F10-250
THERMOSET FILM ADHESIVE

DESCRIPTION
F10-250 thermostet 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

<table>
<thead>
<tr>
<th>Description</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>Film Weight</td>
<td>52 g/m²</td>
</tr>
<tr>
<td>% Volatiles</td>
<td>2.0%</td>
</tr>
<tr>
<td>Density of Film @ 25°C</td>
<td>1.05 g/cm³</td>
</tr>
<tr>
<td>Release Liner</td>
<td>60 # bleached Super Calendared Kraft</td>
</tr>
<tr>
<td>Peel from Liner</td>
<td>20 g/in (7.9 g/cm)</td>
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AVAILABILITY

<table>
<thead>
<tr>
<th>Description</th>
<th>Results</th>
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</thead>
<tbody>
<tr>
<td>Film Thickness</td>
<td>2 mils (51 microns)</td>
</tr>
<tr>
<td>Width</td>
<td>18 in (46 cm) 36 in (91 cm)</td>
</tr>
<tr>
<td>Length</td>
<td>Up to 500 ly (457 m)</td>
</tr>
<tr>
<td>ID Core Size</td>
<td>3 in (7.6 cm)</td>
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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.

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