

Allecomp Inc. 209 Puente Ave.
Test Panel Process Data Sheet

Panel ID: 10724 Date: 2-07-2001 Operator Initial A.S.
Customer Name: LBL Program Name/ Job Number: 00.20
01-003

Fiber/Prepreg/Layup

Fiber / ~~Prepreg~~ P-30 UNI-TAPE e.g. T300 3k 18x18 4x4 Twill RESIN = RS-100

Fabric Aerial Weight 65 gm/m² = weight (gm)/area (in²) x 1550 (Check)

Prepreg Information YLA Lot No. 6448 Roll # 1 e.g. MER ID 123

Number of Plies 8EA 24"X24" plies need to be even, paired and balanced

Lay-Up Sequence [0, +45, -45, 90, 90, -45, +45, 0]

Targeted FV 60 % Calculated Ply Thickness 0.0215 mil/ply

Total Layup Weight 307.6 gms PANEL THICKNESS 0.017

CURE PER
ES-205

Curing

Stain Thickness 0.017 inch

Curing Pressure 100 Ton or 1000 kg

Temperature 160 F 325 F

Dwell Time 30 mins. 1 hr.

Cure Time at Temp and Pressure 350 F 2 hrs.

Date 2-07-2001

As Cured Weight 275.8 gm, Thickness 0.017 inch (average of 4-10 readings)

Trimming Yes or No Yes Panel Size Width 24 inch x Length 24 inch

Weight 275.8 gm, Density 1.72 gm/cc CC = 160.5

Processing

Carbonization Where Date

Weight 275.8 gm, Thickness 0.017 inch (average of 4-10 readings), Density 1.72 g/cc

Additional Process e.g. Resin, Pitch, CVI, Graf. Where Date

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Weight 275.8 gm, Thickness 0.017 inch (average of 4-10 readings), Density 1.72 g/cc

0.016" 0.016"
0.016" 0.0155"
0.016" 0.018"
0.018" 0.016"
0.017" 0.017"

AllComp
209 Puente ave.
City of industry, CA

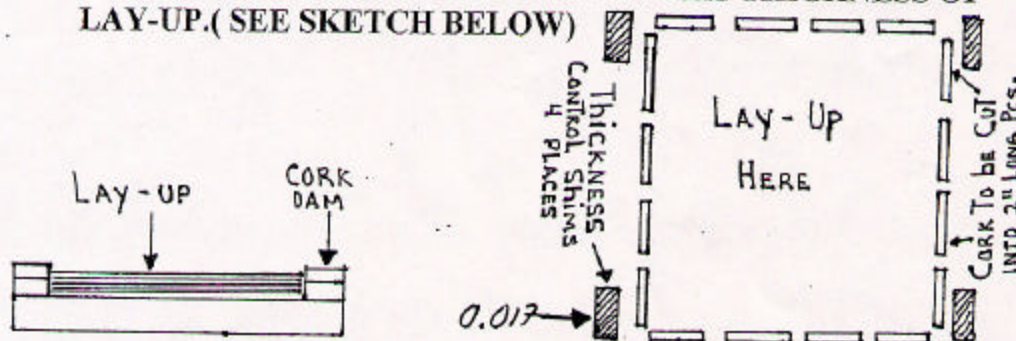
Es 205-

CURE CYCLE FOR YLA RS 10B PHENOLIC RESIN AND UNIDIRECTIONAL PREPREG

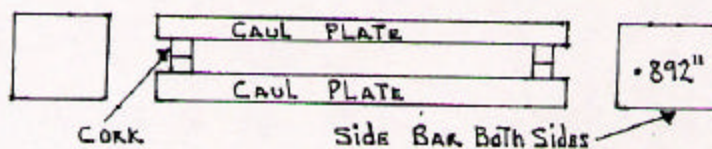
DATE
PANEL ID... 10724

- 1.- PREPARE ALUM CAUL PLATES, METAL SHIMS AND NON-PERFORATED TEFLON FILM
- 2.- PLACE LAY-UP IN THE MIDDLE OF ALUM CAUL PLATES.
- 3.- PLACE A ^{0.032} ~~750~~ WIDE CORK DAM AROUND PERIMETER OF LAY-UP. PLACE PROPER THICKNESS CONTROL SHIMS IN FOUR PLACES.

NOTE: MAKE SURE THAT CORK DAM THICKNESS IS JUST A LITTLE BIT HIGHER THAN THE THICKNESS OF LAY-UP. (SEE SKETCH BELOW)



- 4.- CLOSE LAY-UP ASSEMBLY AND PLACE IN A PREHEATED PRESS TO 160 DEG F WITH THE SIDE BARS ON EACH SIDE. CLOSE PRESS PLATENS TO SIDE BARS AND HOLD FOR 60-90 MINUTES.



5.- AFTER THE ²⁰~~60~~ MINUTES HOLD , REMOVE SIDE BARS .
CLOSE PRESS AND APPLY 100 TONS OF PRESSURE.

6.- RAISE TEMP TO 225 DEG F AND HOLD 60 MINUTES.

7.- RAISE TEMP TO 350 DEG F. AND HOLD 120 MINUTES.

8.-COOL UNDER PRESSURE BELOW 200 DEG F. BEFORE
RELEASING PRESSURE

9.- REMOVE MOLDED PANEL, CLEAN AS NECESSARY,
IDENTIFY PERMANENTLY AND CHARACTERIZE.