

DESCRIPTION

TenCate TC310 is a toughened epoxy film adhesive for composite bonding with excellent mechanical properties and toughness. It is ideal for honeycomb or laminate bonding, and may be cured under autoclave or vacuum bag processing. TC310 is part of the TenCate MicroPly™ brand of adhesives and syntactics.

FEATURES

- › **Excellent balance of high temperature service and toughness**
- › **Can be cured initially at 121°C (250°F), followed by a 177°C (350°F) post cure**
- › **Designed for bonding honeycomb/composite structure or composite-to-composite laminate**
- › **Can be co-cured with prepreg**

PRODUCT TYPE

Epoxy Film Adhesive

TYPICAL APPLICATIONS

Aircraft structural bonding for:
 Honeycomb core/skin bonding
 Precured composite laminate bonding
 Co-cured composite bonding

TYPICAL NEAT RESIN PROPERTIES

Dry T _g (DMA E' Onset)	157°C (315°F)
Dielectric Constant	3.06 at 10 GHz
Loss Tangent	0.013 at 10 GHz
Outgassing (TML)	0.79%
Outgassing (CVMC)	<0.01%
Outgassing (WVR)	0.35%

SHELF LIFE

Out Life:	21 days at ambient
Frozen Storage Life:	12 months at -18°C (<0°F)

Out life is the time during which material retains enough tack, drape, and handling for component lay-up.

*Ambient is 18–22°C (65–72°F)

CURE SCHEDULE

2 hours at 121°C (250°F), followed by 1 hour at 177°C (350°F)
2 hours at 177°C (350°F) without dwelling at 121°C (250°F)

TENCATE TC310 COMMON FILM WEIGHTS/CONFIGURATIONS

Product Name	Carrier	Weight gsm/psf	Roll Quality	Film Width
TC310 0.035 psf, NWFG, 36"	Non Woven Fg	171gsm/0.035 psf	46.5 sqm/500 sf	0.91 m (36")
TC310 0.060 psf, NWFG, 36"	Non Woven Fg	293gsm/0.060 psf	46.5 sqm/500 sf	0.91 m (36")



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MECHANICAL PROPERTIES ON SUPPORTED ADHESIVE

Properties	Condition	Methods	0.03 psf NWFg supported (150gsm)		0.05 NWFg supported (244gsm)	
Tensile Lap Shear	RTD	ASTM D 1002	31.1MPa	4510 psi	37.1 MPa	5383 psi
Tensile Lap Shear	ETD, 121°C (250°F)	ASTM D 1002	27.8 MPa	4035 psi	27.6 MPa	4002 psi
Tensile Lap Shear	ETD, 150°C (300°F)	ASTM D 1002	21.3 MPa	3090 psi	23.7 MPa	3440 psi
Flatwise Tensile ¹	RTD	ASTM C 297	3.3 MPa	485 psi	7.8 MPa	1134 psi
Flatwise Tensile ¹	ETD, 121°C (250°F)	ASTM C 297	2.8 MPa	410 psi	7.6 MPa	1108 psi
Flatwise Tensile ¹	ETD, 150°C (300°F)	ASTM C 297	2.3 MPa	335 psi	7.6 MPa	1103 psi

Properties	Condition	Methods	0.015 psf unsupported (75gsm)		0.035 psf unsupported (175gsm)	
Tensile Lap Shear	RTD	ASTM D 1002	33.3 MPa	4825 psi	34.4 MPa	4985 psi
Tensile Lap Shear	ETD, 121°C (250°F)	ASTM D 1002	27.3 MPa	3965 psi	23.4 MPa	3400 psi
Tensile Lap Shear	ETD, 150°C (300°F)	ASTM D 1002	21.6 MPa	3130 psi	21.2 MPa	3080 psi
Flatwise Tensile ¹	RTD	ASTM C 297	-	-	5.2 MPa	755 psi
Flatwise Tensile ¹	ETD, 121°C (250°F)	ASTM C 297	-	-	5.2 MPa	750 psi
Flatwise Tensile ¹	ETD, 150°C (300°F)	ASTM C 297	-	-	3.6 MPa	520 psi

¹Core 3/16 cell, 0.5" thick, 5052 Al, 4.4 pcf

Mechanical specimens cured for 2 hours at 177°C (350°F) at 1.3 bar (40 psi) autoclave pressure, ramp rate 1.1°C (2°F) per minute. Adherends for tensile lap shear testing: 2024-T₃ Aluminum, 0.063", FPL etched and BR127 primed. Flatwise Tensile Facesheets: 2024-T₃ Aluminum, 0.020".

