HP 250 FR

Description: High performance epoxy system with high shear strength, impact toughness for structural assembly applications, and needing a self-extinguishing epoxy system.

Intended Use: Flame retardant adhesive for aircraft interior applications. Bonds metals, glass, wood, and plastics.

Product features: Meets FAR 25.853 / 25.885 [60sec. Vertical burn test]

Typical Physical Properties:
- Cured 7 days @ 75° F
- Uncured

<table>
<thead>
<tr>
<th>Property</th>
<th>Cured 7 days @ 75° F</th>
<th>Uncured</th>
</tr>
</thead>
<tbody>
<tr>
<td>Impact Resistance</td>
<td>10 ft.lb./in(2)</td>
<td></td>
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<tr>
<td>Shore Hardness</td>
<td>75 Shore D</td>
<td></td>
</tr>
<tr>
<td>Gap-Fill</td>
<td>excellent</td>
<td></td>
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<tr>
<td>% Solids by Volume</td>
<td>100%</td>
<td></td>
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<tr>
<td>Adhesive Tensile Lap Shear (FRP)</td>
<td>625 psi</td>
<td></td>
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<tr>
<td>Adhesive Tensile Lap Shear (ABS)</td>
<td>177 psi</td>
<td></td>
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<tr>
<td>Adhesive Tensile Lap Shear (GBS)</td>
<td>2,600 psi @ 0.008&quot; bondline</td>
<td></td>
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<tr>
<td>Specific Volume</td>
<td>18.7 in(3)/lb.</td>
<td></td>
</tr>
<tr>
<td>T-peel (AL)</td>
<td>20 psi</td>
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</table>

Surface Preparation: Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength.

Mixing Instructions: Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. Proper mixing of the resin and hardener is essential for the curing and development of stated strengths.

25 ML DEV-TUBE
1. Squeeze material into a small container the size of an ashtray.
2. Using mixing stick included on Dev-tube handle, vigorously mix components for one (1) minute.
3. Immediately apply to substrate.

50 ML/400ML/490 ML CARTRIDGES
1. Attach cartridge to Mark 5 dispensing system.
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to substrate.

Application Instructions: 1. Apply mixed epoxy directly to one surface in an even film or as a bead.
2. Assemble with mating part within recommended working time.
3. Apply firm pressure between mating parts to minimize any gap and ensure good contact (a small fillet of epoxy should
Compliances:
Adhesive @ 0.125" passes 60 second vertical burn test.

Chemical Resistance:
Rating chemical resistance is not necessary for this product.

Precautions:
Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.

Warranty:
Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer:
All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.