



# PRODUCT DATA SHEET

**LC-E220**  
**250 Degree Curing**  
**Epoxy Film Adhesive**

### Description

LC-E220 is a 250°F (121°C) epoxy film adhesive specifically designed for bonding metal to metal or metal to various core materials.

### Advantages

LC-E220 demonstrates excellent adhesion and toughness throughout various cure cycles using both press and vacuum bag curing. LC-E220 exhibits excellent resistant's to humidity as well as a variety of test fluids. LC-E220 can also be supplied both supported and unsupported in multiple weight and thicknesses.

### Physical Properties

Density: 1.2 G/cm<sup>3</sup> per ASTM D792  
Gel Time @ 275°F (135°C): 4-6 minutes  
Glass Transition Temperature (T<sub>g</sub>): 218°F (103°C)  
Color: Cream  
Tack: Medium

### Shelf Life/Out Life/Storage

Shelf Life: 6 months from Certification Date  
Out Life: 14 days @ 70°F (21°C)  
Storage Temp: 40° F or below

### Processing/Cure Cycle Recommendations

LC-E220 can be processed at temperatures from 235°F. (113°C.) for 90 minutes to 290°F. (143°C.) for 40 minutes, using low, medium or high pressure. A 250°F (121°C) cure for 60 minutes is optimal in most cases using press, vacuum bag or autoclave processing with 25 psi pressure.

<b>Mechanical Properties</b>				
<b>Property</b>	<b>Tested per Specification</b>	<b>-67 °F</b>	<b>R.T. (75 °F)</b>	<b>180 °F</b>
<b>Tensile Shear (psi)</b>	MMM-A-132	3950	4775	3700
<b>Sandwich Peel Strength (inch lbs. / 1" width)</b>	Mil-A-25463	11.2	16.7	20.4
<b>Flatwise Tension (psi)</b>	Mil-A-25463	1085	1305	935
<b>Flexural Strength (lbs)</b>	Mil-A-25463	2560	2615	2185

\*Tests performed using LC-E220M (supported) .060 psf, press cured @ at 250° F, 25 psi pressure.

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