



3M™ Scotch-Weld™ Structural Adhesive Film AF 191

is a family of thermosetting modified epoxy structural adhesives in film form that are available in a variety of weights and carriers.

3M™ Scotch-Weld™ Structural Adhesive Film AF 191 is a proven adhesive film with excellent mechanical properties. Scotch-Weld AF 191 Films delivers years of industry success and proven performance for over 30 years, backed by 3M's technical service and support.

- **High fracture toughness and peel strength**
- **350°F (177°C) Cure – Excellent long-term elevated temp properties**
- **Available unsupported for reticulation**
- **Available with copper mesh for lightning strike surfacing**

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| Structure | Product | Color | Film Weight (± .005 lb/ft²) | Film Weight (± 24.4 g/m²) | Film Thickness (mils) | Recom. Cure Temp | Recom. Cure Time | Volatile Content | Size | Stock Number |
|-------------|---------|-------------|--------------------------------|------------------------------|--------------------------|---------------------|---------------------|----------------------|---------------------------------|----------------|
| Unsupported | AF 191U | Clear | 0.055 | 244 | 8 | 350°F (177°C) | 1 Hour | Less than 1.5% | 36in x 3yds | 62-3072-5306-2 |
| | | | | | | | | | 36in x 50yds | 62-3072-5309-6 |
| | AF 191U | Clear | 0.035 | 170 | 6 | | | | 36in x 3yds | 62-3053-5306-2 |
| | | | | | | | | | 36in x 50yds | 62-3053-5309-6 |
| | AF 191U | Clear | 0.015 | 73 | 2.5 | | | | 48in x 3yds | 62-3068-6006-5 |
| | | | | | | | | | 48in x 36yds | 62-3068-6005-7 |
| Matte Scrim | AF 191M | Pale Yellow | 0.060 | 293 | 10 | 350°F (177°C) | 1 Hour | Less than 1.5% | 36in x 3yds | 62-2608-5305-6 |
| | | | | | | | | | 36in x 50yds | 62-2608-5301-5 |
| | AF 191M | Amber | 0.035 | 170 | 6 | | | | 36in x 3yds | 62-3151-5306-4 |
| | | | | | | | | | 36in x 50yds | 62-3151-5309-8 |
| | AF 191M | Amber | 0.030 | 146 | 5 | | | | 36in x 3yds | 62-2707-5306-4 |
| | | | | | | | | | 36in x 50yds | 62-2707-5309-8 |
| Knit Scrim | AF 191K | Clear | 0.100 | 488 | 16 | 350°F (177°C) | 1 Hour | Less than 1.5% | 36in x 3yds | 62-3142-5306-3 |
| | | | | | | | | | 36in x 50yds | 62-3142-5309-7 |
| | AF 191K | Amber | 0.080 | 390 | 13 | | | | 36in x 3yds (Lt Green Liner) | 62-3384-5305-3 |
| | | | | | | | | | 36in x 50yds (Yellow Liner) | 62-3384-5309-5 |

Get what you need, when you need it...

Contact your 3M Aerospace Sales Representative for more information on:

- Other sizes available
- Low MOQs
- 30-day lead times on many adhesive films

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60-9700-0304-6