



### PRODUCT DATA SHEET

# GillBOND™ Epoxy Adhesive Film

### **DESCRIPTION**

GillBOND™ A197 and A193 are 300°F (149°C) curing epoxy film adhesives formulated with flame retardant properties. Suitable for use in commercial and defense aerospace applications.

### **APPLICATIONS**

- · Aerospace grade film adhesive
- · Composite to composite bonding
- · Composite to metal bonding
- · Metal to metal bonding

### **FEATURES**

- · 300°F (149°C) curing temperature
- · Fire resistant
- · Excellent peel strength, flatwise tensile strength
- · Good thermal stability
- · Low tack allows for repositioning
- Service temperature to 180°F (82°C)

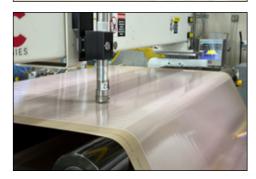
### **AVAILABILITY**

GillBOND™ Film Adhesive	A197	A193	
Nominal weight, psf (gsm)	0.030 (147)	0.060 (294)	
Color	Light Green	Blue	
Width, in (cm)	49 (125)		
Roll Lengths, yds (m)	10, 50 (9, 46)		
Carrier	Nylon Scrim		

### **CONSTRUCTION**

Adhesive: Epoxy film with nylon scrim carrier





### **HEALTH PRECAUTIONS**

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available at https://www.thegillcorp.com/msds.php.

For industrial use only. Keep away from children. Additional information can be found at: www.thegillcorp.com. For sales and order inginformation call 1-626-443-6094.

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### **CURE CYCLE**

Curing is recommended at 300°F (149°C), at least 15 psi (103 kPa), and cure time between 30-90 minutes.

Typical Cure Cycle:

- Apply at least 15 psi (103 kPa)
- Heat up to cure temperature at 2 5°F (1 3°C) per minute
- · Hold at cure temperature for at least 30 minutes
- Cool down under pressure to below 120°F (49°C)

### PERFORMANCE PROPERTIES, TYPICAL

Cure cycle of 300°F (149°C) for 90 minutes is used to generate Performance Properties.

ASTM	Property	Test Temperature °F (°C)	A197 0.03 psf (146 gsm)	A193 0.06 psf (293 gsm)	Substrate
D1002 Lap Shea psi (MPa	Lap Shear	-67 (-55)	3,475 (23.9)	3,534 (24.4)	0.063" 2024-T3 AI, 1" x 7" with 1" overlap
		75 (24)	3,483 (24.0)	3,527 (24.3)	
	psi (ivii a)	180 (82)	2,798 (19.3)	3,104 (21.4)	1 X7 Willi I Overlap
D1781	Metal to Metal CD Peel in-lb/in-width (N/25mm-width)	-67 (-55)	49 (218)	55 (245)	0.020" and 0.063" 2024- T3 Al, 3" x 12"
		75 (24)	58 (259)	63 (281)	
		180 (82)	68 (303)	74 (330)	
D1781	Honeycomb Sandwich CD Peel in-lb/3in-width (N/76mm-width)	-67 (-55)	27 (240.3)	54 (480.6)	Skin: 0.020" 2024-T3 Al Core: 2.2 MIL, 1/8", 8.5#, 5052, 3" x 12"
		75 (24)	38 (338.2)	69 (614.1)	
		180 (82)	36 (320.4)	70 (623.0)	
C297	Flatwise Tensile psi (MPa)	-67 (-55)	1,370 (9.4)	1,802 (12.4)	Skin: 0.020" AI 2024-T3 Core: 2.2 MIL, 1/8", 8.5#, 5052, 2" x 2"
		75 (24)	1,116 (7.7)	1,572 (10.8)	
		180 (82)	830 (5.7)	1,135 (7.8)	

Figures shown reflect typical values and should not be used as design specifications.

### STORAGE LIFE

Shelf life is from day of manufacture according to the storage temperatures listed below. Working life defines the time that is outside of storage temperature.

Storage Condition	A197 and A193	
Shelf Life at 0°F (-18°C)	2 years	
Shelf Life at 40°F (4°C)	6 months	
Working Life at 75°F (24°C)	15 days	

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All recommendations, statements, values and technical data herein are based on tests The Gill Corporation believes to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. Users shall rely on their own information and tests to determine suitability of the product for the intended use and assume all risks and liability resulting from their use of the product. The Gill Corporation's sole responsibility shall be to replace that portion of the product that proves to be defective. The Gill Corporation will not be liable to the buyer or any third person for any injury, loss or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements not contained in a written agreement signed by an officer of The Gill Corporation shall not be binding upon The Gill Corporation.

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