



Welux609A Epoxy Foil

WELUX 609A adhesive resin film is a toughened epoxy film designed to cure between 65 and 120°, allowing flexibility in component manufacture.

Key Features

Cure temperature - as low as 65°C
High service temperatures - up to 120°C after postcure
Low CTE and shrinkage
Work life at 20°C 21 days
Storage life at -18°C 12 months
Very low VOC content – no added solvents during manufacture.

Recommended Cure cycles

Initial cure 80°C at a ramp rate of up to 2°C and maintain for 16 hours under vacuum.
Post cure (where required for high Tg) 1 hour dwell at 120°C – maximum ramp rate of 20°C per hour.

Cure (°C)	Initial Min Cure (Hours)	Tg (°C)
65	16	65
80	5	75
100	2	100
Postcure at 120	1	120

Curing Schedule is meant to be a guide only and is subject to local conditions.

To avoid exotherm particular care must be taken with thick laminates.

Ramp rates must not exceed 3.0°C per minute during initial cure.

Ramp rates must not exceed 0,3°C per minute when postcuring.

Property	Value
Volatile content	<1.0%
Voidage	<1%
(Autoclave cure)	

Storage

The material should be kept frozen at -18°C. It must be kept in sealed plastic bags which must not be opened until fully thawed to room temperature.

Health and Safety

Refer to the product Safety Data Sheet before using this material.

The following precautions must be taken when using epoxy resin films:

Impervious gloves must be worn

Overalls must be worn

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