



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 (293)
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 information call 1-626-443-6094.





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 Shear psi (MPa)	-67 (-55)	3,475 (23.9)	3,534 (24.4)	0.063" 2024-T3 Al, 1" x 7" with 1" overlap
		75 (24)	3,483 (24.0)	3,527 (24.3)	
		180 (82)	2,798 (19.3)	3,104 (21.4)	
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" Al 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

Updated: 02/26/24

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