

CURING PARAMETERS

LC-E445T/LC-E345T, Epoxy Tooling Prepreg

Recommended Cure Cycle (Autoclave)

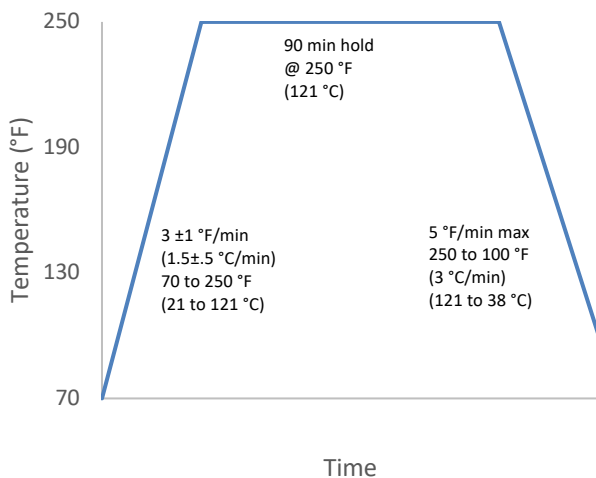
- Apply full vacuum at room temperature, 70 °F (21 °C)
- Ramp to 250 °F (121 °C) at a rate of 3±1 °F/min (1.5±.5 °C/min)
- At 100 °F (37 °C), apply 100 PSI (7 bar) gauge pressure
- Hold at 250 °F (121 °C) for 90 min
- Cool down to 100 °F (37 °C) at maximum rate of 5 °F/min (3 °C/min)
- Release Pressure/Vacuum
- Remove part from bag

Recommended Post Cure (Free Standing)

- Ramp to 250 °F (121 °C) at a rate of 3±1 °F/min (1.5±.5 °C/min)
- Hold at 250 °F (121 °C) for 60 min
- Ramp to 325 °F (162 °C) at a rate of 3±1 °F/min (1.5±.5 °C/min)
- Hold at 325 °F (162 °C) for 60 min
- Ramp to 400 °F (204 °C) at a rate of 3±1 °F/min (1.5±.5 °C/min)
- Hold at 400 °F (204 °C) for 8 hours
- Cool down to 100 °F (37 °C) at maximum rate of 5 °F/min (3 °C/min)

Note: Due to the reactive nature of this product, thicker tools may require an alternate cure and post cure cycles.

LC-E445T/LC-E345T: Initial Cure Cycle



LC-E445T/LC-E345T: Post Cure Schedule

