LC193/H840

LC193 and H840 are manufactured from the same resin base. LC193 is the low temperature cure version for applications where fire resistance and bonding to honeycomb are required. H840 is designed for use in molding thick laminates for applications such as fire resistant and ballistic armor panels. LC193 offers fair adhesion properties over a wide range of cure/laminating conditions. LC193 is self-extinguishing, and meets flammability requirements for use in aircraft interiors. H840 offers low void content.

Properties of LC193-7781

Flexural Strength, psi	72,000
Flexural Modulus, psi	3,000,000
Tensile Strength, psi	64,000
Tensile modulus, psi	3,400,000
Tensile Strain at Failure	1.7%
Compressive Strength, psi	65,000
Compressive Modulus, psi	3,500,000
Interlaminar Shear Strength, psi	6,200
OSU, Peak Heat Release Rate, kW/m^2	16 - 26
OSU, Total Heat Release Rate, $kW\text{-}min/ m^2$	15 - 27

PROCESS INFORMATION – LC193

Autoclave - One hour at 260°F to 280°F at 40 to 60 psi
Press - 30 to 60 minutes at 260°F to 280°F at 40 to 60 psi
Vacuum Bag - One hour at 260°F to 280°F

PROCESS INFORMATION – H840

Autoclave - 310°F to 320°F at 45 to 65 psi.
Press - 310°F to 320°F at 60 to 80 psi
Cycle time for thick laminates

Thickness less than .120 inch: 35 to 45 minutes
Thickness of .120 to .199 inch: 50 to 60 minutes
Thickness of .200 to .319 inch: 65 to 75 minutes
Thickness of .320 to .600 inch: 80 to 90 minutes

Recommended Storage

- Room Temperature (77° F)	Two (2) Weeks
- 40° F	Six (6) Months
- 0° F	Twelve (12) Months

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.

Date: 05/01/06