Product Overview

E-765 Epoxy Prepregs

Park's E-765 is a toughened 270°F cure epoxy prepreg system designed to replace 350°F cure systems in many aircraft structural applications. Park's E-765-3K-PW, -6K-5HS and 7781 materials are AGATE approved. FAA-approved, B-Basis design allowable databases for AGATE materials are available upon request. Park has also developed AGATE approved material and process specifications which are also available upon request.

Key Features & Benefits

- Designed to replace first generation 350°F (176°C) cure systems.
- Wide cure temperature process window of 260°F to 350°F (lower cures are possible depending on the application)
- Exhibits low void content, e.g., <2% after oven/vacuum cure.
- Excellent fiber property translation.
- 180°F Wet service temperature after ~270°F cure
- Good tack and drape characteristics after 30 days at room temperature

Product Forms

- Available on a wide variety of reinforcements including fiberglass and carbon
- Various Fabrics per customer requirements (e.g., plain, harness and twill weaves)
- Unitage and glass broad goods up to 60 inches wide
- Compatible with autoclave, vacuum bag/oven or press cure processes

Applications / Qualifications

- Primary Aircraft Structures
 - Fuselage
 - Wing
 - Control Surfaces
- Secondary Aircraft Structures
 - Fairings
 - Doors
 - Radomes
 - Bulkheads

For Information about Park's materials:

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A E R O S P A C E

Rev. 09-21

Technical Datasheet

E-765 Epoxy Prepregs

Nominal Prepreg and Laminate Physical Properties

Reinforcement	T700 Uni Tape	3K PW	6K 5HS	7781 E-Glass
Fiber Areal Weight (gsm)	150	193	370	303
Resin Solids (%)	35±3	38±3	40±3	38
Volatile Content (% Max)	1.0	1.0	1.0	1.0
Flow – 275F @ 15psi (%)	18±6	20±6	20±6	20±6
Tack	Medium	Medium	Medium	Light-Medium
Tg (dry, by DMA, onset storage mod.)	150° C / 300°F			
Gel time @ 275F (min)	2 - 6	2 - 6	2 - 6	2 - 6
Cure per ply thickness (in.)	0.0056	0.0089	0.0152	0.0098

Nominal Prepreg and Laminate Physical Properties

Reinforcement	12K 2x2 Twill	12K 2x2 Twill	12k 2x2 BW	120 E-Glass
Fiber Areal Weight (gsm)	370	670	635	107
Resin Solids (%)	40 +/- 3	40 +/-3	35 +/-3	45
Volatile Content (% Max)	1.0	1.0	1.0	1.0
Flow – 275F @ 15psi (%)	20±6	20±6	20±6	20±6
Tack	Light - Medium	Light-Medium	Light -Medium	Medium
Tg (dry, by DMA)	165° C / 330°F			
Gel time @ 275F (min)	2 - 6	2 - 6	2 – 6	2 - 6
Cure per ply thickness (in.)	0.015	0.022	0.023	0.005

Selected Laminate Electrical Properties

Reinforcement	Frequency	Dielectric Constant (Dk)	Loss Tangent (Df)
E-765 w/ E-Glass	9.375 GHz	4.5	0.020
E-765 w/ Quartz	9.375 GHz	3.4	0.015

Sandwich Panel Properties

Reinforcement	Property	Test Method	Mean Value
E-765 w/ T300	Climbing Drum Peel	ASTM-D-1781	4 in lb/in
3KPW	Flatwise Tensile Strength	ASTM-C-297	1000 psi

All test data provided are typical values and not intended to be specification values. For review of critical specification tolerances, please contact a Park representative directly. Park reserves the right to change these typical values as a natural process of refining our testing equipment and techniques.



