



FM5 Polyester Prepreg

FM5 is a toughened polyester system designed for table rolling applications such as fishing rods, antennae radomes and kayak paddle shafts. It offers precisely controlled flow, excellent resistance to bending set and extremely high flexural strength making it ideal for dynamic, low frequency applications.

Mechanical Properties of FM5

	7781	3743
Tensile Strength, psi	66,000	107,000
Tensile Modulus, psi	3,500,000	5,400,000
Flexural Strength, psi	97,000	160,000
Flexural Modulus, psi	3,250,000	4,600,000
Short Beam Shear Strength, psi	7,300	9,300

PROCESS INFORMATION – FM5

Autoclave Cycle

Draw Vacuum and apply 50 psi autoclave pressure
5°F/Minute Ramp to 175°F (optional)
Hold for 40 Minutes
5°F/Minute Ramp to 250°F to 265°F
Hold at 250°F to 265°F for 60 to 90 minutes
Cool to Less than 175°F at 3 to 5°F/Minute
Release Pressure/Vacuum and Demold

Vacuum Bag in Oven Cycle

Draw Vacuum
5°F/Minute Ramp to 175°F
Hold for 40 Minutes
5°F/Minute Ramp to 250°F to 265°F
Hold at 250°F to 265°F for 60 to 90 minutes
Cool to Less than 175°F at 3 to 5°F/Minute
Release Vacuum and Demold

Recommended Storage

- Room Temperature (77° F)	Twenty One (21) Days
- 40° F	Six (6) Months
- 0° F	Twelve (12) Months

NOTE: FM3 Prepregs are wound with a polyethylene film interliner for easy release. The rolls are sealed in polyethylene film bags to protect prepreg from air, moisture and other contaminants. The bags should remain sealed while the prepreg is stored 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.

Date: 05/01/06