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NCAMP Material Specification

*This specification is generated and maintained in accordance with NCAMP
Standard Operating Procedures, NSP 100*

Carbon Fiber Reinforced Epoxy Resin Prepregs, Type 33, Class 1, Grade 148
(TenCate Advanced Composites BT250E-6 IM7 GP Unidirectional Tape)

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Distribution Statement A. Approved for public release; distribution is unlimited.

1. SCOPE:**1.1 Form:**

This detail specification along with the base specification NMS 250 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 33, Class 1, Grade 148.

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⁾	33±5% ind 33±3% avg
Fiber Areal Weight	SACMA SRM 23R-94	Every roll ⁽²⁾	148±13 gsm ind 148±10 gsm avg
Volatile Content	ASTM D3530	First and last rolls of every batch ⁽²⁾	2% max, avg
Flow	ASTM D3531	First and last rolls of every batch ⁽²⁾	8.0 to 14.0
Gel Time	ASTM D3532	First and last rolls of every batch ⁽²⁾	5.0 to 25.0
Tack	See 4.6.1	First and last rolls of every batch	Level IV or V
Drape	See 4.6.2	First and last rolls of every batch	Pass
HPLC (Optional)	SACMA SRM 20R-94	First and last rolls of a batch	See QPL
FTIR	ASTM E168 ASTM E1252	First and last rolls of every batch, one test per roll	See QPL
Differential Scanning Calorimetry (DSC) exotherm peak temperature total heat of reaction	SACMA SRM 25R-94	First and last rolls of every batch	See QPL

- (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.

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, TenCate will continue to provide aerospace-grade carbon fiber for this prepreg per the prepregger's carbon fiber procurement specification, TCRMS 03-01-138 Rev B and TenCate'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⁾	ASTM D3171	0.0055 to 0.0061 inch, avg
Dry Glass Transition Temperature, T _g by DMA ⁽⁴⁾	by flexural loading per ASTM D7028	263.24 to 299.24 °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. Limits computed at α=0.01 and modified CV.

⁽⁴⁾ Limits computed from average qualification data ± 18 °F.

3.5.3 Cured Laminate Mechanical Properties:

TABLE 5 - Required Cured Laminate Tests for Mechanical Properties (Class 1)

Property	Test Method ⁽¹⁾	Requirements ⁽³⁾
0° Tension Strength and Modulus, Room Temperature, Ambient Layup: [0] ₈	ASTM D3039	Strength ⁽²⁾ : Min. Ind. ≥ 269.00 ksi Strength ⁽²⁾ : Average ≥ 322.00 ksi Modulus ⁽²⁾ : Between 21.00 and 24.23 msi, avg
90/0° Compression Strength, Room Temperature, Ambient Layup: [90/0/90] ₇	ASTM D6641	Strength ⁽²⁾ : Min. Ind. ≥ 61.50 ksi Strength ⁽²⁾ : Average ≥ 72.00 ksi Modulus ⁽²⁾ : Between 6.75 and 8.00 msi, avg
0° Short Beam Strength, Room Temperature, Ambient Layup: [0] ₄₅	ASTM D2344	Strength: Min. Ind. ≥ 7.06 ksi Strength: Average ≥ 8.80 ksi

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

⁽²⁾ Normalize the properties to a cured ply thickness value of 0.0058 inch, based on actual qualification panel thicknesses.

⁽³⁾ “ind” refers to individual measurements. “avg” refers to the average of 5 replicates. Limits computed at α=0.01 and modified CV.

QUALIFIED PRODUCTS LIST

Supplier Product Designation	Supplier Name and Production Location	Date Qualified	Specification Callout ⁽¹⁾
TenCate Advanced Composites IM7 GP Unidirectional Tape	Supplier Name: TenCate Advanced Composites Production Location: 18410 Butterfield Blvd Morgan Hill, CA 95037	October 20, 2017	NMS 250/1 Classification callout is optional because Type 33, Class 1, Grade 148 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 250/1.” This specification is 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.