ENDUREDGE MAX

Modified Epoxy

NT-350HT Technical Data Sheet

NT-350HT Modified Epoxy Prepreg

Description

The NT-350HT Enduredge Max represents the next generation highly toughened prepreg resin technology. This novel prepreg product offers outstanding surface finish and laminate quality using vacuum bag only processing. Virtually unlimited out-time (with no refrigerated storage) with zero change in process parameters over time. NT-350HT allows the parts builder to efficiently build large out-of-autoclave structures with near zero voids, without complicated debulking processes or elaborate cure cycles. While NT-350HT was designed for OOA processing, it is perfectly suitable for in-autoclave processes as well. NT-350HT is suitable for aerospace secondary and primary structures, space and satellite structures and radomes.

Product Features

- Excellent Mechanical Properties – full mechanicals without post-cure
- No Freezer Storage; >12 months out-time at ambient storage conditions (70-80°F)
- Excellent Mechanical Properties with Vacuum Bag Only processing
- Unique engineered air release channels allows excellent OOA processing
- Very thick laminates can be produced without any debulk steps
- No changes in laminate processing conditions or rheology over time
- Optimized for high quality surface finish

Neat Resin Properties

Density 1.17 g/cc
Dk = 2.78 ; Df = 0.013
Moisture Absorption: 2.2%

DRY Tg	ONSET °F (°C)	LOSS MODULUS °F (°C)	TAN DELTA °F (°C)
Post	315°F (157°C)	367°F (185°C)	383°F (195°C)
Standard	260°F(127°C)	295°F (146°C)	307°F (153°C)

WET Tg	ONSET °F (°C)	TAN DELTA °F (°C)
Post	250°F (120°C)	290°F (143°C)
Standard	242°F (117°C)	282°F (139°C)

NEXX Prepregs are typically 40% RC.

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ALL DATA VACUUM BAG ONLY

Prepreg Electrical Properties on Fiberglass

PROPERTY (0°)	7781	6781
Dielectric Constant at 10 GHz (dry)	4.10	4.00
Loss Tangent at 10 GHz (dry)	0.012	0.012
Dielectric Constant at 10 GHz (24 hr water boil)	4.19	4.8
Loss Tangent at 10 GHz (24 hr water boil)	0.016	0.094

Prepreg Mechanical Properties on Fiberglass

PROPERTY (0°)	METHOD	7781
Flexural Strength	ASTM D7264	103 ksi (711 MPa)
Flexural Modulus	ASTM D7264	2.9 Msi (18.5 GPa)
Short Beam Shear	ASTM D2344	9.2 ksi (63.6 MPa)

All properties normalized to 60% fiber volume except ILSS (fiber volume 40-50%)

Prepreg Mechanical Properties on Carbon

PROPERTY (0°)	METHOD	CARBON FIBER
Tensile Strength	ASTM D3039	121 ksi (836 MPa)
Tensile Modulus	ASTM D3039	9.52 Msi (65.4 GPa)
Compressive Strength	ASTM D6641	93.7 ksi (648 MPa)
Compressive Modulus	ASTM D6641	9.71 Msi(66.7 GPa)
Flexural Strength	ASTM D7264	138 ksi (952 MPa)
Flexural Modulus	ASTM D7264	8.8 Msi (56.1 GPa)
Short Beam Shear	ASTM D2344	9.1 ksi (62.4 MPa)
Open Hole Compression	ASTM D6484	42 ksi*

Data normalized to 60% fiber volume
* OHC 3K 2x2 twill AS4D 0/45 all others on 3K Grafil TR30S 2x2 twill

Prepreg Mechanical Properties in Uni-Directional Fibers

PROPERTY	METHOD	RESULT
Tensile Strength	ASTM D3039	355 ksi (2451 MPa)
Tensile Modulus	ASTM D3039	21.9 Msi (150.4 GPa)
Compressive Strength	ASTM D6641	208.9 ksi (1440 MPa)
Compressive Modulus	ASTM D6641	20.4 Msi (140.6 GPa)
Flexural Strength	ASTM D7264	170.9 ksi (1178.3 MPa)
Flexural Modulus	ASTM D7264	19.9 Msi (137.1 GPa)
Short Beam Shear	ASTM D2344	12.4 ksi (85.0 GPa)

Hexcel IM-7 fiber NT-350 resin system autoclave cured
Normalized to 57% fiber content (except SBS)

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Epoxy Prepreg, Adhesive, and Resin: Guidelines & Handling Procedures

The following guidelines are provided to our customers to assure that best practices are used to attain the best results from NEXX Technology's epoxy products. Keep in mind that these procedures represent best practices for all composite prepreg and adhesive materials.

Freezer Storage

Freezer storage is not required. It will not damage the product but is completely unnecessary. The product is designed to be kept on the shop floor at temperatures below 100°F (37°C) for over a year with no changes in properties, rheology or processing conditions.

Use of Honeycomb & Foam Core Materials

When using nonmetallic honeycomb and foam core materials for sandwich structures, the materials should always be dried in an oven prior to lay-up to drive off any moisture that may be in the core. The core should be cooled in the presence of a desiccant to avoid moisture uptake. Following drying, it is always best to use the material as soon as possible. Recommended core dry time/temp: 121°C (250°F) for 3-4 hours.

Handling Materials

When handling any prepreg materials, always wear clean, powder-free latex gloves. This assures that no hand oils are transferred to the prepreg and/or composite during processing. The presence of oils in the part could lead to problems in both mechanical and electrical performance of the part. This also guards against dermatitis that may occur with some users.

Moisture Absorption and Sensitivity

While very resistant to moisture absorption after cure, epoxies can be adversely affected by moisture uptake prior to cure. Other materials may experience moisture buildup when they are removed from frozen storage. Fortunately, the Enduredge prepreg does not require freezer storage. It will always be ready for immediate use.

Contact Information

NEXX TECHNOLOGIES an MGC Company

Nexx-Technologies
c/o Mitsubishi Gas Chemical America, Inc.
655 Third Avenue
19th Floor
New York, NY 10017
(212) 687-2810
www.enduredge.com
www.mgc-a.com

North America & Asia Pacific
NAsales@nexx-technologies.com
(718) 877-6217

Europe, Middle East & Africa
EUsales@nexx-technologies.com
(718) 877-6217

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AIRTECH ADVANCED MATERIALS GROUP

Airtech International
5700 Skylab Rd.
Huntington Beach, CA 92647
(714) 899-8100
www.airtech.com

Airtech Europe SARL
18, ZI Haneboesch
L - 4562 Differdange
Luxembourg
Phone: 352 58.22.82
Email : sales@airtech.lu
www.airtech.lu

Tygavac Advanced Materials Ltd
The Causeway, Broadway Business Park
Chadderton, Oldham
OL9 9XD United Kingdom
Phone: +44 161 947 1610
Email: sales@tygavac.co.uk
www.tygavac.co.uk

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