

# L-303 (LHR)

## Modified Epoxy Film Adhesive



851 W. 18<sup>th</sup> Street  
Costa Mesa, CA 92627  
(949) 650-8106 Fax: (949) 631-6190  
[www.jdlincoln.com](http://www.jdlincoln.com)

### Product Data Sheet

Revised: 3/18/09

#### Description

L-303 (LHR) is a 250°F (121°C) curing, modified epoxy film adhesive designed to enhance the flame retardance of aircraft interior structures. L-303 (LHR) provides excellent strength over a wide range of processing cycles, and is suitable to rapid 'in-hot / out-hot' cure cycles in heated platen presses.

#### Advantages of L-303 (LHR)

- ❖ Cure cycles as low as 235°F (113°C), varying heat-up rates, vacuum or positive pressure may be used without a significant reduction in bond joint strength.
- ❖ Low volatile content makes L-303 (LHR) ideally suited for large area sandwich or metal to metal sections.
- ❖ L-303 (LHR) displays excellent environmental resistance to salt spray, high humidity, and standard test fluids.

#### Physical Properties

- *Standard Weight:* 0.080 lbs/ft<sup>2</sup> (390 g/m<sup>2</sup>)
- *Optional Weights:* 0.100 lbs/ft<sup>2</sup>, 0.120 lbs/ft<sup>2</sup> (other weights available)
- *Standard Thickness:* 0.012" (0.30 mm)
- *Volatile Content:* Less than 0.5%
- *Tack:* Slightly Tacky

#### Availability

- 48" Wide Rolls x 100 Yards Long (122 cm x 91 m)

#### Shelf Life

- 6 months at 40°F (4°C)
- 7 days at Room Temperature (70°F or 21°C)

#### Cure Cycles

- 40 minutes at 275°F (135°C), or
- 60 minutes at 250°F (121°C), or
- 90 minutes at 235°F (113°C).



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## Applicable Documents

- *MMM-A-132*
- *MIL-A-25463*

## Adhesive Primers

L-303 (LHR) is compatible with:

- *L-309 Corrosion Inhibiting Primer*
- *L-312 Adhesive Primer*
- *L-319-1 Corrosion Inhibiting Adhesive Primer*

## Average Mechanical Properties

PROPERTY	0.080 PSF (390 GSM) FILM	
	25 PSI (0.172 MPa) CURE	TEST METHOD
<b>TENSILE SHEAR STRENGTH</b> -67°F (-55°C) ROOM TEMP 180°F (82°C)	4,200 PSI (28.9 MPa) 4,200 PSI (28.9 MPa) 3,700 PSI (25.5 MPa)	MMM-A-132 MMM-A-132 MMM-A-132
<b>SANDWICH PEEL STRENGTH</b> -67°F (-55°C) ROOM TEMP 180°F (82°C)	6 in lb/in (26.7 Nm/m) 6 in lb/in (26.7 Nm/m) 5 in lb/in (22.3 Nm/m)	MIL-A-25463 MIL-A-25463 MIL-A-25463
<b>FLATWISE TENSILE STRENGTH</b> -67°F (-55°C) ROOM TEMP 180°F (82°C)	875 PSI (6.0 MPa) 900 PSI (6.2 MPa) 850 PSI (5.9 MPa)	MIL-A-25463 MIL-A-25463 MIL-A-25463
<b>FLEXURAL STRENGTH</b> -67°F (-55°C) ROOM TEMP 180°F (82°C)	2,500 PSI (17.2 MPa) 2,500 PSI (17.2 MPa) 2,050 PSI (14.1 MPa)	MIL-A-25463 MIL-A-25463 MIL-A-25463

### NOTICE:

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