



**LC194
Phenolic Prepreg**

LC194 is an advanced phenolic prepreg system that is self-adhesive to aramid/phenolic and aluminum honeycomb core. LC194 offers very good and consistent adhesion property values (climbing drum peel strength) over a wide range of cure/laminating conditions. LC194 is self-extinguishing, and meets flammability requirements for use in aircraft interiors. LC194 the most cost effective system available today.

Properties of LC194-7781

Flexural Strength, psi	90,000
Flexural Modulus, psi	3,500,000
Tensile Strength, psi	60,000
Tensile modulus, psi	3,400,000
Tensile Strain at Failure	1.9%
Compressive Strength, psi	72,000
Compressive Modulus, psi	3,700,000
Short Beam Shear Strength, psi	5,300
Climbing Drum Peel, in-lbs/inch width	6 - 9
OSU, Peak Heat Release Rate, kW/m ²	23 - 32
OSU, Total Heat Release Rate, kW-min/ m ²	18 - 24
(FAR 25.853 (d) Amdt. 25-83)	
Specific Optical Density, Ds (ASTM E662-96)	15 - 24

(Climbing Drum Peel, OSU and Specific Optical Density Specimens tested with two plies per side on aramid honeycomb, 0.25" thick, 3.0 pcf, 1/8" cell)

PROCESS INFORMATION – LC194

Autoclave Cycle

Draw vacuum and apply 40-60 psi autoclave pressure
 5°F/minute ramp to 235 - 250°F
 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
 5°F/minute ramp to 175°F (optional)
 Hold for 30 to 45 minutes (optional)
 5°F/minute ramp to 235°F - 250°F
 Hold 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 235°F to 250°F, 40 to 60 psi, bumps no later than 2 minutes into cycle

Recommended Storage

- Room Temperature (77° F)	Two (2) Weeks
- 40° F	Six (6) Months
- 0° F	Twelve (12) Months

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.