

FM® 400NA

Epoxy; Epoxide
Cytec Industries Inc.

Message:

FM® 400NA adhesive film is the non-asbestos version of FM 400 and is designed to provide similar performance to that of FM 400 adhesive across the board. It is supplied with a lightweight nylon carrier and is designed for bonding metal-to-metal and sandwich composite structures requiring long time exposures to 420°F (216°C). BR® 400 is a modified epoxy corrosion inhibiting primer and provides excellent corrosive resistance when used on aluminum structures. FM 400NA adhesive film will also bond to BR® 127 primer with normal results. Where corrosion resistance is not required, FM 400NA adhesive film can be used without primer. FM 400NA adhesive film can be cured over a wide range of heat-up rates, temperatures and pressures. The recommended cure cycle is a 3 to 8.5°F/min (1.6 to 4.7°C/min) heat-up rate with a 60 minute hold at 350 ± 10°F (177 ± 5.6°C) and 45 ± 10 psi (0.31 ± 0.07 MPa) pressure.

Suggested Applications:

Honeycomb sandwich construction

Metal-to-metal bonding

General Information		
Features	Good Adhesion	
	Good Corrosion Resistance	
	Good Thermal Aging Resistance	
	High Heat Resistance	
Uses	Adhesives	
	Bonding	
	Structural Parts	
Appearance	Grey	
Forms	Film	
Mechanical	Nominal Value	Unit
Flexural Strength ¹	6.62	MPa
Shear Strength		
24°C ²	26.4	MPa
24°C ³	23.4	MPa
Additional Information	Nominal Value	Unit
Volatiles	< 2.0	%
NOTE		
1.	FM 400 film, 0.10 psf (0.50 kg/m ²) with BR 400 primer, bonded honeycomb panels	
2.	FM 400NA film with BR 400 primer, 0.050 in. (1.27 mm) Ti6-4V annealed titanium substrates	
3.	FM 400NA film with BR 400 primer, 2024-T81 bare aluminum substrates	

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