

L-310

“Bond-Aid” Film Adhesive



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Product Data Sheet

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Description

L-310 is a modified phenolic film adhesive that improves the peel strength of a B-stage phenolic prepreg when bonded to honeycomb core materials. Designed for either vacuum or platen press cure cycles, the adhesive film is placed directly between the honeycomb core and the uncured phenolic facing plies. L-310 is co-cured with the prepreg during the normal phenolic prepreg cure cycle.

Advantages of L-310

- ❖ A single 0.002" (0.05 mm) thick film of “Bond-Aid” increases the peel strength of a phenolic honeycomb bond by up to five times with no significant increase in flammability or smoke emission. The most dramatic improvement is seen with a single ply of style 7781 or style 120 fabric prepreg.
- ❖ An excellent thermosetting adhesive in its own right, “Bond-Aid”, may also be used for bonding cured facesheets to the surface of phenolic aramid honeycomb or as an adhesive for bonding decorative laminates to either B-stage or C-stage phenolic composite laminates.
- ❖ L-310 is room-temperature stable which eliminates the need for refrigeration.

Physical Properties

- *Standard Weight:* 0.009 lbs/ft² (44 g/m²) (Other weights are available)
- *Standard Thickness:* 0.002" (0.05 mm)
- *Color:* Light Blue
- *Carrier:* None
- *Tack:* Flexible, Tack-Free Film



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Availability

- *Standard Roll Size: 50" Wide Rolls x 160 Yards Long (127 cm x 146 m)*
- *Available up to 61.5" Wide Rolls up to 200 Yards Long (156 cm x 183 m)*

Shelf Life

- *6 months at Room Temperature (75°F or 24°C)*

Cure Conditions

- *60 minutes at 260-280°F (127-138°C), 15 PSI (0.10 MPa) Minimum*
- *L-310 will co-cure with most phenolic prepregs*
- *Curing may be accomplished with a wide variety of cure temperatures and heat-up rates.*

Flammability

- *Self Extinguishing per FAR Part 25.853*

Sandwich Properties

Core: Aramid / phenolic honeycomb, 1/8" cell, 3 PCF density (3.1 mm cell, 48 kg/m³).

Facesheets: 1 ply each side 'B-Stage' phenolic prepreg style 7781 fiberglass fabric.

- *Room Temperature Sandwich Peel Strength: 6-10 in lb /in (27-45 Nm/m)*

NOTICE:

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