

L-306 FRHT

Core Edge Filler, Two-component



851 W. 18th Street
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Product Data Sheet

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Description

L-306 FRHT is a medium weight, room-temperature curing, flame retardant core edge filler. L-306 FRHT is easily applied with a trowl or spatula in honeycomb core rebate areas for closing out sandwich panels to help prevent mechanical damage to fragile honeycomb cells and to resist moisture penetration. L-306 FRHT is thixotropic and exhibits excellent non-slump / non-sag characteristics. L-306 FRHT does not damage panels due to expansion or exotherm during cure. L-306 FRHT is formulated for improved flame retardance and high temperature performance.

Advantages of L-306 FRHT

- ❖ Excellent handling performance makes L-306 FRHT a true champion in the shop. Edging, filling, smoothing, and clean-up are very easy to accomplish due to the superior workability of L-306 FRHT.
- ❖ Low density of L-306 FRHT compliments lightweight composite structures.

Physical Properties

- *Color Part A:* Yellow
- *Color Part B:* Cream
- *Color Mixed:* Yellow
- *Density:* 45 lbs/ft³ (0.7 g/mL)
- *Form:* Thixotropic Paste

Availability

- 1 Gallon (3.8 L) Kit
- 5 Gallon (18.9 L) Kit



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Mix Ratio and Pot Life

- *Mix 100 Parts A to 25 Parts B by weight*
- *Pot Life at 75°F (24°C) (500 gram mass): 20 minutes*

Shelf Life

- *12 months at Room Temperature (70°F or 21°C)*

Cure Cycles

- *Handling Strength: 4 hours at Room Temperature (70°F or 21°C)*
- *Full Cure: 24 hours at Room Temperature (70°F or 21°C)*
- *Accelerated Cure: 60 minutes at 150°F (65°C)*

Average Mechanical Properties

Compressive Strength (ASTM D 695)

- *-67°F (-55°C) 7000 PSI (48.3 MPa)*
- *RT 6000 PSI (41.4 MPa)*
- *160°F (71°C) 2000 PSI (13.8 MPa)*

Overlap Tensile Strength (ASTM D1002)

- *RT 1600 PSI (11.0 MPa)*

CAUTION: Care should be taken with batches over 500 grams total weight. Large batches or those which are mixed in excess of recommended ratios may become exothermic (i.e., VERY HOT). The user is encouraged to develop standard batch mix sizes.

NOTICE:

Product data and parameters cited in this publication have been obtained in J.D. Lincoln, Inc. laboratories using the materials under carefully controlled conditions. The information, therefore, is believed to be accurate and correctly stated. Data of this type may be considered to be indicative of representative properties obtainable. J.D. Lincoln, Inc. cannot accept responsibility for the misapplication of these products, nor for their use under uncontrolled conditions. Numerical values resulting from the application of this material are dependant on processing details. It is recommended that the user develop his or her own application techniques and generate data consistent with his or her specific application and process.



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