

PRODUCT DATA SHEET

CF180 One component

EPOXY SYNTACTIC PASTE

DENSITY 0.79 - SELFEXTINGUISHING

DESCRIPTION

Designed for edging and repairing honeycomb sandwich structures, filling cells to fix inserts.

PROPERTIES

- Low density
- Thermoreactive one component
- **Meet the requirements of FAR 25§853 / ABD0031**
- Extrudable
- Good resistance at compression
- Fast curing
- Good temperature resistance
- Require storage at low temperature

PHYSICAL PROPERTIES

Aspect	Formable paste	-
Colour	White	-
Density before curing ^(KP)	0.79	LT-020
Density of cured product⁽¹⁾ at 23 °C ^(KP)	0.80	LT-047
Reactivity on 20 mm at 120 °C ^(KP) (min)	25	LT-021
Activation temperature (°C)	100	-

(KP) Key properties. These values are enclosed in Certificate of Analysis.

(1) Product cured 2h at 120°C.

MECHANICAL PROPERTIES ⁽¹⁾

Hardness	(Shore D)	85	LT-022
Tensile strength	(MPa)	39	ISO 527
Elongation at break	(%)	1	ISO 527
YOUNG Modulus	(MPa)	5,500	ISO 527
Flexural strength	(MPa)	50	ISO 178
Flexural modulus	(MPa)	3,900	ISO 178
Compressive strength	(MPa)	85	ISO 604
Compressive modulus	(MPa)		ISO 604
Lap Shear Strength ALU 2017A Sandblasted 150 mesh	(MPa)		ISO 4587
Lap Shear Strength Stainless Steel sandblasted 150 mesh	(MPa)		ISO 4587

(1) Cured 2 h at 120 °C + 2 h at 130 °C.

THERMAL AND SPECIFIC PROPERTIES ⁽²⁾

Glass transition temperature (T _g)	(°C)	125	ISO 11359-2
Coefficient of Thermal Expansion (CTE) (10 °C to 120 °C)	(10 ⁻⁶ K ⁻¹)	32	ISO 11359-2
Flammability on 60 s and 12 s		amdt.25-83 (a) (d) app. F part (I)	FAR 25§853
Smoke toxicity			ABD0031
(2) Cured 2 h 120 °C + 2 h 130 °C + 4 h 150 °C			

PROCESSING

- As the product is stored at low temperature, take the quantity to be used beforehand and leave stabilized until the product is at room temperature. Apply the foam directly on the substrate with the mixer of the cartridge and cure for 2h at 120°C + 2h at 130°C.
- It is possible to reach 50 mm thickness. The exothermic heat will increase according to the mass and the curing cycle.
- **Example: Block 110 x 110 – Thickness 25.4 mm – Curing 2h at 100°C – Bulk exothermy: 140°C (t₀ + 40 min)**

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheet.

STORAGE CONDITIONS

Shelf life at - 18 °C: 18 months*

Shelf life at 6 °C: 9 months*

Shelf life at 25 °C: 3 months*

(*) in original unopened packaging

PACKAGING

- CF180 4 kg, 23 kg.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets.

VALUE BASES

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

LEGAL NOTICE

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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