Lightweight solutions from Bostik are essential for modern construction methods. Reducing weight in transportation vehicles translates into fuel savings and a lower overall impact on the environment. Bostik adhesives offer lightweight solutions specifically formulated to decrease weight yet provide strong, lasting bonds that keep transportation moving.
Adhesive Applications

ATTACHMENT ADHESIVES

- F14-552 | F14-554 | F14-588 | F14-610
- LADH7527FR | LADH7560FR | LADH7590

Attachment adhesives are film or liquid adhesives options chosen by tier manufacturers, giving their components a peel and stick feature for easy interior assembly and installation.

MOUNTING ADHESIVES

- F14-552 | F14-554 | F14-588 | SPA110
- L1096MR | L4145-14H | L4145-14G | L7132K | L7132M | L7132R | L1685MC | LADH1531AC

Mounting adhesives are used to provide immediate bond to substrates upon contact and are used throughout the plane in various interior applications. These adhesives, although traditionally, thought of as liquids, can also be provided as pre-applied pressure sensitive adhesive films.

EMBOSSING RESINS

- 10-651B | F15-789 | F10-337L | F10-250

Embossing resins provide the textured aesthetic to interior panels, bonding layers of low surface energy materials together to prevent marking, stains, and graffiti. Embossing resins can be thermoset or thermoplastic as well as reinforced with fiberglass to further improve durability in use.

HEAT SEAL ADHESIVES

- FPA110-1FR
- LADH300 | LADH7350

Some aerospace applications use assembly processes that require quick sealing of edges or parts with heat. Heat seal adhesives are typically coated onto those substrates and activated with heat later in the assembly process to ensure a quick, effective seal.

LAMINATING ADHESIVES

- FPA110-FR
- PE85 | PE103 | PE120 | PE165 | SPA110 | PA115 | PA145 | SH4275FR-A | SPA145FR-A

Laminating adhesives are used primarily for textile and fabric applications to adhere layered constructions together. Seating upholstery, decorative trims and cushions are common applications that use laminate adhesives.

SKIN TO CORE COMPOSITES

- FPA110-1FR | F10-250 | F10-316
- SH4275FR-A | SPA145FR-A

Composite panels are comprised of a core material, typically honeycomb or foam core construction, sandwiched between two outer skins. These skins can come in a variety of formats, from prepreg to decorative skins. Bostik products act as a tie layer between these substrates.
Skin to Core
COMPOSITES

Laminate
ADHESIVES
Mounting ADHESIVES

Embossing RESINS

Attachment & Heat Seal ADHESIVES
Heat Activated Film Adhesives

- **Flame Retardant ThermoSet**: F10-651B | F15-789
- **Non Flame Retardant ThermoSet**: F10-250 | F10-316
- **Flame Retardant Thermoplastic**: F10-337L | FPA110-FR

Bostik heat activated films are thin, non-tacky solvent cast films, which allow for ease of handling and positioning prior to assembly, with thicknesses ranging from 1 to 3 mils. The adhesive is activated with heat at the desired time to bond substrates together.

Pressure Sensitive Film Adhesives

- **Flame Retardant**: F14-552 | F14-554 | F14-588
- **Non Flame Retardant**: F14-610

Bostik pressure sensitive films are produced using our solvent cast process, with thicknesses ranging from 1 to 3 mils. Pressure sensitive films are ideal for pre-applied applications enabling peel and stick functionality.

Substrate Compatibility

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>PVF</th>
<th>PVC</th>
<th>ALUMINUM</th>
<th>PHENOLIC</th>
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Liquid Adhesives

APPLICATIONS
Decorative Laminate Mounting | Decorative Laminate Edge Wrapping | Hook and Loop Attachment | Honeycomb Core Splicing | Insulation and HVAC | General Bonding

MOUNTING ADHESIVES
L7132K | L7132M | L7132R | L4145 L1096MR | L1685MC | LADH1531AC

Bostik’s mounting adhesives are liquid, solvent-based adhesives that are either one or two-part systems. They are ideal for general bonding of a large surface area or when clamping is difficult. Mounting adhesives adhere to themselves and can be applied with a spray or brush application. These adhesives are used by applying an even coat of the adhesive to each substrate, allowing it to dry, and mating the two substrates together.

