

Epoxy tooling prepreg system

RP802

Overnight Cure

Applications

- Composite tooling

TDS010





Description

RP802 is an epoxy tooling prepreg system capable of withstanding temperatures up to 190°C after full post cure.

RP-802 is available in carbon and glass woven fabrics from 200 - 800 g/m² impregnated with epoxy resin. RP-802 prepreg allows high quality tooling laminates to be produced directly from a low temperature master model permitting a wide choice of master model materials. Using a low temperature vacuum bag and autoclave process for initial cure, the tool laminate can then be demoulded for freestanding post cure.

Key Features & Benefits

- Initial cure from 60°C to 70°C
- Post cure: 170°C
- Autoclave processing
- Excellent surface finish

Shelf life

Storage Temperature	Shelf life
-18°C	12 months
20°C	Tack life: 10 days Out life: 12 days

Material Types

Fibre Type	Weave Style	Weight	Thickness/Ply	Width
Carbon	Twill 2/2	200 g/m ²	0.23 mm	1250 mm
Carbon	Twill 2/2	645 g/m ²	0.72 mm	1250 mm
Glass	8HS	300 g/m ²	0.25 mm	1250 mm
Glass	Twill 2/2	800 g/m ²	0.70 mm	1250 mm

Other fabric styles available



Cure Cycle

Preferred initial cure can be either of the following:

60°C for 16 hours
70°C for 8 hours

Heat ramp up rate: 0.5-1.0°C/minute up to temperature, under 6-7 bar pressure and >0.9 bar vacuum.

Ensure even heat in the autoclave and make sure that temperature does not exceed over 5°C of the component initial cure temperature.

When the entire component has reached the initial curing temperature, hold for the specified time.

Cool the laminate under pressure to room temperature (or <30°C) at 3°C per minute (max). Tooling can be demoulded from the master after this cure.

For post cure, the tool must rest on a level surface to prevent possible deformation. The recommended post cure cycle is as follows:

- From initial cure temperature, ramp up at 1°C per minute up to 170°C and cure for >2.5 hours, then cool naturally. This will provide a Tg >170°C (DSC).
- Post cure > 4h @ 170°C provides a Tg of 190°C (DSC).

The maximum heat ramp up rate at each stage is 1°C/minute.

Health and Safety: Refer to the Material Safety Datasheet before use.

Find out what PRF can do for your business

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Plastic Reinforcement Fabrics Ltd

