

COMPOTOOL BoxPreg

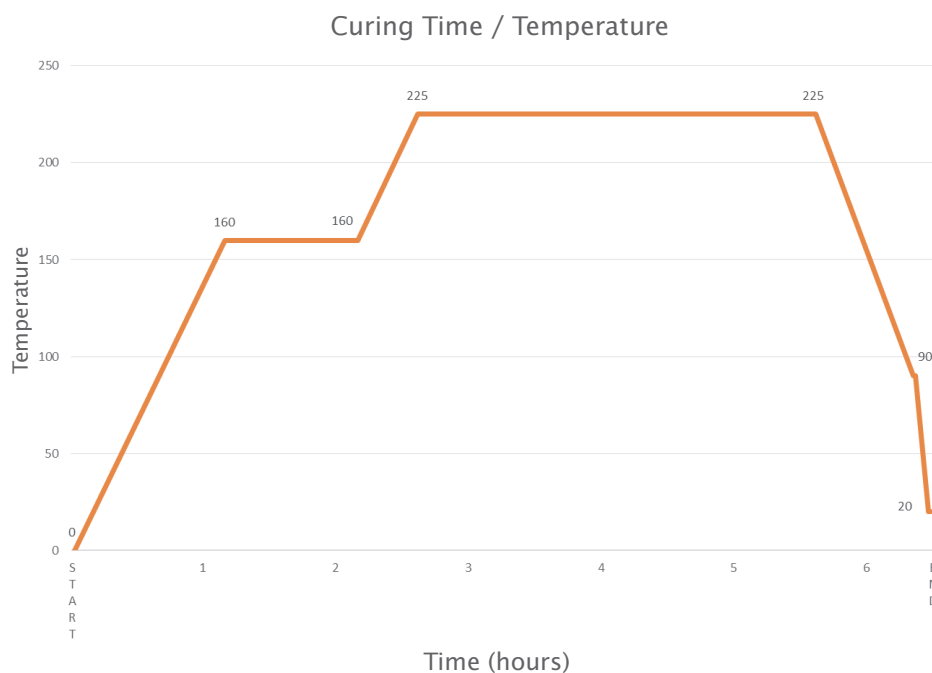
COMPOTOOL BoxPreg is a high temperature Benzoxazine tooling prepreg for high production tooling. BoxPreg can be cured on the COMPOTOOL board at 225°C (435°F) with a fast single cure cycle reducing demand on autoclave time. BoxPreg in combination with COMPOTOOL tooling boards significantly reduce tooling production time and costs. BoxPreg offers superior handling characteristics and 6 months working life at room temperature. High accuracy composite tooling can be produced in hours.

Key Features:

- 6 months out life at room temperature ($\leq 25^{\circ}\text{C}/75^{\circ}\text{F}$).
- 24 months storage at -18°C (-40°F).
- 260°C (500°F) TG ideal for high production tooling.
- Low shrinkage for improved dimensional tolerance.
- Full cure on Compotool master model eliminating post cure off the master model distortion.
- Fast cure cycles.

Technical Information:

	BOX200	BOX650
Fabric weight and weave	200 g/m ² 3K 2X2 Twill	650 g/m ² 12K 2X2 Twill
Prepreg Weight (Grams/m ²)[lbs/ft ²]	345 (.070)	995 (.204)
Resin Weight % (± 3)	42	37
Autoclave Cured Ply Thickness (mm) [Inches]	0.23 (.009)	0.68 (.027)
Glass Transition Temperature (Tg)	260°C (500°F)	260°C (500°F)
Continuous Use Temperature	190°C (375°F)	190°C (375°F)
Maximum Short Use Temperature	220°C (428°F)	220°C (428°F)
Shrinkage %	0.025	0.025
CTE 10^{-6} K^{-1} (10^{-6} F^{-1})	2.5 (1.39)	2.5 (1.39)



Curing Information:

1. Apply full vacuum at 0.97 Bar (14 Psi).
2. Apply 6.2 Bar (90 Psi) autoclave pressure then vent to atmosphere when pressure exceeds 1 Bar (14.5 Psi).
3. Ramp the laminate temperature up at a rate of 1~3°C (4~5°F) per minute until the lagging thermocouple reaches a temperature of 160 ±3°C (320 ±37°F).
4. Dwell at 160 ±3°C (320 ±5~°F) for 60 minutes.
5. Ramp the laminate temperature up at a rate of 1~3°C (4~5°F) per minute until the lagging thermocouple reaches a temperature of 225° ±3°C (437° ±37°F).
6. Dwell at 225° ±3°C (437° ±5°F) for 3 hours.
7. Cool to below 90°C (194°F) at a rate of 3°C (5°F) per minute before dumping pressure and removing from the autoclave.

For alternate cure cycles please contact your local Compotool representative.

Storage:

COMPOTOOL BoxPreg should be stored in protected area. Can be stored at room temperature for less than 6 months if the materials will be stored longer then keep below -18° (0°F).

Supply:

Compotool BoxPreg is available in 1.27 meter (50 Inch) wide rolls or in 423 x 423mm (16.6 x 16.6 Inch) squares. For other custom sizes please contact your local Compotool representative.

Health and Safety:

FOR INDUSTRIAL OR PROFESSIONAL USE ONLY.

DO NOT HANDLE UNTIL PRECAUTIONS ON THE SAFETY DATA SHEET HAS BEEN CAREFULLY READ AND UNDERSTOOD.

FOR ADDITIONAL ENVIROMENTAL, HEALTH AND SAFTY INFORMATION REFER TO SAFETY DATA SHEET.

BY ACCEPTING THE GOODS SUPPLIED BY COMPOTOOL SELLER AND BUYER AGREE TO THE FOLLOWING LIMITED WARRANTY AND REMEDIES LIMITATIONS:

COMPOTOOL warrants that goods sold will be merchantable. If goods are defective, Buyer may return them at Buyer's cost to COMPOTOOL within 12 months of purchase for a full refund of the purchase price. Other than this limited warranty, there are no express or implied warranties. There is no warranty as to fitness for a particular use. COMPOTOOL recommends that The Buyer shall take all recommended safety precautions while working with the goods. COMPOTOOL and Buyer agree that other than return of the purchase price COMPOTOOL will not be liable for any damages, consequential damages or incidental damages. When handling this product prolonged skin contact may lead to skin irritation and airborne dust can be released. It is recommended that suitable gloves, respiratory and eye protection equipment are used when handling. When sanding and machining use appropriate dust extraction and work in a well-ventilated area.

All information contained in this data sheet is given in good faith and based on tests believed to be reliable. COMOPTOOL Ltd. makes no warranty of fitness for a particular use. It is the responsibility of the user to determine the suitability of the products for their intended use and to assume all risk and liability in connection with their use. This information will be periodically reviewed and may be subject to modification.