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NCAMP Material Procurement Specification

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

Tenax™ Dry Reinforcement (Carbon Fiber)  
Class 2, Style UD, Grade 190

Prepared by: Michelle Man (NCAMP), Alfonso Lopez (Teijin Carbon), Elisabeth Boeck (Teijin Carbon)

Reviewed by: Royal Lovingfoss (NIAR), John Tomblin (NIAR), Rachael Andrulonis (NIAR), Ed Hooper (NCAMP AER), Patrick Kistner (Teijin Carbon), Vera Richter (Teijin Carbon), Joe Spangler (Formerly at Teijin Carbon)

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National Center for Advanced Materials Performance  
Wichita State University – NIAR  
1845 Fairmount Ave., Wichita, KS 67260-0093, USA

## REVISIONS:

Rev	By	Date	Pages Revised or Added
N/C	Michelle Man	12/20/2022	Document Initial Release
A	Michelle Man	06/30/2025	Updated Solvay to Syensqo, requirements in Section 2.

## 1 SCOPE:

### 1.1 Form:

This detail specification along with the base specification NMS 241F establishes the requirements for unidirectional dry reinforcement woven fabric. This detail specification is intended to be used with an NCAMP qualified resin material specification and process specification to produce qualified acceptance specification limits.

This detail specification provide specific material properties called out in the base specification and may contain 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.

### 1.2 Classification:

All products qualified to this detail specification have the following classification: Class 2, Style UD, Grade 190, Unidirectional Woven Fabric (Uni-Fabric).

### 1.3 Reinforcement Fabric Construction.

The construction of this reinforcement fabric consists of 0°/V; the 0° carbon fibers followed by a layer of veil. The carbon fiber is woven with a combi-fusible bonding yarn with the veil applied on top of the woven UD. Figure 1 illustrates the detailed construction of the reinforcement.



Figure 1 Detail Construction of the woven fabric (Uni-Fabric)

## 2 Physical and Chemical Property Requirements:

Dry reinforcement testing to meet the requirements detailed in this specification shall be performed on every lot of material and shall be the responsibility of the material supplier.

Table 2-1 – Reinforcement Physical Properties

Property	Test Method <sup>(1)</sup>	Number of Replicates per lot	Requirements <sup>(2)</sup>
Product Areal Weight	DIN EN 12127 (Cramer-Method No. U02.1-01- 02)	3	196 ± 5.00 gsm, ind. 196 ± 5.00 gsm, avg.
Setting Weft	Cramer-Method No. U02.1-01- 03	1	1.50 ± 0.10, ind. 1.50 ± 0.10, avg.
Material Width 50"	Cramer-Method No. U02.1-01- 05	3	1270 ± 20 mm

<sup>(1)</sup> Specific procedures should be identical to those used in the original material qualification program. Cramer internal standards may be requested from the supplier.

<sup>(2)</sup> "ind." refers to individual measurements. "avg." refers to the average measurements per roll.

The following sampling Interval shall be used:

A standard unit of reinforcement fabric (RF) is defined to an area of 175 m<sup>2</sup>, independent of the width and weight of the RF and the actual size of the produced units.

The number of units to be tested in relation to the number of units in a production lot is given in the following table.

The first ten production lots of a newly qualified material shall be tested according to statistical distribution. Further production lots shall be tested in accordance with the normal distributions unless otherwise agreed between the supplier and purchaser.

Number of Standard Units in a production lot (n)	Number of standard units to be tested (x)	
	Normal	Statistical
01 – 03 (0 m <sup>2</sup> – 525 m <sup>2</sup> )	1	Each Unit
04 – 15 (525 m <sup>2</sup> - 2.625 m <sup>2</sup> )	2	3
16 – 25 (2.625 m <sup>2</sup> - 4.375 m <sup>2</sup> )	4	4
26 – 40 (4.375 m <sup>2</sup> - 7.000 m <sup>2</sup> )	5	5
>= 41 ( >= 7.000 m <sup>2</sup> )	7	7

The unit number to be sampled shall be in accordance with the following:

- Two units sampled: First and last produced roll
- More than two units sampled: First and every  $n / (x-1)$  unit to be tested (to the lowest number)

## 2.1 Constituent Material Requirements:

2.1.1 Reinforcement: The carbon fiber tow is a Tenax™ - E IMS65 E23 24K 830 tex fibers and are manufactured in accordance with NMS 818/15.

### 3 Related Specifications

The following are NCAMP qualified materials and process specifications that may be used with this material.

Document type	Specification Number	Document Name
Process Specification	NPS 82401	Fabrication of NMS 241 Qualification, Equivalency, and Acceptance Test Panels for Vacuum Assisted Resin Transfer Molding of Carbon Fiber Reinforcements with Syensqo PRISM™ EP2400 toughened epoxy resin
Material <b>Procurement</b> Specification	NMS 241R/1	Resin Specification: Syensqo PRISM™ EP 2400 Toughened Epoxy Resin (formerly Solvay)
Material <b>Acceptance</b> Specification	NMS 241/3	Oven Cure of VARTM Processed Dry Reinforcements with Toughened Epoxy Resin – Tenax™ UD Woven DRWF with Syensqo PRISM™ EP2400 Resin (formerly Solvay)

## QUALIFIED PRODUCTS LIST

Supplier Product Designation	Supplier Name and Production Location	Date Qualified	Specification Callout <sup>(1)</sup>
DRWF IM UD 0190 720004	<b>Fiber Supplier Name:</b> Teijin  <b>Production Location:</b> C. Cramer & Co. GmbH Eper Straße 45-47 48619 Heek Germany  Textile Production Line: 231x	May 2025	NMS 241F/3  Material QPL:  Classification callout is optional because Class 2, Style UD, Grade 190, Dry reinforcement woven fabric is the only classification allowed in this QPL

<sup>(1)</sup> 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 Process Control Document (PCD) Preparation and Maintenance Guide, NRP 101.

<sup>(1)</sup> **The proper specification callout for material procurement purpose is “NMS 241F/3”.** 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.

**Class 2 Product Key (for reference only)**

Product Designation	Description	Construction	US Product key	European Product key
DRWF IM UD 0190 720004	V6_04-IMS65-UDY5_RP15-0190	0°/V	C720004-50	720004