

# L-303

## Film Adhesive, Flame Retardant



851 W. 18<sup>th</sup> Street  
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(949) 650-8106 Fax:(949) 631-6190  
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### Product Data Sheet

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#### Description

L-303 is a 250°F (121°C) curing, high peel strength, flame retardant, modified epoxy film adhesive. L-303 is intended to be used for structural bonding of aluminum, fiberglass, aramid, and other structural materials to themselves and to various types of core materials such as aluminum, aramid/phenolic, PVC foam, and paper for sandwich construction.

#### Advantages of L-303

- ❖ The high peel strength and high toughness of L-303 allow the designer to use this material in high abuse areas such as aircraft interiors, cargo systems, marine structural bulkheads, etc.
- ❖ L-303 is very easy to process through a wide variety of cure temperatures and pressures. Curing may occur in autoclave, press, or vacuum bag from 90 minutes at 235°F (113°C) or in just 40 minutes at 275°F (135°C) with contact pressure (235°F temperatures are recommended for urethane or PVC core).
- ❖ With dry subcomponents, 'in-hot / out-hot' press cycles may be developed by the user.

#### Physical Properties

- *Standard Weight:* 0.060 lbs/ft<sup>2</sup> (292 g/m<sup>2</sup>)
- *Optional Weights:* 0.030 lbs/ft<sup>2</sup>, 0.045 lbs/ft<sup>2</sup>, 0.075 lbs/ft<sup>2</sup>, 0.090 lbs/ft<sup>2</sup>
- *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)
- 5 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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## Adhesive Primers

L-303 is compatible with:

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

## Applicable Documents

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

## Average Mechanical Properties

PROPERTY	0.060 PSF (292 GSM) FILM		
	25 PSI (0.172 MPa) CURE	VACUUM BAG CURE	TEST METHOD
<b>TENSILE SHEAR STRENGTH</b>			
-67°F (-55°C)	5,400 PSI (37.2 MPa)	5,000 PSI (34.5 MPa)	MMM-A-132
ROOM TEMP	5,200 PSI (37.2 MPa)	5,100 PSI (35.2 MPa)	MMM-A-132
180°F (82°C)	3,100 PSI (21.3 MPa)	2,800 PSI (19.3 MPa)	MMM-A-132
<b>SANDWICH PEEL STRENGTH</b>			
-67°F (-55°C)	9 in lb/in (40.1 Nm/m)	-	MIL-A-25463
ROOM TEMP	14 in lb/in (62.3 Nm/m)	14 in lb/in (62.3 Nm/m)	MIL-A-25463
180°F (82°C)	14 in lb/in (62.3 Nm/m)	-	MIL-A-25463
<b>FLATWISE TENSILE STRENGTH</b>			
-67°F (-55°C)	1,200 PSI (8.3 MPa)	-	MIL-A-25463
ROOM TEMP	1,150 PSI (7.9 MPa)	1,050 PSI (7.2 MPa)	MIL-A-25463
180°F (82°C)	850 PSI (5.9 MPa)	-	MIL-A-25463
<b>FLEXURAL STRENGTH</b>			
-67°F (-55°C)	2,000 PSI (13.8 MPa)	-	MIL-A-25463
ROOM TEMP	2,400 PSI (16.5 MPa)	2,200 PSI (15.2 MPa)	MIL-A-25463
180°F (82°C)	1,900 PSI (13.1 MPa)	-	MIL-A-25463

### NOTICE:

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