AEROSPACE

Technical Datasheet

E-765 Epoxy Prepregs

Laminate Mechanical Properties - Carbon

Reinforcement	Laminate Mechanical Properties - Carbon						
Tiber Areal Weight (gsm) 150 193 370 370							
Cure Type Vacuum/Oven Vacuum/Oven Vacuum/Oven Autoclave Tensile Strength, 0° (Ksi) -65°F Dry 370 93 89 91 70°F Dry 370 95 86 100 180°F Dry 349 93 98 100 180°F Wet 333 96 100 ASTM-D-3039-95 Tensile Modulus (Msi) 8.9 9.9 70°F Dry 18.8 8.5 9.5 9.9 70°F Dry 18.7 8.2 9.3 9.3 180°F Wet 18.6 8.0 8.9 ASTM-D-3039-95 Wet 18.6 8.0 8.9 Compressive Strength (Ksi) -65°F Dry 180° 96 114 115 180°F Dry 177 77 83 82 180°F Wet 107 57 64 SACMA 1-94 </td <td>Uni Tape</td> <td>3K PW</td> <td></td> <td>6K 5HS</td>			Uni Tape	3K PW		6K 5HS	
Tensile Strength, 0° (Ksi)	Fiber Areal We	eight (gsm)	150	193	370	370	
-65°F Dry 370 93 89 91 70°F Dry 370 95 86 100 180°F Wet 333 96 100 ASTM-D-3039-95 Tensile Modulus (Msi) -65°F Dry 18.8 8.5 9.5 9.9 70°F Dry 18.7 8.2 9.3 9.3 180°F Wet 18.6 8.0 8.9 ASTM-D-3039-95 Compressive Strength (Ksi) -65°F Dry 180 96 114 115 180°F Wet 107 57 64 ASACMA 1-94 Compressive Modulus (Msi) -65°F Dry 17.9 7.8 10.3 10.1 70°F Dry 18.1 7.7 8.8 8.9 180°F Wet 107 57 64 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 17 11 8.5 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 13 10 11 12 180°F Wet 18.0 7.5 8.5 SACMA 1-94 In-plane Shear Strength, V-notched (Ksi) -65°F Dry 20 19 18 180°F Dry 180°F Wet 180°F W			Vacuum/Oven	Vacuum/Oven	Vacuum/Oven	Autoclave	
-65°F Dry 370 93 89 91 70°F Dry 370 95 86 100 180°F Wet 333 96 100 ASTM-D-3039-95 Tensile Modulus (Msi) -65°F Dry 18.8 8.5 9.5 9.9 70°F Dry 18.7 8.2 9.3 9.3 180°F Wet 18.6 8.0 8.9 ASTM-D-3039-95 Compressive Strength (Ksi) -65°F Dry 180 96 114 115 180°F Wet 107 57 64 ASACMA 1-94 Compressive Modulus (Msi) -65°F Dry 17.9 7.8 10.3 10.1 70°F Dry 18.1 7.7 8.8 8.9 180°F Wet 107 57 64 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 17 11 8.5 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 13 10 11 12 180°F Wet 18.0 7.5 8.5 SACMA 1-94 In-plane Shear Strength, V-notched (Ksi) -65°F Dry 20 19 18 180°F Dry 180°F Wet 180°F W	Tensile Streng	ıth, 0° (Ksi)					
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180°F Wet 333 96	70°F	Dry	370	95	86	100	
ASTM-D-3039-95 Tensile Modulus (Msi) -65°F Dry 18.8 8.5 9.5 9.9 -70°F Dry 18.7 8.2 9.3 9.3 -70°F Dry 18.2 7.9 9.0 9.2 -70°F Wet 18.6 8.0 8.9 -70°F Dry 18.6 8.0 8.9 -70°F Dry 18.0 96 114 115 -70°F Dry 180 96 114 115 -70°F Dry 177 77 83 82 -70°F Dry 177 77 83 82 -70°F Dry 177 77 83 82 -70°F Dry 17.9 7.8 10.3 10.1 -70°F Dry 18.1 7.7 8.8 8.9 -70°F Dry 18.4 7.5 8.9 8.8 -70°F Dry 18.4 7.5 8.9 8.8 -70°F Dry 18.4 7.5 8.9 8.8 -70°F Dry 18.4 7.5 8.9 8.5 -70°F Dry 17 11 -70°F Dry 13 10 11 12 -70°F Dry 9. 8 -70°F Dry 9. 18 10 11 12 -70°F Dry 16 14 15	180°F	Dry	349	93	98	100	
Tensile Modulus (Msi)	180°F	Wet	333	96		100	
-65°F Dry 18.8 8.5 9.5 9.9 70°F Dry 18.7 8.2 9.3 9.3 9.3 180°F Dry 18.6 8.0 8.9 8.9 ASTM-D-3039-95							
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180°F		,					
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Compressive Strength (Ksi)			18.6	8.0		8.9	
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180°F Dry 177 77 83 82 180°F Wet 107 57 64 Compressive Modulus (Msi) -65°F Dry 17.9 7.8 10.3 10.1 70°F Dry 18.1 7.7 8.8 8.9 180°F Dry 18.4 7.5 8.9 8.8 180°F Wet 18.0 7.5 8.5 Short Beam Shear (Ksi) -65°F Dry 17 11 70°F Dry 13 10 11 12 180°F Dry 9 8 180°F Wet 6 5 ASTM-D-2344 -65°F Dry 26 21 21 In-plane Shear Strength, Y-notched (Ksi) 18 18 18 180°F Dry 16 14							
180°F SACMA 1-94 Wet 107 57 64 Compressive Modulus (Msi) -65°F Dry 17.9 7.8 10.3 10.1 70°F Dry 18.1 7.7 8.8 8.9 180°F Dry 18.4 7.5 8.9 8.8 180°F Wet 18.0 7.5 8.5 Short Beam Shear (Ksi) -65°F Dry 17 11 70°F Dry 13 10 11 12 180°F Wet 6 5 -		,					
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Compressive Modulus (Msi) 17.9 7.8 10.3 10.1 70°F Dry 18.1 7.7 8.8 8.9 180°F Dry 18.4 7.5 8.9 8.8 180°F Wet 18.0 7.5 8.5 SACMA 1-94 Short Beam Shear (Ksi) 8.5 Short Beam Shear (Ksi) 70°F Dry 13 10 11 12 180°F Dry 9. 8 180°F Wet 6 5 ASTM-D-2344 In-plane Shear Strength, V-notched (Ksi) 21 21 70°F Dry 26 21 21 70°F Dry 16 14 15 180°F Wet 11 11 10		Wet	107	57		64	
-65°F Dry 17.9 7.8 10.3 10.1 70°F Dry 18.1 7.7 8.8 8.9 8.9 180°F Dry 18.4 7.5 8.9 8.5		Modulus (Msi)					
70°F Dry 18.1 7.7 8.8 8.9 180°F Dry 18.4 7.5 8.9 8.8 180°F Wet 18.0 7.5 8.5 Short Beam Shear (Ksi) 8.5 -65°F Dry 17 11 70°F Dry 13 10 11 12 12 180°F			17.0	7.0	10.3	10.1	
180°F Dry 18.4 7.5 8.9 8.8 180°F Wet 18.0 7.5 8.5 Short Beam Shear (Ksi) -65°F Dry 17 11 70°F Dry 13 10 11 12 180°F Dry 9. 8 180°F Wet 6 5 ASTM-D-2344 6 5 In-plane Shear Strength, V-notched (Ksi) 26 21 21 70°F Dry 20 19 18 180°F Dry 16 14 15 180°F Wet 11 11 10		•					
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V-notched (Ksi) 26 21 21 70°F Dry 20 19 18 180°F Dry 16 14 15 180°F Wet 11 11 10							
V-notched (Ksi) 26 21 21 70°F Dry 20 19 18 180°F Dry 16 14 15 180°F Wet 11 11 10	In-plane Shear Strength,						
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70°F Dry 20 19 18 180°F Dry 16 14 15 180°F Wet 11 11 10			26	21		21	
180°F Dry 16 14 15 180°F Wet 11 11 10		•					
180°F Wét 11 11 10		•					
ASTM-D-5379-93							
		3					

