

## Foil adhesive KFL 120

### Description:

Letoxit KFL 120 structural film adhesive is an adhesive designed for high-strength bonds. It serves to adhesive bonding of metallic materials, in particular those of aluminium alloys, as well as many non-metallic materials. Especially it fits for manufacture of sandwich parts including honeycomb structures. The adhesive is one-component, based on modified epoxy resins, and contains suitable curing system. The adhesive is particularly useful for bonding of aircraft structures, transportation (both road and rail) and for other demanding applications.

### Curing:

The Letoxit KFL 120 adhesive is cured at 120-125°C for 60 minutes.

### Properties of cured bonded joint:

Shear strength

Loading temperature (°C)	Shear strength* (MPa)
-75	30 – 36
+20	36 – 41
+60	35 – 38
+80	26 – 37
+100	25 – 35

\*CSN 66 8510, DIN 53 283, ASTM D 1000-72

Peel strength

Loading temperature (°C)	Peel strength	Tested according to standard
+20	4 – 7 N/mm	CSN 668516, DIN 53 282, ISO TC 61/SC11, ASTM D 1876-72
+20	280 N	DIN 53289, ISO TC 61 2144E
+20	9,6 N/mm	DIN 53 295

### References:

AERO L39 ALBATROS  
L 420  
L 610  
Z 142  
LARUS



5M s.r.o.  
Na Záhonech 1177  
686 04 Kunovice  
Czech Republic

Development ■ Production ■ Sales ■ Consultancy

tel.: +420 572 433 711  
fax: +420 572 433 700  
e-mail: 5M@5M.cz  
www.5M.cz