

L-303 (LHR)

Modified Epoxy Film Adhesive



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Product Data Sheet

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/ft² (390 g/m²)
- *Optional Weights:* 0.100 lbs/ft², 0.120 lbs/ft² (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).

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
TENSILE SHEAR STRENGTH		
-67°F (-55°C)	4,200 PSI (28.9 MPa)	MMM-A-132
ROOM TEMP	4,200 PSI (28.9 MPa)	MMM-A-132
180°F (82°C)	3,700 PSI (25.5 MPa)	MMM-A-132
SANDWICH PEEL STRENGTH		
-67°F (-55°C)	6 in lb/in (26.7 N/25 mm)	MIL-A-25463
ROOM TEMP	6 in lb/in (26.7 N/25 mm)	MIL-A-25463
180°F (82°C)	5 in lb/in (22.3 N/25 mm)	MIL-A-25463
FLATWISE TENSILE STRENGTH		
-67°F (-55°C)	875 PSI (6.0 MPa)	MIL-A-25463
ROOM TEMP	900 PSI (6.2 MPa)	MIL-A-25463
180°F (82°C)	850 PSI (5.9 MPa)	MIL-A-25463
FLEXURAL STRENGTH		
-67°F (-55°C)	2,500 PSI (17.2 MPa)	MIL-A-25463
ROOM TEMP	2,500 PSI (17.2 MPa)	MIL-A-25463
180°F (82°C)	2,050 PSI (14.1 MPa)	MIL-A-25463

NOTICE:

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