



# F10-250

## THERMOSET FILM ADHESIVE

### KEY FEATURES

- Excellent oil and heat resistance
- Forms an excellent bond to metals and a range of plastics

### DESCRIPTION

F10-250 thermoset nitrile phenolic film adhesive was designed for applications which require high temperature and chemical resistance.

### FEATURES

- Excellent heat resistance with serviceable bonds up to 400°F (204°C)
- Excellent shear characteristics
- Excellent adhesion to a wide variety of metals and plastics
- Resistance to fuel and oil

### BASIC USES

- Automotive under the hood applications
- High temperature gasketing

### DIRECTIONS FOR USE

F10-250 is a thermosetting adhesive; therefore, the heat history of the film should be kept to a minimum prior to making the final bond to prevent premature curing.

Initial bonds may be made by laminating F10-250 to the primary substrate between 225 and 275°F (107-135°C) at the bond line.

Final bond: to fully thermoset, remove release liner and laminate primary substrate to other with pressure for 3 minutes at 360°F (182°C) bond line. Shorter dwell times will require higher temperatures to achieve the same degree of cure.

### PACKAGING

F10-250 is supplied on a single release liner with two-sided release. It is available at a 2 mil (51 microns) thickness and widths of 18 and 36 inches (46 and 91 cm). Rolls are up to 500 ly (457 m) in length.



### TYPICAL PHYSICAL PROPERTIES

Description	Results
Film Weight	52 g/m <sup>2</sup>
% Volatiles	2.0%
Density of Film @ 25°C	1.05 g/cm <sup>3</sup>
Release Liner	60 # bleached Super Calendered Kraft
Peel from Liner	20 g/in (7.9 g/cm)

### AVAILABILITY

Film Thickness	2 mils (51 microns)
Width	18 in (46 cm) 36 in (91 cm)
Length	Up to 500 ly (457 m)
ID Core Size	3 in (7.6 cm)

### STORAGE AND HANDLING

Store in a dry location at 40 to 80°F (4 to 27°C). Shelf life is approximately 12 months under these conditions.

### HEALTH AND SAFETY PRECAUTIONS

Please refer to SDS for complete details.

### LIMITED WARRANTY

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