Description

F161 is a structural, heat resistant and electrical grade epoxy formulation designed for autoclave curing. F161 is a high temperature, laminate grade epoxy resin with a 350°F (177°C) cure. F161 is unique in that it was the first resin system to meet all types and classes of MIL-R-9300 B.

Features

Uncured

- Moderate Viscosity During Cure
- Adaptable to Offer Good Tack and Drape for Processing
- Can Be Adapted for Use on Various Weaves and Fiber Reinforcements
- Nonburning System Available (Bromine Added)

Cured

- Heat Resistant Properties
- Excellent Heat Aging Properties, Adaptable to Tooling
- Electrical Grade Formulation
- Certified to MIL-R-9300 B, Types I and II, Grades O and D, Form B

Neat Resin Properties

Specific gravity

 $T_g dry$

T_a wet

Equilibrium moisture absorption

Linear coefficient of thermal expansion

Tensile strength

Tensile modulus

Tensile strain

Fracture toughness, K_{1C}

Strain energy release rate, G_{1C}

Gel time @ 350°F (177°C)

1.243

386°F (197°C)

305°F (152°C)

2.8%

2.6 x 10⁻⁵ in/in/°F (4.68 x 10⁻⁵ cm/cm/°C)

8.7 ksi (60 MPa)

0.52 msi (3.59 GPa)

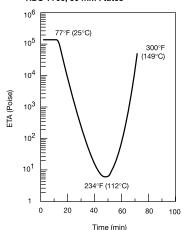
2.2%

0.394 ksi $\sqrt{\text{in}}$ (0.433 MPa $\sqrt{\text{m}}$)

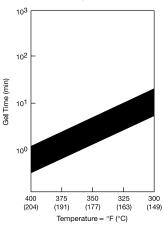
0.262 in-lb/in² (0.0459 kJ/m²)

1-7 min

Rheometrics Curve of F161 Resin 4°F (2°C)/min, 10 rads/sec, RDS-7700, 50 mm Plates



Gel Time vs Temperature



® Kevlar is a registered trademark of E.I. DuPont de Nemours, Wilmington, Delaware.
™ F161 is a trademark of Hexcel Corporation, Pleasanton, California.
® Hexcel and the Hexcel logo are registered trademarks of Hexcel Corporation, Pleasanton, California.



Availability

| Form | Hexcel Designation | Fiber | Fiber Areal Wt. lbs/ft² (g/m²) | Weave | Count Warp x Fill | Available Widths Standard Width, in (cm) | |
|--------------------|-----------------------|------------------------------------|-----------------------------------|--|---|--|--|
| Glass Fabrics | 120-38"-F161 | 450-1/2 | 377 (115) | Crowfoot MIL-C-9084 TYIII | 60 x 58 | <u>38</u> ", 50", 60" (<u>96.5,</u> 127, 152.4) | |
| | 1581-38"-F161 | 150-1/2 | 992 (303) | 8 Harness Satin MIL-C-9084 TYVIIIA | 57 x 54 | 38", 50", 60", 72" (96.5, 127, 152.4, 182.9) | |
| | 7781-38"-F161 | 75-1/0 | 992 (303) | 8 Harness Satin MIL-C-9084 TYVIIIB | 57 x 54 | 38", 50", 60", 72" (96.5, 127, 152.4, 182.9) | |
| Kevlar® Fabrics | K120-38"-F161 | Kev. 49 195 | 198 (61) | Plain | 34 x 34 | <u>38</u> ", 50", 60" (<u>96.5</u> , 127, 152.4) | |
| | K285-38"-F161 | 3"-F161 Kev. 49 557 (170) Crowfoot | | 17 x 17 | 38", 50", 60" (<u>96.5,</u> 127, 152.4) | | |
| | K281-38"-F161 | Kev. 49 1140 | 557 (170) | Plain | 17 x 17 | 38", 50", 60" (<u>96.5</u> , 127, 152.4) | |
| Glass | T2E285-12"-F161 | E-Glass 1062 | 933 (285) | | | | |
| Tapes | T2S265-12"-F161 | S-2 Roving | 868 (265) | n/a | n/a | <u>12</u> ", 3"–24" (<u>30.5,</u> 7.6–61) | |
| Kevlar | T7D150-12"-F161 | Kev. 49 7100 | 491 (150) | | | | |

Note: Alternatively, glass and Kevlar weaves may be used with the F161 resin system. Consult your nearest Hexcel Sales Representative for additional information.