HEAT SEAL ADHESIVES
LADH300 LADH7350

Heat Seal adhesives are liquid, solvent-based adhesives that are typically roll coat applied. The adhesive is dried and then laminated at elevated temperatures to form the heat seal.

PRIMERS
L1007M

Bostik’s primer is designed to enhance the adhesive anchorage to metal, plastic, glass, wood, concrete and many other rigid and semi-rigid surfaces where adhesion can be difficult. It is applied to the substrate as a pretreatment to the adhesive application.

PRESSURE SENSITIVE ADHESIVES
LADH7527FR | LADH7560FR LADH7590

Bostik’s pressure sensitive liquid adhesives are self-crosslinking, solvent-based, acrylic adhesives. When dried at elevated temperatures, these adhesives form a crosslinked network that is capable of forming a bond when pressure is applied.

SUBSTRATE COMPATIBILITY

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Bostik FR web adhesives are flame retardant, hot-melt adhesives converted into a thin web like film. The weight of the web can be varied between 12 – 60 grams per square yard. These products offer superior adhesive usage control to manufacturers; preventing over-spray and waste from spray and film applications.

Bostik web adhesives offer the same usage control advantages to manufacturers as the flame retardant webs, without the flame retardancy for less stringent applications. The weight of the web can be varied between 12 – 100 grams per square yard.

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**POLYESTER ADHESIVE WEBS**

- **SPA145FR**: 293°F / 145°C
- **SPA110**: 220°F / 105°C
- **PA115**: 230°F / 110°C
- **SPA128**: 257°F / 125°C
- **PA145**: 285°F / 141°C
- **PE165**: 350°F / 177°C
- **PE120**: 284°F / 140°C
- **PE103**: 220°F / 105°C
- **PE85**: 200°F / 93°C

**POLYAMIDE ADHESIVE WEBS**

- **SPA145FR-A**: 293°F / 145°C
- **SPA110**: 220°F / 105°C
- **PA115**: 230°F / 110°C
- **SPA128**: 257°F / 125°C
- **PA145**: 285°F / 141°C
- **PA165**: 350°F / 177°C
- **PA120**: 284°F / 140°C
- **PE103**: 220°F / 105°C
- **PE85**: 200°F / 93°C

**APPLICATIONS**

- Composites: Bonding to Skin
- Composites: Lay-Up Aids
- Composites: Skin to Core
- Decoratives (Heat Activated)
- Heat Seal
- Layered Laminates
- Seating: Foam to Cover

**FLAME RETARDANT WEBS**

**NON FLAME RETARDANT WEBS**

**SUBSTRATE COMPATIBILITY**
## BMS Approvals
### SPECIFICATIONS

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
<th>UNIT OF MEASURE</th>
<th>BOSTIK PRODUCT NUMBER</th>
<th>TYPE OF PRODUCT</th>
<th>APPLICATIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>BMS 5-127G Type II &amp; III, Class 2</td>
<td>1-Gallon Kit</td>
<td>L7132K</td>
<td>Solvent-Based Adhesive</td>
<td>Decorative laminate bonding, edge wrapping and honeycomb core splicing</td>
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<td>BMS 5-14 – BAC 5010 Type 40</td>
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<td>Solvent-Based Adhesive</td>
<td>Thermo-acoustical insulation, cover film bonding, general purpose contact cement</td>
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<tr>
<td>BMS 8-254 Type IV - Low Heat Release Resin</td>
<td>60” x 120’</td>
<td>F10-651B</td>
<td>Film Adhesive</td>
<td>Embossing resin to hold texture in decorative structure; improves flammability and makes overall structure pass OSU; also used to bond decorative laminate to aluminum</td>
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<td>F15-789-5</td>
<td>Film Adhesive</td>
<td>Embossing resin to hold texture in decorative structure; coated on fiberglass and tougher resin system for use in high wear areas</td>
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Bostik, Inc.
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