

CORFIL® 5250-4

CORFIL® 5250-4 is a single component, non-metallic filled, syntactic material formulated for use in insert potting, edge filling, and core filling of high temperature honeycomb sandwich structures.

CORFIL® 5250-4 is based on bismaleimide (BMI) chemistry and is available in six and twelve ounce easy-to-use cartridges.

Typical applications for CORFIL® 5250-4 include honeycomb core filling, insert potting and edge filling in BMI composite honeycomb sandwich panel construction.

Features and Benefits

- Use in metallic and non-metallic honeycomb
- Excellent compressive strength up to 475°F (246°C)
- Easily spreadable
- Co-curable with BMI composite materials, i.e. CYCOM® 5250-4

CHARACTERISTICS

Table 1 | Physical Properties

Property	
Appearance	Thixotropic paste
Density	50 pcf (0.80 g/cc)
Solids	100%
Shelf Life	6 months at or below 0°F (-18°C) from date of shipment

Table 2 | Product Availability

Property	
Color	Yellow
Cartridge Size	6 oz. 12 oz. 1 Quart

PROPERTIES

Table 3 | Typical Mechanical Properties

Property	Test Temperature	CORFIL 5250-4
	°F (°C)	psi (MPa)
Compression Strength ASTM D 695	75 (24)	12000 (82.7)
	350 (177)	7500 (51.7)
	475 (246)	2250 (15.5)



PROCESSING

Handling

CORFIL® 5250-4 is supplied ready to use.

Recommended Cure Cycle

CORFIL® 5250-4 can be cured over a broad range of time/temperature/pressure profiles.

Heat up from room temperature to 350°F (177°C) at a rate of 2°F - 5°F (1°C - 3°C) per minute. Hold at 350°F (177°C) for 120 - 240 minutes to yield typical values. A post cure of 240 minutes at 450°F (232°C) will yield improved compression values and condition the material for 450°F (232°C) use.

Surface Preparation

The substrate must be free from contamination, i.e., dirt, oil, grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and dry thoroughly.

HEALTH & SAFETY

Please refer to the product SDS for safe handling, personal protective equipment recommendations and disposal considerations.