Physical Properties

| | Property | Glass I | abrics | Kevlar Fabrics | | |
|----------|--|----------------|----------------|----------------|----------------|--|
| Prepreg | Material description | 1581 | 7781 | 120 | 285 | |
| | % Flow @ 350°F 50 psi (177°C, 345 kPa) | 15–25 | 15–25 15–25 | | 20–30 | |
| | % Resin content (dry) | 33–39 | 34–40 | 52–58 | 47–53 | |
| Laminate | Cured thickness per ply – in (cm) | 0.0109 (0.028) | 0.0115 (0.029) | 0.0039 (0.010) | 0.0097 (0.025) | |
| | % Fiber volume | 43.4 | 41.2 | 44.0 | 47.9 | |

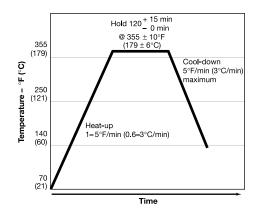
Mechanical Properties (Autoclave Cure)

| D | Temp | Glass Fabrics | | | Kevlar Fabrics | | | |
|--------------------------------------|----------------------------|---------------|-------------|-------------|----------------|-------------|-------------|-------------|
| Property | °F (°C) | 120 1581 7781 | | 7781 | 120 | | 285 | |
| | | | | | Dry | Wet | Dry | Wet |
| Tensile strength, ksi (MPa) | -65 (-54) | | | | 57.0 (393) | | 56.8 (392) | |
| Tensile modulus, msi (GPa) | – 65 (– 54) | | | | 3.96 (27.3) | | 3.66 (25.2) | |
| Tensile strength, ksi (MPa) | 75 (24) | 66 (455) | 61.5 (424) | 63.5 (438) | 59.5 (410) | 57.9 (399) | 62.1 (428) | 57.9 (399) |
| Tensile modulus, msi (GPa) | 75 (24) | 3.1 (21) | 3.95 (27.2) | 4.02 (27.7) | 3.76 (25.9) | 3.61 (24.9) | 3.85 (26.5) | 3.64 (25.1) |
| Tensile strain | 75 (24) | | 15,560 | 15,800 | 15,800 | 16,000 | 16,100 | 15,900 |
| Tensile strength, ksi (MPa) | 270 (132) | | | | 48.4 (334) | 37.6 (259) | 50.6 (349) | 37.5 (259) |
| Tensile modulus, msi (GPa) | 270 (132) | | | | 3.17 (21.9) | 2.69 (18.6) | 3.58 (24.7) | 3.55 (24.5) |
| Tensile strength, ksi (MPa) | 350 (177) | 58 (400) | 53 (365) | 47.8 (330) | 34.5 (238) | 27.5 (190) | 40.8 (281) | 36.7 (253) |
| Tensile modulus, msi (GPa) | 350 (177) | 2.5 (18) | 2.96 (20.4) | 3.54 (24.4) | 2.76 (19.0) | 2.59 (17.9) | 3.16 (21.8) | 2.93 (20.2) |
| Compression strength, ksi (MPa) | -65 (-54) | | | | 32.2 (222) | | 28.9 (199) | |
| Compression modulus, msi (GPa) | -65 (-54) | | | | 3.49 (24.1) | | 3.59 (24.8) | |
| Compression strength, ksi (MPa) | 75 (24) | 70 (482) | 66.1 (456) | 68.0 (469) | 28.9 (199) | 20.2 (139) | 44.6 (308) | 18.5 (128) |
| Compression modulus, msi (GPa) | 75 (24) | 3.0 (21) | 3.98 (27.4) | 4.37 (30.1) | 3.88 (26.8) | 3.04 (21.0) | 4.07 (28.1) | 2.85 (19.7) |
| Compression strength, ksi (MPa) | 270 (132) | | | | 17.0 (117) | 10.2 (70) | 15.1 (104) | 10.3 (71) |
| Compression modulus, msi (GPa) | 270 (132) | | | | 2.67 (18.4) | 2.27 (15.7) | 2.49 (17.2) | 2.20 (15.2) |
| Compression strength, ksi (MPa) | 350 (177) | 43 (296) | 40.0 (276) | 39.2 (270) | 13.1 (90) | 7.5 (52) | 12.3 (85) | 7.6 (52) |
| Compression modulus, msi (GPa) | 350 (177) | 2.9 (20) | 3.30 (22.8) | 3.21 (22.1) | 2.45 (16.9) | 2.03 (14.0) | 2.26 (15.6) | 1.75 (12.1) |
| Short beam shear strength, ksi (MPa) | -65 (-54) | | | | 4.95 (34) | | 4.26 (29) | |
| Short beam shear strength, ksi (MPa) | 75 (24) | | | | 4.95 (34) | 5.23 (36) | 4.28 (30) | 4.38 (30) |
| Short beam shear strength, ksi (MPa) | 270 (132) | | | | 3.83 (26) | 2.21 (15) | 3.39 (23) | 2.49 (17) |
| Short beam shear strength, ksi (MPa) | 350 (177) | | | | 2.73 (19) | 2.30 (16) | 2.06 (14) | 1.61 (11) |
| Long beam ultimate, lb/in (kg/m) | -65 (-54) | | | | 115 (2054) | | 183 (3268) | |
| Long beam flex ult., lb/in (kg/m) | 75 (24) | 191 (34) | 264 (48) | | 90 (1607) | | 144 (2572) | |
| Long beam flex ult., lb/in (kg/m) | 270 (132) | | | | 33 (539) | | 59 (1054) | |

