



DA 911U Unidirectional Carbon Epoxy Prereg System

DESCRIPTION

DA 911U is a tough, versatile, modified epoxy resin system that cures at 350°F to 400°F. DA911U can be supplied as a prepreg tape coated on unidirectional graphite.

PHYSICAL PROPERTIES

Weight:	0.053 lbs./sq ft
Resin Content:	40% by Weight
Volatiles:	Less than 1%
Tack:	Medium
Gel Time:	71 Minutes, 9 Seconds at 300°F 25 Minutes, 4 Seconds at 350°F 9 Minutes, 15 Seconds at 400°F
Shelf Life:	One year at 0°F with a cumulative out time of 150 hours at room temperature.
Standard Roll:	per customer request.

MECHANICAL PROPERTIES

Cure Cycle:	Press cured for two hours at 350°F and 50 psi pressure or one hour at 400°F with a 2 to 5°F per minute ramp time.	
Thickness:	0.006 inch/ply	
Resin Content:	32% by Weight	
Interlaminar Shear	(ASTM D 2344)	14.6 KSI
Tensile Strength	(ASTM D 3039)	250 KSI
Tensile Modulus	(ASTM D 3039)	17.5 MSI

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DA911U Prereg

CURE CYCLE

The prepreg may be cured using a heat up rate of 2-5 degrees per minute heat-up to 270°F ±5° F and 50 psi pressure for 90 minutes. Plus 180 minutes at 350°F ±5°F A pressure of 50 psi is recommended, however pressures of 30 to 50 psi may be used.

STORAGE

Store material in a contaminate free container and store at 0 degrees F for extended storage. For shorter storage time requirements store at 40 degrees F, this enables quicker stabilization times.

APPLICATION

Remove prepreg from cold storage at least 20 hours prior to use to allow for stabilization at room temperature. Keep the material wrapped to prevent moisture from condensing on the adhesive. If details are cut and replaced into cold storage, shorter stabilization times may be used.

Cut the prepreg to size, remove the poly separator and apply to part or mold. Remove the separator paper. Continue process until the desired number of plies is obtained.

CLEAN UP

The adhesive can be removed from non-bonding areas with ketones or methylene chloride. Be sure to follow all Material Safety Data Sheet (MSDS) guidelines for the solvent to be used.

CAUTION

This material contains epoxy resins and amines which may cause irritation to sensitive skin. Avoid contact with eyes or skin. If contact with skin occurs, wash as soon as possible with soap and water. If contact with eyes occurs, flush with water for 15 minutes. Do not handle or use this material until Material Safety Data Sheet has been read and understood. The user of this material is required to use the necessary protective equipment as directed by applicable state and federal laws when handling, curing, and grinding this material.

IMPORTANT NOTICE

Information in this data sheet has been obtained under controlled laboratory conditions and is believed to be accurate. Properties listed are typical values and are not intended for use in preparing specifications. Actual values may vary. No warranty is expressed or implied for which APCM assumes legal responsibility. APCM cannot be responsible for misapplication or handling and use under conditions beyond its control and under no circumstances shall be liable for incidental or consequential damage resulting from handling or use of this material.

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