**Description**

HexPly® M34 is an epoxy system, specifically developed for low temperature curing of large structural components, particularly in industrial markets.

HexPly® M34 is a self-extinguishing system, providing excellent fire-resistant properties, and meeting the German and French rail qualifications DIN 5510, S3-SR2-ST2 and NF F 16-101 (M2, F1). HexPly® M34 prepreg is ideal for manufacturing sandwich structures, providing excellent adhesion to PVC foam cores.

HexPly® M34 exhibits a good shelf life at Room Temperature for a low temperature curing system.

**Benefits and Features**

- Halogen free
- 10 days shelf life at room temperature
- Self adhesive on foam (PVC) and on honeycomb
- Low pressure moulding capability 0.8-3 bar (12-43 Psi)
- Good flexibility and handleability of prepregs
- Suitable for thick laminates - low exotherm
Resin Matrix Properties

Rheology

Gel Time

Cured Matrix Properties cured at 75°C (167°F) - 8H

<table>
<thead>
<tr>
<th>Test</th>
<th>Values</th>
<th>Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Glass transition temperature</td>
<td>80°C (176°F)</td>
<td>DMA</td>
</tr>
<tr>
<td>Cured resin density</td>
<td>1.26 g/cm³</td>
<td></td>
</tr>
<tr>
<td>Flexural</td>
<td>Str = 120 MPa (17.4 KSI)</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Mod = 3.8 GPa (551 KSI)</td>
<td></td>
</tr>
</tbody>
</table>

Prepreg Curing Conditions

The standard cure cycle is 8 hours at 75°C (167°F), at a pressure between 0.8 and 3 bar. The following alternative cure cycles can be used:

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>65°C (149°F)</td>
<td>16 hours</td>
</tr>
<tr>
<td>90°C (194°F)</td>
<td>90 minutes</td>
</tr>
<tr>
<td>120°C (250°F)</td>
<td>40 minutes</td>
</tr>
</tbody>
</table>
Prepreg Storage Life

- Shelf Life @ 23 + 2 °C (73 °F) 10 days
- Guaranteed Shelf Life @ -18 °C (0 °F) 12 months (maximum, from date of manufacture)

Precautions for Use

The usual precautions when handling uncured synthetic resins and 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.

For more information

Hexcel is a leading worldwide supplier of composite materials to aerospace and industrial markets. Our comprehensive range includes:

- HexTow® carbon fibers
- HexForce® reinforcements
- HiMax® multiaxial reinforcements
- HexPly® prepregs
- HexAM® additive manufacturing
- HexMC® molding compounds
- HiFlow® RTM resins
- HexBond® adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed® laminates & pultruded profiles

For U.S. quotes, orders and product information call toll-free 1-800-688-7734. For other worldwide sales office telephone numbers and a full address list, please go to:

http://www.hexcel.com/contact