



EP254 Epoxy Prepreg

EP254 is a low temperature curing, toughened epoxy that cures in the 235°F to 275°F range. EP254 co-laminates to graphite epoxy prepregs without shear failure between the dissimilar materials and is available in a wide range of tack and drape. EP254 handling characteristics makes it especially well suited for table rolling applications.

Properties of EP254-7781

Flexural Strength, psi	95,000
Flexural Modulus, psi	3,400,000
Tensile Strength, psi	60,000
Tensile Modulus, psi	3,500,000
Compressive Strength, psi	63,000
Short Beam Shear Strength, psi	10,500
Interlaminar Shear Strength, psi	8,200
Dielectric Constant at 7.7 GHZ	4.59
Loss Tangent at 7.7 GHZ	0.015

Properties of EP254 - 5.7 Ounce 3K Plain Weave Carbon

Flexural Strength, psi	155,000
Flexural Modulus, psi	4,600,000
Tensile Strength, psi	90,000
Tensile Modulus, psi	5,900,000

Properties of EP254 / 3743, E-Glass Fabric

Flexural Strength, psi	155,000
Flexural Modulus, psi	4,600,000
Tensile Strength, psi	90,000
Tensile Modulus, psi	5,900,000

NOTE: The data presented herein has been developed under controlled manufacturing and test conditions and is considered accurate. No warranty is expressed or implied regarding the accuracy or use of this data or the use of this product. It is the responsibility of the end user to determine suitability for use.



PROCESS INFORMATION - EP254

Autoclave Cycle

Draw vacuum and apply 45-70 psi autoclave pressure
5° F/minute ramp to 175° F (optional)
Hold for 30—45 minutes
5° F/minute ramp to 245° F - 255° F
Hold for 60 to 90 minutes
Cool to less than 180° F at 3 to 5° F/minute
Release pressure/vacuum and demold

Vacuum Bag in Oven Cycle

Draw vacuum
5° F/minute ramp to 175° F
Hold for 30 to 45 minutes
5° F/minute ramp to 245° F - 255° F
Hold for 60 to 90 minutes
Cool to less than 180° F at 3 to 5° F/minute
Release vacuum and demold

Press Cycle

60 - 90 minutes at 245° F to 255° F, 45 to 70 psi

Recommended Storage

- Room Temperature (77° F)	Four (4) Weeks
- 40° F	Six (6) Months
- 0° F	Twelve (12) Months

NOTE: EP254 Epoxy Prepreg is wound with a polyethylene film release liner for easy release. The rolls are sealed in polyethylene film bags to protect prepreg from moisture and other contaminants. The bags should remain sealed while the prepreg is under refrigeration and only removed when the prepreg has had sufficient time to warm to room temperature. When not in use, the prepreg should be returned to refrigerated storage. Care should be exercised to limit out-time of the prepreg in order to insure maximum shelf life. Torn bags should be replaced.

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