All mechanical property values are based on the calculated fiber volume, found on the previous table.

Reported property values are averages to which no statistical assurance should be associated. While Hexcel believes that the data contained herein are factual, the data are not to be taken as a warranty or representation for which Hexcel assumes legal responsibility. They are offered solely for your consideration, investigation, and verification.

Cure Cycle



Cure Procedure

I. Autoclave only (typical cure cycle at left)

- A. Edge bleed and surface bleed.
- B. Apply 22 in (74 kPa) Hg vacuum minimum to vacuum bag.
- C. Apply 45 ± 5 PSIG (310 \pm 34 kPa) pressure.
- D. Vent vacuum bag to atmosphere when pressure reaches 20 PSIG (138 kPa).
- E. Below 140°F (60°C) release pressure and remove part.

II. Autoclave and Postcure (optional)

- A. Cure as above except hold for 60 minutes at 355°F (179°C).
- B. Debag and cure for 3 hours at 400°F (204°C) in an air circulating oven.



Storage

F161 prepreg should be sealed in a polyethylene bag and refrigerated, preferably below 32°F (0°C). Following removal from refrigerated storage, allow the prepreg to reach room temperature before opening the polyethylene bag to avoid moisture condensation. Shelf life: 6 months at 0°F (-18°C), 3 months at 40°F (4°C).

Shipping

Prepreg fabric and tape are generally shipped in sealed polyethylene bags in insulated containers packed with dry ice or refrigerated shipment.

Disposal of Scrap

Disposal of this material should be in a secure landfill in accordance with state and federal regulations.

Handling and Safety Precautions

Hexcel recommends that customers observe established precautions for handling epoxy resins and fine fibrous materials. Operators working with this product should wear clean, impervious gloves to reduce the possibility of skin contact and to prevent contamination of the material.

Airborne graphite as a result of sawing, grinding, etc., can present electrical shorting hazards; refer to NASA Technical Memorandum 78652. Material Safety Data Sheets (MSDS) have been prepared for all Hexcel products and are available to company safety officers on request from your nearest Hexcel Sales Office.

Important

Hexcel Corporation makes no warranty, whether expressed or implied, including warranties of merchantability or of fitness for a particular purpose. Under no circumstances shall Hexcel Corporation be liable for incidental, consequential, or other damages arising out of a claim from alleged negligence, breach of warranty, strict liability or any other theory, through the use or handling of this product or the inability to use the product. The sole liability of Hexcel Corporation for any claims arising out of the manufacture, use, or sale of its products shall be for the replacement of the quantity of this product which has proven to not substantially comply with the data presented in this bulletin. Users should make their own assessment of the suitability of any product for the purposes required. The above supercedes any provision in your company's forms, letters, or other documents.

For technical assistance, applications and procedures, or further information, please contact:

Administrative Office and Customer Service Center

5794 West Las Positas Blvd. P.O. Box 8181 Pleasanton, CA 94588-8781 Tel (925) 847-9500 Fax (925) 734-9676

Hexcel Composites

Duxford, Cambridge CB2 4QD United Kingdom Tel 44 (0) 1223 833141 Fax 44 (0) 1223 838808

Sales Offices

2350 Airport Fwy., Suite 550 Bedford, TX 76022-6027 Tel (817) 315-3939 Fax (817) 571-8629

Sales Offices (continued)

101 East Ridge Drive, Suite 102 Danbury, CT 06810-4140 Tel (203) 798-8311 Fax (203) 798-8161

11410 Northeast 122nd Way, Suite 320 Kirkland, WA 98034-6927

Tel (425) 821-7411 Fax (425) 823-6437