



HexPly[®] M901

Fast curing epoxy matrix



Product Data Sheet

Description

HexPly[®] M901 is a high-performance epoxy matrix for use in structural prepreg applications for automotive, UAV, and industrial markets. Suitable for high production rates for harsh thermal and environmental conditions applications.

HexPly[®] M901 exhibits a high glass transition point and an excellent retention of its physical properties after hot-wet treatment.

HexPly[®] M901 is an epoxy resin system supplied with unidirectional or woven carbon and glass fibers.

Benefits and Features

- Excellent mechanical performances.
- Fast cure cycle (from 15 minutes).
- Cost-Effective resin system.
- Flexible cure capabilities.
- Outstanding surface aspect.
- Long out life at room temperature.

HexPly[®] M901 is designed for autoclave or press cure (compatible with hot-in hot-out processes) to obtain optimum mechanical performance from the composite part. Performance level are highly dependent on part design and relative to cure cycle.

Cured Matrix Properties

- Glass transition T° (Dry)* 170±5°C
- Glass transition T° (Wet)* 115±5°C
- Gel Time @ 130°C 5-6 minutes
- Density 1.10-1.25 g/cm³
- Color Warm Warm White

Test Method

DMA onset according to EN6032
(single cantilever 5°C/min 1hz 15µm)

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(single cantilever 5°C/min 1hz 15µm)

ISO1183-1

**See below for cure cycle details*

Wet ageing according to EN2823.



Prepreg Curing Conditions

Hexply[®] M901 matrix is a flexible cure matrix that is compatible with a broad range of cure time and temperature, both in autoclave and press process. Please contact Hexcel's Technical support team for more information on cure cycles.

Nominal Autoclave cure cycle for monolithic parts:

1. Apply Full Vacuum
2. Pressure gauge: 5-7 bars
3. Recommended heat-up rate: 0.5 – 3°C/min *
4. Recommended cure cycle: 30min @130°C

**Defined heat-up rates will vary depending on the autoclave dimensions, the mass of tooling used and the size of the component to be manufactured. As the product is Hot-in/hot-out process compatible, the limiting factor will be tooling and autoclave capacity for the maximum ramp.*

Nominal press cure cycle for monolithic parts *

1. Set tooling temperature at 160°C: Hot-in
2. Pressure gauge: 5-10 bars **
3. Recommended cure cycle: 15min @160°C
4. Part release at 160°C: Hot-out

**Maximum part thickness can be studied by the technical support team. Contact Hexcel for more detailed information*

***Staging may be required based on tooling and part geometry*

For above press cure cycles the following glass transition temperature can be achieved:

Cure Temperature (°C)	Cure Time (min)	Tg Dry (°C)	Tg Wet (°C)
160	15	175	115
130	30	150	110

Prepreg Storage Life

(Stored sealed, in dry conditions and in absence of direct sunlight)

- Out Life 15 weeks at RT (23°C)
- Shelf-life 18 months at -18°C



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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

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
- HexMC® molding compounds
- HiFlow® RTM resins
- HexBond® adhesives
- HexTool® tooling materials
- HexWeb® honeycomb
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products

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>

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