



## EP255FA Epoxy Film Adhesive

EP255FA is a 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.

Climbing Drum Peel Strength, in-lb/in	9 to 12
Flat-wise Tensile Strength, psi	475 to 550
Short Beam Flexural Shear Strength, lbs	1,900 to 2,400
60 Second Vertical Ignition	Pass
Tack	Slight
Release Liner	Red 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 - EP255 Film Adhesive

#### Autoclave Cycle

Draw Vacuum and apply 25-50 psi autoclave pressure  
5° F/minute ramp to 235° F to 255° F  
Hold at 235° F to 255° 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 - 255° F  
Hold at 235° F - 255° 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

### Recommended Storage

- Room Temperature (77° F)	One (1) Week
- 40° F	Six (6) Months
- 0° F	Twelve (12) Months

**NOTE:** EP255 Film Adhesive is wound with a polyethylene film release 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.

NOTE: 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.