Description
HexPly® M27 is specifically designed for applications with fast curing cycles. It is ideally suited for high volume production techniques—in particular for ski manufacture. HexPly® M27 has been specially developed for UD-prepregs with high glass fiber weights, e.g., 1637–6548 lbs/ft² (500–2000 g/m²).

Features
• Suited to Press and Autoclave Manufacturing Methods
• Short Curing Cycles [Typically 12 min at 248°F (120°C)]
• Suitable for a Range of Pressure Cycles (1–10 Bar)
• Medium Flow for Ease of Processing
• No Tack
• No Volatiles
• Very Good Adhesive Properties to a Variety of Substrates (Aluminum, Steel, Wood, etc.)

Resin Matrix Properties
Gel time at 248°F (120°C) 5.5 min

Cured Matrix Properties
Glass transition temperature (Tg) 100 ± 8.3°F (5°C) 248°F (120°C) curing temperature

Prepreg Curing Conditions
The ideal cure cycle is 12 min at 248°F (120°C) at a pressure between 1 and 10 bar. The following alternative cure cycles can be used:

<table>
<thead>
<tr>
<th>Temperature °F (°C)</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>212 (100)</td>
<td>70 min</td>
</tr>
<tr>
<td>248 (120)</td>
<td>12 min</td>
</tr>
<tr>
<td>284 (140)</td>
<td>9 min</td>
</tr>
</tbody>
</table>
Shelf Life

**Tack life**
- at 95°F (+35°C) 3 days
- at 73°F (+23°C) 5 days

**Guaranteed shelf life***
- at 73°F (+23°C) 4 weeks
- at 0°F (−18°C) 12 months

* (maximum, from date of manufacture)

Storage

HexPly® M27 prepregs should be stored as received in a cool dry place or in a refrigerator. Following removal from refrigerated storage, allow the prepreg to reach room temperature before opening the polyethylene bag to avoid moisture condensation. (A full reel in its packaging can take 48 hours.)

Handling and Safety Precautions

Hexcel recommends that customers observe established precautions for handling uncured synthetic resins and fine fibrous materials. Operators working with this product should wear clean, impervious gloves to reduce the possibility of skin contact and to prevent contamination of the material.

Safety Data Sheets (SDS) have been prepared for all Hexcel products and are available to company safety officers on request from your nearest Hexcel Sales Office.

For more information

Hexcel is a leading worldwide supplier of composite materials to aerospace and industrial markets. Our comprehensive range includes:
- HexTow® carbon fibers
- HexForce® reinforcements
- HiMax® multiaxial reinforcements
- HexPly® prepregs
- HexMC®-i molding compounds
- HexFlow® RTM resins
- HexBond™ adhesives
- HexTool® tooling materials
- HexWeb® honeycombs
- Acousti-Cap® sound attenuating honeycomb
- Engineered core
- Engineered products
- Polyspeed® laminates & pultruded profiles
- HexAM® additive manufacturing

For U.S. quotes, orders and product information call toll-free 1-800-688-7734. For other worldwide sales office telephone numbers and a full address list, please go to:

[https://www.hexcel.com/contact](https://www.hexcel.com/contact)