

L-291

Phenolic Fiberglass Facesheet



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Product Data Sheet

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Description

Fiberply L-291 (0°/90°) is a modified phenolic facesheet with self extinguishing and low heat release properties. L-291 (0°/90°) is intended to be used as a single ply or multiple ply skin for aramid/phenolic honeycomb or other cored aircraft interior sandwich panels.

Advantages of L-291

- ❖ The L-291 system processes easily in most platen presses and autoclaves.
- ❖ Improved strength and stiffness to weight ratios because excess resin deposits inherent with woven fiberglass prepregs are eliminated.
- ❖ Pre-plyed materials reduce the assembly labor in the production of sandwich panels.
- ❖ Reduced cost relative to woven prepregs because the complicated steps of weaving, stitching, heat-cleaning, and refinishing have been eliminated. The fiberply process produces adhesive prepreg directly from fiber and resin.
- ❖ The designer may order any length and width needed for a specific panel, thus reducing scrap.

Physical Properties

- *Standard Weight:* 0.150 lbs/ft² (732 g/m²)
- *Standard Resin Content:* 33% by weight
- *Volatile Content:* 10% Maximum by weight
- *Standard Tack:* Press Grade Medium
- *Cured Ply Thickness:* 0.014" (0.35 mm)
- *Other Weights and Resin Contents, and Fibers are Available.*

Availability

- 50" x 122" Sheets (127 cm x 310 cm)
- Custom Dimensions Available



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Shelf Life

- *6 months at 40°F (4°C) or below*
- *14 days at Room Temperature (70°F or 21°C)*

Cure Cycles

Press Cure:

- 1) *Heat press to minimum 260°F (127°C)*
- 2) *Insert panel or assembly into press. Close with 40 PSI (0.275 MPa) or Greater*
- 3) *Bump panel after 1 minute to release trapped volatiles generated from cure*
- 4) *Repeat as necessary until gas becomes negligible*
- 5) *Cure for 60 minutes at 260-270°F (126-132°C)*
- 6) *Cool to 170°F (77°C) under pressure, remove*

Autoclave Cure:

- 1) *Use plenty of breather in vacuum bag (no bleeder limits resin loss)*
- 2) *Apply full vacuum to part in autoclave*
- 3) *Ramp to 260°F (126°C) at 3-7°F/minute (2-4°C/minute) under pressure*
- 4) *Use 35 PSI (0.241 MPa) or greater autoclave pressure during ramp and cure*
- 5) *Cure for 60 minutes at 260-270°F (127°-132°C)*
- 6) *Cool to 170°F (77°C) under pressure, remove*

Flammability

Self Extinguishing per FAR Part 25.853

NOTICE:

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