

LORD® 2850 A/B SYNTACTIC FOAM

Technical Data Sheet

LORD® 2850 A/B foam is a modified epoxy syntactic foam system offering a smooth, creamy texture well suited to trowel or injection application techniques. LORD 2850 foam is used to provide reinforcement to honeycomb core and other hollow structures.

Features and Benefits

Durable: provides high compressive strengths and low weight versus volume.

Low Outgassing: exhibits low outgassing properties for use in aerospace applications.

Temperature Resistant: performs at temperatures from -320°F to +225°F (-196°C to +107°C).

Identifiable Appearance: provides identification of properly mixed material by a color change.

Easy to Apply: dispenses easily from convenient cartridge packaging.

Application

Surface Preparation: Remove all contamination and loose particles from the surfaces to be bonded. Etch aluminum alloys with sodium dichromate-sulfuric acid to obtain optimum mechanical strength.

Mixing: Thoroughly stir LORD 2850 B component before mixing with LORD 2850 A component. Mix LORD 2850 A component with LORD 2850 B component at ratio of 100:8, by weight.

Applying: Apply LORD 2850 foam to the area to be filled by injection methods or by using a spatula. Providing a slight vibration will help the material to flow and allow air bubbles to escape.

Curing: Allow foam to cure for 24 hours at room temperature [77-86°F (25-30°C)]. Allow material to cure before moving parts.

Cleanup: Before the foam sets up, clean excess foam on the bonded assembly, as well as the mixing and application equipment, with hot water and detergent or an organic solvent such as ketones. Once foam has cured, heat the material to 400°F (204°C) or above to soften foam. This allows the parts to be separated and the foam to be more easily removed.

Typical Properties*

	2850 A Component	2850 B Component	Mixed
Appearance	Yellow Paste	Blue Liquid	Green Paste
Viscosity, cP	Thixotropic	50	Thixotropic
Density lb/gal (kg/m ³)	5.0 - 5.8 (600 - 695)	7.8 - 8.3 (940 - 1000)	5.3 - 5.8 (640 - 700)
Flash Point, °F (°C)	>257 (>125)	>257 (>125)	>257 (>125)
Working Time, minutes @ 77°F (25°C)	–	–	30
Time to Handling Strength, hour	–	–	1

*Data is typical and not to be used for specification purposes.

Shelf Life/Storage

Shelf life of each component is six months when stored in a clean, dry environment at 68-86°F (20-30°C) in original, unopened containers.

Cautionary Information

Before using this or any Parker Lord product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Typical Cured Properties*

Compressive Strength, psi (MPa) @ room temperature @ -320°F (-196°C)	9000 (62.1) 12,000 (82.7)
Tensile Shear Strength, psi (MPa) @ room temperature @ -320°F (-196°C)	2500 (17.2) 1800 (12.4)
Outgassing ASTM E595 Total Mass Loss (TML), % Collected Volatile Condensable Materials (CVCM), %	0.98 0.01

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