TENCATE TC310, 0.060 PSF 106 Fg

ADHESIVE CURE: 2 HOURS AT 177°C (350°F) UNDER 1 BAR 30 PSI AUTOCLAVE PRESSURE.

Test	Condition	Method	Results	Results
Flatwise Tensile	CTD	ASTM C 297 1"x1"	88 MPa	12726 psi
Flatwise Tensile	RTD	ASTM C 297 1"x1"	72 MPa	10406 psi
Flatwise Tensile	ETD1	ASTM C 297 1"x1"	61 MPa	8835 psi
Honeycomb ¹ Flatwise Tensile	CTD	ASTM C 297 2"x2"	6 MPa	929 psi
Honeycomb ¹ Flatwise Tensile	RTD	ASTM C 297 2"x2"	6 MPa	859 psi
Honeycomb ¹ Flatwise Tensile	ETD1	ASTM C 297 2"x2"	5 MPa	753 psi
Lapshear Al-Al	CTD	ASTM D 1002	26 MPa	3758 psi
Lapshear Al-Al	RTD	ASTM D 1002	28 MPa	4108 psi
Lapshear Al-Al	ETD1	ASTM D 1002	22 MPa	3230 psi
Lapshear Al-Al	ETW	ASTM D 1002	21 MPa	3054 psi
Thick-Adherend Lap Shear Strength ²	CTD	ASTM D 5656	65 MPa	9506 psi
Thick-Adherend Lap Shear Strength	RTD	ASTM D 5656	62 MPa	8951 psi
Thick-Adherend Lap Shear Strength	ETD	ASTM D 5656	45 MPa	6585 psi
Thick-Adherend Lap Shear Strength	ETD1	ASTM D 5656	38 MPa	5495 psi
Thick-Adherend Lap Shear Strength	ETW	ASTM D 5656	40 MPa	5776 psi
Thick-Adherend Lap Shear Strength	ETW1	ASTM D 5656	27 MPa	3972 psi

TENCATE TC310, 0.060 PSF 106 Fg

ADHESIVE CURE: 2 HOURS AT 177°C (350°F) UNDER 1 BAR 30 PSI AUTOCLAVE PRESSURE. *Continued from page 2*

Test	Condition	Method	Results	Results
Thick-Adherend Lap Shear Modulus ²	CTD	ASTM D 5656	0.4 GPa	0.062 Msi
Thick-Adherend Lap Shear Modulus	RTD	ASTM D 5656	0.4 GPa	0.060 Msi
Thick-Adherend Lap Shear Modulus	ETD	ASTM D 5656	0.2 GPa	0.035 Msi
Thick-Adherend Lap Shear Modulus	ETD	ASTM D 5656	0.3 GPa	0.043 Msi
Thick-Adherend Lap Shear Modulus	ETW ⁴	ASTM D 5656	0.4 GPa	0.052 Msi
Thick-Adherend Lap Shear Modulus	ETW ⁴	ASTM D 5656	0.1 GPa	0.017 Msi
T-peel	CTD	ASTM D 1876	26 N/25 mm	6 lb/in
T-peel	RTD	ASTM D 1876	39 N/25 mm	9 lb/in
T-peel	ETD ¹⁴	ASTM D 1876	23 N/25 mm	5 lb/in
G _{1c} DCB3	RTD	D6-83079-131	261 J/m ²	1.49 in-lb/in ²
G _{2c} ENF (Natural Crack) ³	RTD	D6-83079-132	1496 J/m ²	8.55 in-lb/in ²
Lapshear GrEp-GrEp ³	CTD	ASTM D 1002	13.6 MPa	1977 psi
Lapshear GrEp-GrEp ³	RTD	ASTM D 1002	12.8 MPa	1855 psi
Lapshear GrEp-GrEp ³	ETD1	ASTM D 1002	11.2 MPa	1628 psi
Lapshear GrEp-GrEp ³	ETW1	ASTM D 1002	5.9 MPa	860 psi

Notes: All aluminum surfaces have been FPL etched and BR127 bond primed.

¹Plascore Aluminum core XR1-7.9-0.250-N-5052 12.7 mm (0.5") thickness for honeycomb flatwise tensile testing.

²Bonded and tested at National Institute for Aviation Research (NIAR) Wichita, KS, for thick adherend testing.

³Bonded to grit blasted standard-modulus graphite fabric with 121°–135°C (250°–275°F) final cure epoxy (HX-42).

⁴CTD is 18°C (65°F), ETD is tested at @ 82°C (180°F), ETD1 is tested @ 121°C (250°F), ETW is tested at 82°C (180°F) and ETW1 is tested at 121°C (250°F) after 14 days 85% RH & 71°C (160°F) humidity exposure.