

# L-F500

## Non-expandable, high strength structural adhesive

### Product Description

L-F500 is an epoxy-based, dry-to-the-touch adhesive film used for high strength structural bonding. In order to prevent galvanic corrosion from occurring, L-F500 can be paired with a fleece layer to act as a spacer.

### Technical Data

TYPICAL PROPERTIES			
		L-F500	Test Method
Physical Properties	Color	Green	
	Thickness	0.3 mm - 1 mm	
	Surface Density	390 g/m <sup>2</sup> - 1300 g/m <sup>2</sup>	
	Density	1.2 - 1.4 g/cc	
Mechanical Properties	Tensile Modulus*	>2800 MPa	ISO 527-1
	Tensile Strength*	>28 MPa	ISO 527-1
	Tensile Elongation*	~2%	ISO 527-1
	Lap Shear Strength Without Anti-Corrosion Oil**	>30 MPa	NF EN 2243-1
	Lap Shear Strength With Anti-Corrosion Oil**	>25 MPa	NF EN 2243-1
	Average T-Peel Strength Without Anti-Corrosion Oil***	>5 N/mm	NF EN ISO 11339
	Average T-Peel Strength With Anti-Corrosion Oil***	>3 N/mm	NF EN ISO 11339
	Average Impact Wedge Peel Cleavage Strength Without Anti-Corrosion Oil****	>20 N/mm	ISO 11343
Average Impact Wedge Peel Cleavage Strength With Anti-Corrosion Oil****	>20 N/mm	ISO 11343	

Cure conditions of samples: 30 min @ 165°C

\* 4 to 6 mm thick at 1 mm/min

\*\* 0.3 mm bondline, 1.8mm G10/10 galvanized steel, 12.5 x 25 mm overlap

\*\*\* 0.3 mm bondline, 0.7mm G10/10 galvanized steel, 25 x 100 mm overlap

\*\*\*\* 0.3 mm bondline, 0.7mm G10/10 galvanized steel, 20 x 30 mm overlap

### Cure Schedule

- 30 minutes at 130 - 190°C (265 - 375°F).
- Other curing cycles: please contact us (performance can vary based on curing cycle).

### Shelf Life & Storage Conditions

- Shelf life: 3 months from date of shipping when stored at or below 23°C (73°F) with 70% relative humidity.
- Shelf life: 6 months from date of shipping when stored at or below 5°C (41°F) with 70% relative humidity.

### Health & Safety

- Consult product specific Material Safety Data Sheet.

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