



# Redux® 322

## Modified epoxy film adhesive

### Product Data

#### Description

Redux 322 is a high performance modified epoxy film adhesive curing at 175°C. It is suitable for bonding metal to metal and for sandwich structures, where operating temperatures are experienced up to 220°C for short periods, or 200°C for continuous operation. Redux 322 is a hot melt film which is free from solvents and consequently has a very low volatile content.

#### Features

- Cure at 175°C
- Good co-cure potential with 175°C curing prepregs
- Good hot lap shear performance
- Good high temperature performance in metal sandwich structures
- Low volatile content and low out gassing properties
- Available with or without a woven nylon carrier

#### Applications

- Metal to metal bonding
- Sandwich constructions

#### Form

Product Description	Areal Weights g/m <sup>2</sup>	Support	Roll Width mm	Standard Roll m <sup>2</sup>
Redux 322U	300	No	533	40
Redux 322	240	Yes	533	40
Redux 322	300	Yes	533	40
Redux 322	380	Yes	533	40

#### Instructions For Use

##### Pretreatment

It is essential that all substrates to be used are free of contamination and are in as ideal a state for bonding as possible. As pretreatment varies significantly depending on the substrates used, please refer to the Hexcel Composites publication Redux Bonding Technology for optimum procedures.

If there is to be a delay between the pretreatment and bonding of aluminium, the pretreated surface should be protected with Redux 122 or Redux 140 surface pretreatment protection solution to conserve the optimum bonding surface. This will enable bonding to be delayed for up to 2 weeks without deterioration of the pretreated surface. The correct application of Redux 122 or Redux 140 should not alter the bonding performance of Redux 322 (for full application details consult the relevant data sheet).



# Redux 322

## Application

1. Allow sufficient time for the adhesive to warm to room temperature (15°C to 27°C) before removing the protective polythene.
2. Cut the film to the shape and size required.
3. Remove the release paper and position the adhesive on the prepared bonding surface.
4. Remove the polythene backing sheet.
5. Complete the joint assembly and apply pressure while the adhesive is being cured at 140-700kN/m<sup>2</sup>. For sandwich structures the pressure application should be selected to suit the type of core used. After the adhesive has cured it is advisable to maintain pressure on the bonded assembly until it has cooled sufficiently to be handled without discomfort.

## Curing

Redux 322 should be cured at 175±5°C for 60 minutes to obtain optimum properties. Enough time should be allowed for heat to penetrate through the assembled parts to ensure that the adhesive reaches that temperature before timing starts. Cure pressures of around 140-700 kPa and heat up rates of up to 5°C per minute are recommended during cure. After curing it is recommended that components are cooled to below 70°C before releasing the pressure.

## Mechanical Properties

All the performance values given in this data sheet are based on experimental results obtained during testing under laboratory conditions. They are typical values expected for Redux 322 prepared and cured as recommended and under the conditions indicated. They do not and should not constitute specification minima.

## Metal Bonding Strengths

Redux 322 at areal weights indicated in the tables were used to bond Alclad 2024-T3 aluminium test specimens; the aluminium was pretreated in accordance with DTD 915B (ii) (chromic/ sulphuric acid pickling). Redux 122 primer was used after the pretreatment. The honeycomb tests used Hexcel's 7.9-1/4-40(5052)T aluminium honeycomb.

Test	Test Temperature °C	Redux 322U 300g/m <sup>2</sup>	Redux 322 240g/m <sup>2</sup>	Redux 322 300g/m <sup>2</sup>	Redux 322 380g/m <sup>2</sup>
Lap Shear Strength MPa	22	22	21	21	21
	150	26	21	24	23
	180				18
Climbing Drum Peel N/76mm	22	100	300	245	350
Flatwise Tensile MPa	22	8		8	8.7

### Storage

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Redux 322 has been formulated for maximum storage life consistent with its high performance. Certain precautions, however, will help to enhance that storage life as follows:

1. When stored at room temperature (less than 27°C) it should be kept on a horizontal mandrel passed through the tube core on which the roll is wound. This avoids the risk of local thinning of the film under the weight of the roll.
2. When storing under refrigeration the original packaging should be retained if possible. When returning to the refrigerator after use it is essential to protect the film with a water vapour barrier packaging material such as polythene.
3. On withdrawal from the refrigerator the water vapour barrier packaging should not be removed until the roll of adhesive has reached room temperature. This may take up to 24 hours depending on the size of the roll and the temperature involved (failure to observe this will result in the film becoming damp).
4. The film should be handled with care whilst in the frozen state since it will be brittle and easily cracked.

On receipt, Redux 322 will have a storage life of at least 12 months at -18°C plus an additional shop life of 1 month at below 27°C.

### Volatile content

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Redux 322 has a very low volatile content, usually well below 1%. In practice, the loss in weight when cured is negligible and emission of volatile products is not of practical significance.

### Associated products

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Redux 122 and Redux 140 surface pretreatment protection solutions (primers).  
Redux 219/2NA and 219/3NA foaming film adhesives.

### Handling and safety precautions

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In common with all Redux adhesives in film form, Redux 322 is particularly free from handling hazards for the following reasons:

- Film is covered on both sides by protective release paper and polythene sheet which are not removed until final component assembly. It should be cut to shape before removing the protective coverings and virtually no handling of the film is necessary.
- Low tack at normal room temperature. The film is dependent on elevated temperature for wetting-out the adherend surfaces.
- Volatile-free at normal room temperature.
- Splash-free, leak-free, spillage-free.

However, the usual precautions necessary when handling synthetic resins should be observed. A Material Safety Data Sheet for Redux 322 is available on request.



## Release Certification

The Quality System at Hexcel Composites Duxford has been certified to ISO 9001 by Lloyd's Register Quality Assurance, and is approved by the UK Civil Aviation Authority and Ministry of Defence. Certificates of Conformity and Test Reports can be issued for batches of Redux 322 on request.

## Important

All information is believed to be accurate but is given without acceptance of liability. Users should make their own assessment of the suitability of any product for the purposes required. All sales are made subject to our standard terms of sale which include limitations on liability and other important terms.

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## For More Information

Hexcel Composites is a leading worldwide supplier of composite materials to aerospace and other demanding industries. Our comprehensive product range includes:

- Carbon, glass, aramid and hybrid prepregs
- Honeycomb cores
- Structural film adhesives
- Honeycomb sandwich panels
- Special process honeycombs
- RTM materials

For further information, please contact your nearest sales office, or visit our website at [www.hexcelcomposites.com](http://www.hexcelcomposites.com)

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