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NCAMP Material Specification

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Standard Operating Procedures, NSP 100*

Medium Temperature, Out-of-Autoclave, Oven-Vacuum-Bag Cure Epoxy Resin
Impregnated Fiber Reinforced Composite Materials, Type 32, Class 1, Grade 145
(Solvay (formerly Cytec & Advanced Composites Group) MTM45-1 IM7 Tape)

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REVISIONS:

Rev	By	Date	Pages Revised or Added
N/C	Michelle Man, Vinsensius Tanoto, Yeow Ng, John Tomblin	7/17/2018	Document Initial Release.
A	Vinsensius Tanoto, Royal Lovingfoss	4/22/2024	All Sections: <ul style="list-style-type: none"> • Formatting. Cover Page: <ul style="list-style-type: none"> • Clay Scoggins (Solvay) was added as reviewer. Revision Table: <ul style="list-style-type: none"> • Revision Table was added. QUALIFIED PRODUCTS LIST: <ul style="list-style-type: none"> • Supplier Product Designation name was revised from “MTM45-1/IM7-145-32%RW” to “MTM45-1-32%-12KIM7GP-145-610 (Formerly MTM45-1/IM7-145-32%RW)”. • Supplier Name additional information was added, “Cytec Engineered Materials Inc. (a member of the Syensqo group). • Production Location was revised from “5350 South 129th East Avenue, Tulsa, OK 74134, USA” to “4300 Jackson Street, Greenville, TX 75402, USA”.

1. SCOPE:

1.1 Form:

This detail specification along with the base specification NMS 451 establishes the requirements for continuous unidirectional carbon fiber impregnated with a modified B-staged epoxy resin (“unidirectional tape prepreg”). The prepreg is produced using a hot-melt process.

This detail specification follows the section and table numbering scheme of the base specification. It contains additional or superseding requirements. The base specification shall govern where no additional requirement is specified; in such cases, the applicable sections are omitted from this detail specification.

1.3 Classification: All products qualified to this detail specification have the following classification: Type 32, Class 1, Grade 145

3. TECHNICAL REQUIREMENTS:

Table 1 – Prepreg Physical and Chemical Properties

Property	Test Method ⁽¹⁾	Number of Replicates	Requirements ⁽³⁾
Resin Content	ASTM D3529	Every roll ⁽²⁾	32±3% ind. 32±2% avg.
Fiber Areal Weight	SACMA SRM 23R-94	Every roll ⁽²⁾	145±7 gsm ind. 145±5 gsm avg.
Volatile Content	ASTM D3530	First and last rolls of every batch ⁽²⁾	2% max ind. 0.74% max avg.
Flow	ASTM D3531	First and last rolls of every batch ⁽²⁾	12±5 % avg.
Gel Time	ASTM D3532	Optional	60±6 minutes ind.
Tack	See 4.6.1	First and last rolls of every batch	Level IV
Drape	See 4.6.2	First and last rolls of every batch	Pass
HPLC	SACMA SRM 20R-94	One roll per batch ⁽⁴⁾	P1/P2 = 0.75 to 1.35 P1/P3 = 1.0 to 2.25 P1/P4 = 0.5 to 0.95
FTIR	ASTM E168 ASTM E1252	One roll per batch ⁽⁴⁾	A798/A1481 = 0.9 to 1.15
Differential Scanning Calorimetry (DSC) exotherm peak temperature	SACMA SRM 25R-94	Every resin batch	442.4 to 453.2 °F

- (1) Specific procedures should be identical to those used in the original material qualification program.
- (2) Three specimens should be taken across the width of the prepreg; left, center, right.
- (3) "ind." refers to individual measurements. "avg" refers to the average measurements per roll. Limits computed at $\alpha=0.01$ and modified CV.
- (4) Optional to perform HPLC and/or FTIR; Two specimens should be tested per sampled roll.

3.2 Constituent Material Requirements:

3.2.2 Reinforcement: Efforts to qualify the carbon fiber to NCAMP carbon fiber material specification, NMS 818, are ongoing. In the meantime, Solvay will continue to provide aerospace-grade carbon fiber for this prepreg per the prepregger's carbon fiber procurement specification and Solvay's internal aerospace-grade PCD. In addition, the following change control is implemented on the carbon fiber:

The carbon fiber tow product manufacturer shall establish control factors which will yield product meeting the technical requirements of this specification. The factors which are used in the production of fiber tow used in the prepreg material qualification shall constitute the approved factors; they shall be used for manufacturing production carbon fiber tow product. Control factors are Controlled Process Equipment and Controlled Process Parameters for producing the product. Control factors include, but are not limited to, the following:

- a) PAN Precursor formulation (raw ingredients and ratios),
- b) PAN Precursor manufacturing process, equipment, line, or site,
- c) PAN Precursor acceptance requirements,
- d) Carbon fiber tow processing parameters (e.g. temperature and speed),
- e) Carbon fiber tow manufacturing equipment, line, or site,
- f) Carbon fiber tow acceptance requirements,
- g) Carbon fiber tow acceptance test methods,
- h) Carbon fiber tow acceptance sampling plan,
- i) Carbon fiber tow surface treatment methods and levels,
- j) Carbon fiber tow sizing formulation and sizing level, and
- k) Carbon fiber tow sizing application and drying methods, including equipment.

