

L-528

Woven Phenolic Prepreg



851 W. 18th Street
Costa Mesa, CA 92627
(949) 650-8106 Fax: (949) 631-6190
www.jdlincoln.com

Product Data Sheet

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Description

L-528 is a modified phenolic prepreg with excellent fire, smoke and toxicity properties. L-528 is the result of development aimed at creating a new generation of aircraft interior prepregs. L-528 is intended to be used as a single ply or multiple ply skin for aramid/phenolic honeycomb in aircraft interior honeycomb sandwich panels.

Advantages of L-528

- ❖ When used with L-310FR phenolic adhesive film, L-528 prepreg facings create sandwich panels with high peel strength and high toughness.
- ❖ Processing of L-528 can be easily adapted to most heated presses or autoclaves.
- ❖ L-528 is also an excellent laminating prepreg for air conditioning ducting and other interior laminate requirements.
- ❖ When tested per the FAA required OSU test, L-528 will allow the designer to create complex structure which meets stringent FAR requirements.

Physical Properties on 7781 Glass Fabric

- *Standard Weight:* 0.098 lbs/ft² (479 g/m²)
- *Standard Resin Content:* 38% by weight
- *Volatile Content:* 2-10%
- *Standard Tack:* Medium Tack
- *Cured Ply Thickness:* 0.010" (0.254 mm)
- *Other Weights, Resin Contents, and Fabrics are Available.*

Availability

- *Up to 60" width in rolls up to 100 yards long (152 cm x 91 m)*

Shelf Life

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

Cure Cycles

- *60 minutes at 275°F (135°C), or*
- *120 minutes at 260°F (127°C).*

Flammability

- *Self Extinguishing per FAR part 25.853*

Sandwich Properties*

Core: ¼" cell x 0.004" (6.35 mm cell x 0.10 mm) Aluminum Foil

Adhesive: 1 ply L-310FR each side

Facings: 2 plies L-528-7781 each side

- *RT Flatwise Tensile Strength: 900 PSI (6.2 MPa)*
- *RT Sandwich Peel Strength: 8 in lb/in (36 Nm/m)*

*Sandwich peel strength varies with the orientation of fibers directly against the core and test direction.

- ❖ Fibers laid up parallel with the test direction produce minimum strengths.
- ❖ Fibers laid up perpendicular to the test direction produce maximum strengths.
- ❖ L-528-7781 sandwich peel strength ranges from 5-10 in lb/in (22-44 Nm/m).

Mechanical Data

PROPERTY	LAMINATE PROPERTIES	
	50 PSI (0.34 MPa) CURE	TEST METHOD
ULTIMATE TENSILE STRENGTH		
Room Temperature (RT)	53 KSI (366 MPa)	ASTM D638
160°F (71°C)	51 KSI (352 MPa)	ASTM D638
RT(WET)	45 KSI (310 MPa)	ASTM D638
TENSILE MODULUS		
Room Temperature (RT)	3.5 MSI (24 GPa)	ASTM D638
160°F (71°C)	3.5 MSI (24 GPa)	ASTM D638
RT(WET)	3.4 MSI (23 GPa)	ASTM D638
ULTIMATE COMPRESSION STRENGTH		
Room Temperature (RT)	57 KSI (393 MPa)	ASTM D695
160°F (71°C)	56 KSI (386 MPa)	ASTM D695
RT(WET)	54 KSI (372 MPa)	ASTM D695
COMPRESSION MODULUS		
Room Temperature (RT)	3.5 MSI (24 GPa)	ASTM D695
160°F (71°C)	3.5 MSI (24 GPa)	ASTM D695
RT(WET)	3.5 MSI (24 GPa)	ASTM D695
ULTIMATE FLEXURAL STRENGTH		
Room Temperature (RT)	86 KSI (593 MPa)	ASTM D790
160°F (71°C)	76 KSI (524 MPa)	ASTM D790
FLEXURAL MODULUS		
Room Temperature (RT)	3.5 MSI (24 GPa)	ASTM D790
160°F (71°C)	3.2 MSI (22 GPa)	ASTM D790

NOTICE:

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