



FA EP255SP Epoxy Film Adhesive

FA EP255SP is 250°F curing, modified epoxy film adhesive that is designed for use in a variety of bonding applications such as metal to metal, metal to composite, composite to composite, composite to core or metal to core. Sandwich constructions suitable for this adhesive include aramid, aluminum and various foams. Cure temperatures as low as 235°F can be utilized, allowing the use of temperature sensitive skins and cores. Autoclave, oven or press molding operations are applicable.

Physical and Mechanical Properties

Climbing Drum Peel Strength, in-lb/in	17
Tack	Slight
Release Liner	Beige Poly
Standard Areal Weight, psf (others available)	0.06
Standard Carrier (others available)	Non-woven

Note: Mechanical property data generated per MIL-A-25463B using aluminum skins and honeycomb.

PROCESS INFORMATION

Vacuum Bag in Autoclave Cycle

- Draw Vacuum and apply 25-50 psi autoclave pressure
- 5°F/minute ramp to 235°F to 275°F
- Hold at 235°F to 275°F for 60 to 90 Minutes
- Cool to less than 180°F at 3 to 5°F/Minute
- Release pressure/vacuum and de-mold

Vacuum Bag in Oven Cycle

- Draw Vacuum
- 5°F/minute ramp to 175°F (Optional)
- Hold for 30 to 45 minutes (Optional)
- 5°F/minute ramp to 235°F to 275°F
- Hold at 235°F to 275°F for 90 to 120 Minutes
- Cool to less than 180°F at 3 to 5°F/Minute
- Release vacuum and de-mold

Press Cycle

- 60 to 90 minutes at 235°F to 275°F, 25 to 50 psi

Note: Temperatures are verified via implanted thermocouple

RECOMMENDED STORAGE

77°F	1 week
40°F	6 months
0°F	12 months

NOTE: FA 255SP Film Adhesive is wound with a polyethylene film liner for easy release. The rolls are sealed in polyethylene film bags to protect prepreg from moisture and other contaminants. The bags should remain sealed while the prepreg is under refrigeration and only removed when the prepreg has had sufficient time to warm to room temperature. When not in use, the prepreg should be returned to refrigerated storage. Care should be exercised to limit out-time of the prepreg in order to insure maximum shelf life. Torn bags should be replaced. The data presented herein has been developed under controlled manufacturing and test conditions and is considered accurate. No warranty is expressed or implied regarding the accuracy or use of this data or the use of this product. It is the responsibility of the end user to determine suitability for use.

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