If it is necessary to make any change in the above control factors, the carbon fiber tow product manufacturer shall submit for re-approval to NCAMP through the prepreg manufacturer in accordance with NRP 101 Prepreg Process Control Document (PCD) Preparation and Maintenance Guide. NRP 102 Polyacrylonitrile-based Carbon Fiber Process Control Document (PCD) Preparation and Maintenance Guide may be used as a reference. The change shall not be incorporated prior to the receipt of re-approval notice, typically in the form of a signed Advanced Change Notice (ACN).

3.5 Laminate (Cured Prepreg) Requirements:

3.5.2 Cured Laminate Physical Properties:

TABLE 3 - Cured Laminate Physical Properties

Property	Test Method ⁽¹⁾	Requirements ⁽²⁾
Cured Ply Thickness ⁽³⁾	SACMA SRM 10R-94	0.00521 and 0.00588 inch, avg.
Dry Glass Transition Temperature, Tg by DMA	SACMA SRM 18R-94	332.2 and 382.5 °F, ind.

⁽¹⁾ Specific procedures should be identical to those used in the original material qualification program.

⁽²⁾ "ind." refers to individual measurements. "avg." refers to the average measurements per panel.

⁽³⁾ Computed from actual qualification panel thicknesses and theoretical nominal CPT. Limits computed at $\alpha=0.01$ and modified CV.

3.5.3 Cured Laminate Mechanical Properties:

TABLE 4 - Required Cured Laminate Tests for Mechanical Properties (Class 1)

Property	Test Method ⁽¹⁾	Requirements ⁽³⁾
0/90° Tension Strength and Modulus, Room Temperature Dry Layup: [0/90] _{4S}	ASTM D3039	Strength ⁽²⁾ : Min. Ind. ≥ 145.50 ksi Strength ⁽²⁾ : Average ≥ 168.10 ksi Modulus ⁽²⁾ : 10.6 and 12.6 msi, avg.
90/0° Compression Strength, Room Temperature Dry Layup: [90/0] _{4S}	ASTM D6641	Strength ⁽²⁾ : Min. Ind. ≥ 69.98 ksi Strength ⁽²⁾ : Average ≥ 88.61 ksi, avg.
0° Short Beam Strength, Room Temperature Dry Layup: [0] ₁₆	ASTM D2344	Strength: Min. Ind. ≥ 11.80 ksi Strength: Average ≥ 13.47 ksi

⁽¹⁾ Specific procedures should be identical to those used in the original material qualification program.

⁽²⁾ Normalize the properties to a nominal cured ply thickness (CPT) value of 0.0055 inch based on theoretical nominal CPT, using the following equation:
Normalized_Value = Measured_Value x Measured_CPT / Nominal_CPT.

⁽³⁾ "ind." refers to individual measurements. "avg" refers to the average of 5 replicates. Limits computed at $\alpha=0.01$ and modified CV.

QUALIFIED PRODUCTS LIST

Supplier Product Designation	Supplier Name and Production Location	Date Qualified	Specification Callout ⁽¹⁾
MTM45-1-32%-12KIM7GP-145-610 (Formerly MTM45-1/IM7-145-32%RW)	Supplier Name: Cytec Engineered Materials Inc. <i>(a member of the Syensqo group)</i> Production Location: 4300 Jackson Street Greenville, TX 75402 USA Cage Code: 0LHZ4	March 28, 2018	NMS 451/6 Classification callout is optional because Type 32, Class 1, Grade 145 is the only classification allowed in this QPL.

- ⁽¹⁾ In accordance with NCAMP Standard Operating Procedures, NSP 100, this QPL shall not contain alternate materials/products. Additional production location may be included in the QPL only after successful equivalency demonstration and approval per NCAMP Prepreg Process Control Document (PCD) Preparation and Maintenance Guide, NRP 101.
- ⁽¹⁾ The proper specification callout for material procurement purpose is “NMS 451/6.” This specification was developed based on the material properties that are available publicly. The purchaser may specify additional requirements beyond those specified in this specification, especially when the purchaser has generated additional material properties beyond those available publicly or when the application requires additional requirements. The additional requirements are subject to supplier review and approval.