



EP255N Epoxy Prepreg

EP255N is a variant of the EP255 system. EP255N has increased mechanical performance over EP255. EP255N is a modified epoxy that is cured in the 235 to 275° F temperature range. It is self-adhesive to aramid and aluminum honeycomb. EP255N exhibits excellent strength properties and can be used for a wide variety of structural and aerospace applications. EP255N meets the requirements of MIL-R-9300B, type 1. EP255N has excellent resistance to ethylene glycol, hydrocarbon fluids and oils, Skydrol and water.

Mechanical Properties of EP255N-7781

Flexural Strength, psi	94,000
Flexural Modulus, psi	3,300,000
Tensile Strength, psi	63,000
Tensile Modulus, psi	3,650,000
Compressive Strength, psi	60,000
Compressive Modulus, psi	3,900,000
Short Beam Shear Strength, psi	8,600
Climbing Drum Peel, in-lbs/3 inch width	18 to 24

PROCESS INFORMATION – EP255N Prepreg

Autoclave Cycle

Draw vacuum and apply 45-70 psi autoclave pressure
Increase temperature at 5° F/minute to 240 - 250° F (part temperature)
Hold for 60 to 90 minutes
Cool to less than 150° F at 3 to 5° F/minute
Release pressure/vacuum and demold

Vacuum Bag in Oven Cycle

Draw vacuum
Increase temperature at 5° F/minute ramp to 175° F (optional)
Hold for 30 to 45 minutes (optional)
Increase temperature at 5° F/minute ramp to 240° F - 250° F
Cure for 60 to 90 minutes
Cool to less than 150° F at 3 to 5° F/minute
Release vacuum and demold

Press Cycle

45 to 60 minutes at 240° F to 25° F, 45 to 70 psi

Recommended Storage

- Room Temperature (77° F)	Four (4) Weeks
- 40° F	Six (6) Months
- 0° F	Twelve (12) Months

NOTE: EP255N Prepreg is wound with a polyethylene film liner for easy release. The rolls are sealed in polyethylene film bags to protect prepreg from moisture and other contaminants. The bags should remain sealed while the prepreg is under refrigeration and only removed when the prepreg has had sufficient time to warm to room temperature. When not in use, the prepreg should be returned to refrigerated storage. Care should be exercised to limit out-time of the prepreg in order to insure maximum shelf life. Torn bags should be replaced

NOTE: The data presented herein has been developed under controlled manufacturing and test conditions and is considered accurate. No warranty is expressed or implied regarding the accuracy or use of this data or the use of this product. It is the responsibility of the end user to determine suitability for use.