

De-bulking guidelines

Thawing prepreg before use

Cytec prepregs must be stored in a freezer. When material is removed from the freezer, it is essential that the roll be allowed to thaw and reach room temperature before the polythene bag is opened. For example, the thaw time for a 20 linear metre (250ft²) roll taken from -18°C (0°F) storage into a 21°C (70°F) room is typically between 4 and 6 hours. Condensation may form on the surface of the material if it is not fully thawed. Moisture within a curing laminate may be detrimental to final part quality and appearance. When materials are returned to the freezer they must be resealed in a polythene bag containing a desiccant pack to prevent ingress of moisture.

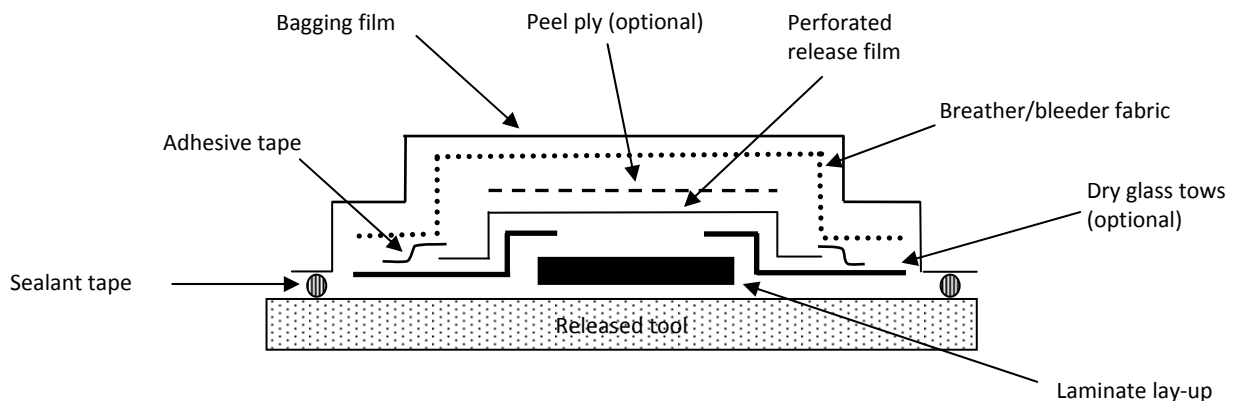
Lay-up

Prepreg should be cut to shape and laid up in accordance with design instructions. Care must be taken during lay-up to ensure the prepreg conforms exactly to the tool shape, especially around internal female corners.

To enable the prepreg to conform fully to all geometries of the tool and to remove any trapped air between plies, it is recommended that the lay-up is de-bulked at regular intervals. This is carried out by placing the lay-up under a vacuum bag and pulling a minimum of 980mbar (29"Hg)* for up to 30 minutes.

*This is the ideal vacuum level, however, it is recognised that it is not always possible to attain. If in doubt, please contact our technical support staff for further information.

Recommended consumables



Product type	Product name	Material	Maximum operating temperature
Release film (perforated)	E2760P	Blended co-polymer	121°C (250°F)
	A2000P3	Blended co-polymer	150°C (302°F)
Peel ply (optional) [†]	A100	Nylon	180°C (356°F)
Breather/bleeder fabric	AB100/A3000	Polyester	205°C (401°F)
Bagging film	VACFILM400Y	Co-extruded nylon	150°C (302°F)
	VACFILM450V	Co-extruded nylon	170°C (338°F)
Sealant tape	SM5227	Butyl	93°C (200°F)
	UCS180	Butyl	180°C (356°F)

[†] A peel ply placed over the top of the perforated release film is recommended when using tacky resins to ensure the breather/bleeder fabric does not adhere to the prepreg through the perforations.