



HexPly[®] 260

135°C curing phenolic matrix

Product Data

Description

HexPly 260 is a phenolic resin developed to meet such F.S.T. (Fire, Smoke, Toxicity) regulations and the 1990 O.S.U. index (65/65), for aircraft interior parts as: side wall panels, floor panel, galleys, ceiling panels and lavatories.

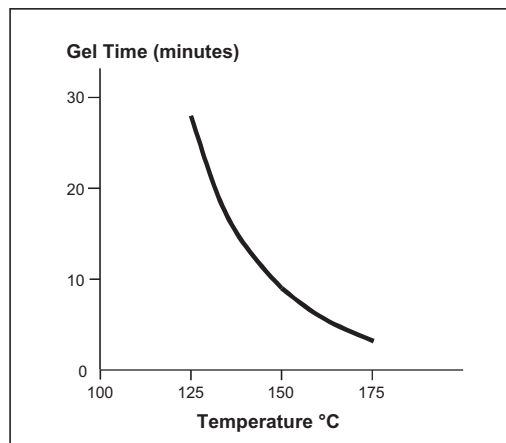
HexPly 260 prepreg is available in various fabric reinforcements

Benefits and Features

- Controlled flow matrix for easy processing
- Excellent tack life of 30 days at 25°C
- Self extinguishing
- Good peel properties
- Versatile cure cycle 125 - 150°C
- Suitable for vacuum bag, press and autoclave processes
- Maximum service temperature of 80°C

Resin Matrix Properties

Gel Time



Prepreg Curing Conditions

HexPly 260 system can be processed using various cure cycles, at a pressure between 0.8 to 3 bar.

| Temperature (°C) | Time |
|------------------|---------|
| 125 | 2 hours |
| 135 | 90 min |
| 150 | 30 min |

Heat up rate 1 - 3°C/min

Performance testing should accompany alternative cure cycles to ensure suitability for the particular application.



Fire Properties (Specific O.S.U. properties FAR 25 Amendment 66)

Heat Release Rate vs. Time

| | 2 min Total KW min/m ² Requirement: 65 | Peak KW/m ² Requirement: 65 |
|---|--|---|
| Laminate - 4 plies | | |
| 7781 glass | 35 | 43 |
| G 874 hybrid | 26 | 50 |
| Sandwich ⁽¹⁾ - 2 plies | | |
| 7781 glass | 44 | 44 |
| G 874 hybrid | 37 | 40 |
| Sandwich ⁽¹⁾ - 2 plies + LHR Schneller film | | |
| 7781 glass | 63 | 53 |
| G 874 hybrid | 59 | 53 |
| Sandwich ⁽²⁾ - 3 plies + LHR Schneller film | | |
| 7781 glass | 49 | 44 |

Fabric Style

7781: 8 harness satin glass: 302 g/m² and 0,230 µm ply thickness
G 874: 65% glass/35% carbon: 170 g/m² and 0,220 µm ply thickness

⁽¹⁾ Nomex Honeycomb A1, 29 kg/m³ - thickness 3.17 mm ⁽²⁾ Nomex Honeycomb A1, 48 kg/m³ - thickness 20.3 mm

Cured resin density 1.18 g/cm³

Prepreg Storage Life

| | | |
|-------------------------|---------|-----------|
| ■ Tack life | @ 23°C | 28 days |
| ■ Guaranteed shelf life | @ -18°C | 12 months |

Precautions for Use

The usual precautions when handling uncured synthetic resins and fine fibrous materials should be observed, and a Safety Data Sheet is available for this product. The use of clean disposable inert gloves provides protection for the operator and avoids contamination of material and components.

Important

All information is believed to be accurate but is given without acceptance of liability. Users should make their own assessment of the suitability of any product for the purposes required. All sales are made subject to our standard terms of sale which include limitations on liability and other important terms.

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