



PRODUCT DATA SHEET

LC-E232FR
250° Flame Retardant
Foaming Film Adhesive

Description

LC-E232FR is a 250°F (121°C) flame retardant foaming epoxy film adhesive specifically designed for splicing honeycomb or pre-bonding honeycomb to various materials. LC-E232FR is supplied as an unsupported film at approximately .050" thick with an expansion rate of 2-3 times its original thickness.

Advantages

LC-E232FR can be cured with most 250° F (121° C) to 350° F (176° C) systems. LC-E232FR is designed to evenly transfer load(s) from one section of core to the other while filling the void between exterior skin facings when applicable.

Physical Properties

Density: 1.01 G/cm3 per ASTM D792
Gel Time @ 275°F (135°C): 5 -7 minutes
Standard Thickness: .050"
Color: Cream
Tack: Medium

Shelf Life/Out Life/Storage

Shelf Life: 6 months from Certification Date
Out Life: 7 days @ 70°F (21°C)
Storage Temp: 40° F or below

Processing/Cure Cycle Recommendations

LC-E232FR can be processed at temperatures from a 250°F (121°C) cure for 60 minutes to a 350°F.(176°C.) cure for 20 minutes. A 250°F (121°C) cure for 60 minutes is optimal in most cases.

Mechanical Properties				
Property	Tested per Specification	-67 °F	R.T. (75 °F)	160 °F
Core Shear (psi)	MMM-A-132	N/A	780	N/A
Tube Shear Strength (psi)	ASTM E990-13 QAP 91	N/A	2200	2400
Tube Shear Strength (14 days exposure @ RT) (psi)	ASTM E990-13 QAP 91	N/A	2100	N/A

Flammability Properties		
12 Second Vertical	Tested per Specification	
Extinguishing time (seconds)	Part 25 Appendix F	Pass
Burn length (inches)	Part 25 Appendix F	Pass
Drip Extinguishing Time (seconds)	Part 25 Appendix F	Pass

*Tests performed using LC-E232FR @ .050" thick

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