

L-397

Phenolic Surfacing Film



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Product Data Sheet

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Description

L-397 is a phenolic-based surfacing film designed to be co-cured or post-cured with phenolic prepregs to improve the surface finish of composite parts. L-397 is formulated to adapt to most phenolic systems and can be applied to the surface of fiberglass, carbon, or aramid fabrics, woven or unidirectional. L-397 is appropriate for finishing surfaces on honeycomb sandwich structures as well as on laminated or layered parts.

Advantages of L-397

- ❖ The high strength and high toughness of L-397 allows the designer to use this material in high abuse areas such as aircraft interiors, cargo systems, marine structural bulkheads, etc.
- ❖ After cure, L-397 is paint-ready and sandable (if necessary for finish).
- ❖ L-397 is formulated to meet both OSU heat release and smoke density and the FAA's 12" and 60" vertical flammability standards for aircraft interiors.
- ❖ The weight and tack of L-397 can be tailored to meet specific customer needs so that the most efficient process is used and the best possible parts are made.

Physical Properties

- *Standard Weight:* 0.030 lbs/ft² (146 g/m²)
- *Optional Weights:* 0.020 lbs/ft², 0.045 lbs/ft², 0.060 lbs/ft² (other weights available)
- *Standard Thickness:* 0.004" (0.102 mm)
- *Volatile Content:* Less than 20%
- *Tack:* Medium to High
- *Appearance:* Cream to Light-Pink Film

Metallic Mesh and Support Scrim

- L-397 is available pre-consolidated with a variety of scrims and metallic mesh materials.

Availability

- 50" or 60" Wide Rolls x 60 Yards Long (127 cm or 152 cm x 55 m)

Shelf Life

- Storage Life: 6 months at 0°F (-18°C)
- Lay Up Life: 5 days at Room Temperature (75°F or 24°C)
- Curable Work Life: 10 days at Room Temperature (75°F or 24°C)

Recommended Cure Cycle

Oven, Autoclave, or Press:

- 1) Debulk individual layers if possible (N/A for Press Cycle)
- 2) Apply vacuum at RT (75°F or 24°C) (For Press Cycle, instead apply 40 PSI / 0.275 MPa)
- 3) Ramp at 5-8°F / minute (2.5-4.5°C / minute) to 285°F (141°C)
- 4) Hold for 60 minutes at 285°F (141°C)
- 5) Cool to 120°F (49°C) or below, release pressure
 - Alternatively use 40 minutes at 300°F (149°C) or 15 minutes at 315°F (157°C)

Prepreg Compatibility

L-397 is compatible with:

- L-591 / 791 / 991
- L-526 / 726 / 926
- L-528 / 728 / 928
- Other systems may be compatible (shop trial will determine compatibility)

NOTICE:

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