



HexPly[®] 260

135°C curing phenolic matrix



Product Data Sheet

Description

HexPly 260 is a phenolic resin developed to meet such F.S.T. (Fire, Smoke, Toxicity) regulations and the 1990 O.S.U. index (65/65), for aircraft interior parts as: side wall panels, floor panel, galleys, ceiling panels and lavatories.

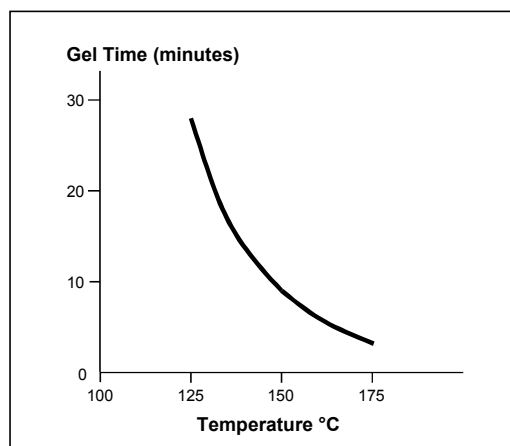
HexPly 260 prepreg is available in various fabric reinforcements

Benefits and Features

- Controlled flow matrix for easy processing
- Excellent tack life of 30 days at 25°C
- Self extinguishing
- Good peel properties
- Versatile cure cycle 125 - 150°C
- Suitable for vacuum bag, press and autoclave processes
- Maximum service temperature of 80°C

Resin Matrix Properties

Gel Time



Prepreg Curing Conditions

HexPly 260 system can be processed using various cure cycles, at a pressure between 0.8 to 3 bar.

Temperature (°C)	Time
125	2 hours
135	90 min
150	30 min

Heat up rate 1 - 3°C/min

Performance testing should accompany alternative cure cycles to ensure suitability for the particular application.



Fire Properties (Specific O.S.U. properties FAR 25 Amendment 66)

Heat Release Rate vs. Time		
	2 min Total KW min/m ² Requirement: 65	Peak KW/m ² Requirement: 65
Laminate - 4 plies		
7781 glass	35	43
G 874 hybrid	26	50
Sandwich (1) - 2 plies		
7781 glass	44	44
G 874 hybrid	37	40
Sandwich (1) - 2 plies + LHR Schneller film		
7781 glass	63	53
G 874 hybrid	59	53
Sandwich (2) - 3 plies + LHR Schneller film		
7781 glass	49	44
Fabric Style		
7781: 8 harness satin glass: 302 g/m ² and 0,230 µm ply thickness		
G 874: 65% glass/35% carbon: 170 g/m ² and 0,220 µm ply thickness		

⁽¹⁾ Nomex Honeycomb A1, 29 kg/m³ - thickness 3.17 mm ⁽²⁾ Nomex Honeycomb A1, 48 kg/m³ - thickness 20.3 mm

Cured resin density 1.18 g/cm³

Prepreg Storage Life

- Tack life @ 23°C 28 days
- Guaranteed shelf life @ -18°C 12 months (maximum from date of manufacture)

Precautions for Use

The usual precautions when handling uncured synthetic resins and fine fibrous materials should be observed, and a Safety Data Sheet is available for this product. The use of clean disposable inert gloves provides protection for the operator and avoids contamination of material and components.

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 US 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>

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