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

Medium Temperature, Out-of-Autoclave, Oven-Vacuum-Bag Cure Epoxy Resin Impregnated Fiber Reinforced Composite Materials, Type 36, Class 2, Grade 193, Style 3k-70-PW

(Old reinforcement name: G30-500 3k-70-PW)
(New reinforcement name: HTS40 E13 3k-70-PW)
(Solvay reinforcement name: CF0526A)

Solvay (Formerly Cytec, Umeco Structural Materials (USM-OK), The Advanced Composites Group (ACG)) MTM45-1 CF0526A-36%RW

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REVISIONS:

Rev	By	Date	Pages Revised or Added
N/C	Yeow Ng and John Tomblin		Document DRAFT REVISION
A	Yeow Ng and John Tomblin	9/26/2012	Document Initial Release
B	Vinsensius Tanoto, Royal Lovingfoss	5/16/2016	• Removed NASA logo from cover page. • Added Royal Lovingfoss and Vinsensius Tanoto as reviewers on cover page. • Added Greenville facility in the QPL.
C	Vinsensius Tanoto, Royal Lovingfoss	8/15/2018	• Added Revisions Table on page 2. • Revised DSC to 442.4 to 453.2 ºF.
D	Vinsensius Tanoto, Royal Lovingfoss	8/8/2019	• Updated cover page to reference CF0526A-36%RW. • Added Chris Ridgard (Solvay), Chad Duplantis (Solvay), and Gene Spinks (Solvay) to the reviewer list.

1. SCOPE:

1.1 Form:

This detail specification along with the base material specification NMS 451 establishes the requirements for carbon fiber fabric impregnated with a modified B-staged epoxy resin (“fabric 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 36, Class 2, Grade 193, Style 3k-70-PW

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)	36±3% ind. 36±2% avg.
Fiber Areal Weight	ASTM D3776 or SACMA SRM 23R-94	Every roll(2)	193±9 gsm ind. 193±8 gsm avg.
Volatile Content	ASTM D3530	First and last rolls of every batch(2)	1.0% max ind. 0.77% max avg.
Flow	ASTM D3531	First and last rolls of every batch(2)	17.0% to 23.8% avg.
Gel Time	ASTM D3532	Optional	54.2 to 67.2 min avg.
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
IR	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 ºF

(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 α=0.01 and modified CV.
(4) Optional to perform either HPLC or IR.

3.2 Constituent Material Requirements:

3.2.2 Reinforcement: The carbon fiber tow shall be qualified to NMS 818/10. The fabric weaving is controlled through prepreg PCD and NRP 101.This product does not contain tracer yarn. Tracer yarn may be included only if it is specifically requested by the purchaser. The inclusion of tracer yarn might alter the material properties.

3.4 Visual and Dimensional Requirements:

3.4.4 Roll characteristics - The standard width for this product is 50 inches. Other widths may be supplied only if it is specifically requested by the purchaser.

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	0.00749 to 0.00847 inch, avg.
Dry Glass Transition Temperature, Tg by DMA	SACMA SRM 18R-94	354.1 to 385.8 ºF 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 α=0.01 and modified CV.

3.5.3 Cured Laminate Mechanical Properties:

TABLE 5 - Required Cured Laminate Tests for Mechanical Properties (Class 2)

Property	Test Method[1]	Requirements[3]
0° (warp) Tension Strength and Modulus, Room Temperature Dry Layup: $[0]_{14}$	ASTM D3039	Strength[2]: Min. Ind. $\geq$ 114.10 ksi Strength[2]: Average $\geq$ 131.20 ksi Modulus[2]: 8.50 to 9.98 msi, avg.
90° (fill) Compression Strength and Modulus, Room Temperature Dry Layup: $[90]_{18}$	ASTM D6641	Strength[2]: Min. Ind. $\geq$ 69.37 ksi Strength[2]: Average $\geq$ 81.08 ksi Modulus[2][4]: 7.50 to 8.91 msi, avg.
90° (fill) Short Beam Strength, Room Temperature Dry Layup: $[0]_{18}$	ASTM D2344	Strength: Min. Ind. $\geq$ 8.39 ksi Strength: Average $\geq$ 9.58 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 0.0079 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. Unless otherwise noted, the specification limits are derived using the statistical methods in CMH-17 Rev G, Volume 1, section 8.4.1 with α=1% and n=5 along with modified coefficient of variation approach in section 8.4.4.

[4] Permissible to use a minimum of one specimen with strain gage.

QUALIFIED PRODUCTS LIST

Supplier Product Designation	Supplier Name and Production Location	Date Qualified	Specification Callout[1]
MTM45-1/CF0526A-36%RW	Supplier Name: Solvay (Formerly Umeco Structural Materials) Production Location: 5350 South 129th East Avenue Tulsa, OK 74134 USA	9/26/2012	NMS 451/13 Classification callout is optional because Type 36, Class 2, Grade 193, Style 3k-70-PW is the only classification allowed in this QPL.
MTM45-1/CF0526A-36%RW	Supplier Name: Solvay (Formerly Umeco Structural Materials) Production Location: 4300 Jackson St Greenville, TX 75402 USA	9/29/2017	NMS 451/13 Classification callout is optional because Type 36, Class 2, Grade 193, Style 3k-70-PW 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 451/13.” 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.