



PRODUCT DATA SHEET

LC-E225

250 Degree Curing Toughened
High Peel Epoxy Film Adhesive

Description

LC-E225 is a 250°F (121°C) toughened, high peel, epoxy film adhesive specifically designed for bonding metal to metal or metal to various core materials while maintaining excellent peel strength.

Advantages

LC-E225 demonstrates excellent adhesion and toughness using press, vacuum bag or autoclave processing. The wide range of cure cycles allows LC-E225 to exhibit higher elongation thus increased compatibility with numerous metallic materials. LC-E225 can also be supplied both supported and unsupported in multiple weights and thicknesses.

Physical Properties

Density: 1.2 G/cm³ per ASTM D792
Gel Time @ 275°F (135°C): 4 -5 minutes
Glass Transition Temperature (T_g): 230°F (110°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-E225 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.

Mechanical Properties				
Property	Tested per Specification	-67 °F	R.T. (75 °F)	180 °F
Tensile Shear (psi)	MMM-A-132	5150	5050	3600
Sandwich Peel Strength (inch lbs. / 1" width)	Mil-A-25463	8.4	13.8	13.6
Flatwise Tension (psi)	Mil-A-25463	1070	1210	890
Flexural Strength (lbs)	Mil-A-25463	2640	2660	2150

*Tests performed using LC-E225M (supported) .060 psf, press cured @ at 250° F, 25 psi pressure.

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