



AEROSPACE MATERIAL SPECIFICATION

AMS6885™/4

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Unidirectional Carbon Fiber Tape Epoxy Repair Prepreg, Vacuum Curing Part 4 - Purchasing Specification for Film Adhesive

RATIONALE

Provide a unidirectional carbon fiber tape epoxy prepreg capable of curing under vacuum for repair of carbon fiber reinforced epoxy structures. The prepreg system includes a film adhesive to be applied in a co-bonding process with the prepreg for solid laminate and sandwich bonding. AMS6885/4 is the purchasing specification for the film adhesive.

AMS6885/4 has been reaffirmed to comply with the SAE Five-Year Review policy.

A reaffirmed status is given to technical reports that have been reviewed by the technical committee and deemed to be current with no need for immediate revision. No changes have been made to this document as a result of this review.

FOREWORD

This Purchasing Specification (PS), AMS6885/4, belongs to the Technical Specification system explained in AMS6885.

TABLE OF CONTENTS

1.	SCOPE.....	3
1.1	Limitation	3
2.	APPLICABLE DOCUMENTS	3
2.1	SAE Publications.....	3
2.2	PRI Publications.....	3
2.3	Other Publications.....	3
2.4	Definitions	3
3.	REQUIREMENTS	4
3.1	Defects	4
4.	RELEASE TESTING	4
4.1	General.....	4
4.2	Release Testing	4
4.3	Release Test Certificate.....	5
4.3.1	Physical and Chemical Tests	6
4.3.2	Mechanical Tests	6
4.3.3	General.....	6
4.4	Retest.....	6
4.5	Rejection	6
4.6	Warranty.....	7
4.7	Audit	7
4.8	Sampling	7
4.8.1	Sampling for Mechanical Tests	7
4.8.2	Sampling for Physical and Chemical Tests.....	7
5.	STORAGE LIFE EXTENSION	7
5.1	Storage Life Extension Tests and Requirements	8
5.2	Acceptable Storage Life Extension	8

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Documents

Standard Sharing Hub

5.3	Extension Test Records	9
6.	PREPARATION FOR DELIVERY	9
6.1	Packing.....	9
6.1.1	General.....	9
6.1.2	Film Adhesive Rolls and Kits	9
6.1.3	Size of Film Adhesive Rolls and Kits	9
6.1.4	Support Tube	10
6.2	Marking.....	10
6.2.1	Film Adhesive Rolls.....	10
6.2.2	Film Adhesive Kits.....	10
6.2.3	Defects	10
6.2.4	Marking for Shipment	10
6.3	Shipment	11
6.3.1	Storage Before Shipping	11
6.3.2	Delivery Date Responsibility	11
6.3.3	Shipping Conditions	11
6.3.4	Shipping Condition Verification	11
7.	RECEIPT OF MATERIAL.....	12
8.	HEALTH, SAFETY, AND ENVIRONMENT.....	12
9.	NOTES	12
9.1	Revision Indicator.....	12
Table 1	Batch release tests for uncured film adhesive - physical and chemical properties	4
Table 2	Batch release tests for cured film adhesive - mechanical properties	5
Table 3	Number of rolls to be tested per batch.....	7
Table 4	Tests and requirements for storage life extension.....	8
Table 5	Acceptable storage life extension	8

1. SCOPE

This Purchasing Specification, AMS6885/4, specifies the batch release and delivery requirements for film adhesive used for repair. This specification is applicable only when the film adhesive is used as part of the repair system defined in AMS6885 and AMS6885/1.

This specification also defines the procedure and requirements for storage life extension of materials purchased against this specification. It is only applicable for materials qualified against AMS6885 (refer to PRI-QPL-AMS6885), and shall be carried out within the responsibility of the purchaser and under control of its Quality organisation.

1.1 Limitation

This specification relates to qualified film adhesive listed in the associated PRI-QPL-AMS6885.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), www.sae.org.

AMS6885	Unidirectional Carbon Fiber Tape Epoxy Repair Prepreg, Vacuum Curing, Part 0 - Introduction
AMS6885/1	Unidirectional Carbon Fiber Tape Epoxy Repair Prepreg, Vacuum Curing, Part 1 - General Requirements
AMS6885/5	Unidirectional Carbon Fiber Tape Epoxy Repair Prepreg, Vacuum Curing, Part 5 - Material Specification for Unidirectional Carbon Fiber Tape Epoxy Prepreg for Repair and Film Adhesive for Repair, 120 to 145 °C (250 to 290 °F) Curing

2.2 PRI Publications

Available from Performance Review Institute, 161 Thorn Hill Road, Warrendale, PA 15086-7527, Tel: 724-772-1616, www.pri-network.org.

PRI-QPL-AMS6885 Performance Review Institute - Qualified Products List of AMS6885

Individual Product Sheets (IPS) of Qualified Products, Appendix to PRI-QPL-AMS6885

2.3 Other Publications

Refer to Section 2 of AMS6885/1 for reference to all other documents listed within this part specification.

2.4 Definitions

Refer to AMS6885/1.

3. REQUIREMENTS

The film adhesive to be delivered shall meet the general requirements in accordance with AMS6885/1 and the requirements of this PS and the relevant IPS.

3.1 Defects

Refer to AMS6885/1 for defect definitions and limits applicable to film adhesive rolls and kits and to [6.2.3](#) for defect marking.

4. RELEASE TESTING

4.1 General

Products shall be manufactured in accordance with the manufacturing schedule of qualification and revisions agreed to by the CACRC-QPG. The relevant revision number and date of the manufacture schedule are specified in the relevant IPS of the material to be purchased.

4.2 Release Testing

Release testing shall consist of the tests given in [Tables 1](#) and [2](#), unless otherwise agreed between the manufacturer and the CACRC-QPG and specified in the relevant IPS. The test results shall demonstrate compliance with the technical requirements of this PS and the relevant MS and IPS.

Release testing shall be the responsibility of the manufacturer. The test samples extracted should be representative of the entire film adhesive batch delivered in accordance with this specification. See [4.8](#) for the number of samples required based on the size of the batch.

The purchaser reserves the right to perform any of the inspections and/or tests required by this specification and may reject any material which fails to meet the requirements. The purchaser and/or the CACRC-QPG reserve the right to witness manufacture and/or testing following warranty claims or qualification (refer to AMS6885/1 and AMS6885/2).

Table 1 - Batch release tests for uncured film adhesive - physical and chemical properties

No.	Property	Number of Samples Per Roll ⁽¹⁾	Test Method
1.1	Mass per Unit Area	3	AMS6885/1 and relevant IPS
1.2	Volatile Content ⁽²⁾	3	
1.3	Adhesive Flow ⁽²⁾	3	
1.4	DSC - Uncured	3	
1.5	HPLC ⁽²⁾	3	
1.6	Infrared Spectroscopy ⁽²⁾	3	
1.7	Viscosity ⁽²⁾ Dynamic 2 °C/min	3	

⁽¹⁾ Number of rolls to be tested is dependent on the batch size and is defined in [4.8](#).

⁽²⁾ Specific test parameters to be agreed at the onset of the screening and qualification program between the manufacturer and the CACRC-QPG and specified in the relevant IPS.

NOTE:

Test results shall meet the requirements specified in the relevant IPS.