

Application

Letoxit LH 161 is one-component flame retarded epoxy filler with very low density, which is suitable especially for filling honeycomb sandwich structures edges.

It can be applied for all types of honeycomb and foam structures such as for composite production. The cured filler has very good mechanical properties under stress in temperature range from -75°C to +100°C. It can be used for all application fields, especially for manufacturing of aircraft parts.

Letoxit LH 161 fulfills requirements on flammability according to standard JAR, Part 25, Par.25.853 (a)

Appearance

The filler is white thixotropic paste.

Type

Epoxy filler, which contains a hardening system

Application method

Filler can be applied by gun or by hand. Filler does not expand during curing reaction. No volatile compounds are released from filler during preparation or curing.

Processing of filler is at room temperature. Filler should not be processed at temperature above 50°C due to exothermic reaction possibility in drum.

Letoxit LH 161 is usually cured at temperature 120-125°C for 60 minutes and can be cured under vacuum or pressure.

Curing time is counted from the moment when the temperature within the produced part reaches curing temperature. Filler can be also cured at lower temperature, but longer time has to be set. Filler cannot be cured under temperature 85°C.

It is necessary to keep the composition at the curing temperature for at least the minimal curing time. It is necessary to verify that the curing temperature is reached within whole cross-section of the cured composition. Temperature inside the cured composition can be measured with thermocouple etc.

Filler has very low thermal conductivity. Therefore strong exothermic reaction can occur in thick layer of filler during curing.

Properties of LH 161

Property	Unit	Measured
Number of components	pcs	1
Application time at 23°C	hours	Min. 168
Minimal cure time at 120°C	minutes	45
Viscosity at 25°C	Pa.s	160
Density	kg/m ³	695
Glass transition temperature	°C	120
Compressive strength at 23°C	MPa	54
Compressive modulus at 23°C	GPa	1,5
Shear strength at 23°C	MPa	11
Flammability vertical 60s – burn length	mm	85
Flammability vertical 60s – after flame time	s	2
Flammability vertical 60s – after time	s	0

TECHNICAL DATA SHEET

of drips		
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Packing

Letoxit LH 161 is packed in tin boxes or PE containers 0.5, 1, 5 or 10 liters or in drums 30 liters. The adhesive can be filled into cartridges of 310 ml, mechanical or pneumatic application gun is then used.

Storage

Without the change of properties, the filler can be stored for 1 month at +20°C, for 3 months at 5°C and up to 1 year for -18°C. The temperature +30°C mustn't be crossed during transport and storage.

Producer and Supplier

5M s.r.o.
Na Záhonech 1177
686 04 Kunovice
Czech Republic

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