All test data provided are typical values and not intended to be specification values. For review of critical specification tolerances, please contact a Park representative directly. Park reserves the right to change these typical values as a natural process of refining our testing equipment and techniques.



Technical Datasheet

E-765 Epoxy Prepregs

Laminate Mechanical Properties - Glass

Reinforcement	Laminate Mechanical Properties - Glass				
Fiber Areal Weight (gsm)	D: (120	7781		
Cure Type Vacuum/Oven Vacuum/Oven Tensile Strength, 0° (Ksi) -65°F Dry -73 70°F Dry -53 65 180°F Dry 61 180°F Wet 50 ASTM-D-3039-95 50 Tensile Modulus (Msi) 50 -65°F Dry 3.9 70°F Dry 3.6 180°F Dry 3.6 180°F Wet 3.4 ASTM-D-3039-95 3.6 180°F Wet 3.4 ASTM-D-3039-95 3.6 180°F Wet 3.4 3.7 180°F Dry 85 73 180°F Wet 52 3.4 3.7 180°F Wet 52 3.8 180°F 19 4.1 19 4.1 10°F	Reinforcement		E-Glass		
Tensile Strength, 0° (Ksi) 65°F Dry 73 73 70°F Dry 53 65 65 180°F Dry 61 180°F Dry 50 ASTM-D-3039-95 50 ASTM-D-3039-95 50 ASTM-D-3039-95 3.9 70°F Dry 3.9 70°F Dry 3.6 180°F Dry 85 70°F 180°F Dry 85 70°F 180°F Pry 63 73 180°F Pry 63 73 180°F Pry 63 73 18 180°F Pry 4.1 70°F Dry 4.1 70°F Dry 4.1	Fiber Areal Weight (gsm)	107	300		
-65°F Dry 73 70°F Dry 53 65 180°F Dry 61 180°F Wet 50 ASTM-D-3039-95 Tensile Modulus (Msi) -65°F Dry 3.6 180°F Dry 3.6 180°F Dry 3.6 180°F Dry 3.6 180°F Wet 3.4 ASTM-D-3039-95 Compressive Strength (Ksi) -65°F Dry 85 70°F Dry 63 73 180°F Dry 61 180°F Wet 52 SACMA 1-94 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 2.6 3.8 180°F Dry 3.7 180°F Wet 3.7 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 3.7 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 10 70°F Dry 9 8 180°F Wet 5 ASTM-D-2344 In-plane Shear Strength, V-notched (Ksi) -65°F Dry 24 770°F Dry 18 180°F Wet 5 ASTM-D-2344 In-plane Shear Strength, V-notched (Ksi) -65°F Dry 24 770°F Dry 18 180°F Dry 18 180°F Dry 18 180°F Dry 18 180°F Dry 24 770°F Dry 18 180°F Dry 18	Cure Type	Vacuum/Oven	Vacuum/Oven		
70°F Dry 53 65 180°F Dry 61 180°F Wet 50 ASTM-D-3039-95 50 Tensile Modulus (Msi) 3.9 -65°F Dry 3.9 70°F Dry 3.6 180°F Wet 3.4 ASTM-D-3039-95 3.4 ASTM-D-3039-95 Compressive Strength (Ksi) 85 -65°F Dry 63 73 180°F Dry 61 1 180°F Dry 52 SACMA 1-94 52 3.8 1 180°F Dry 4.1 7 70°F Dry 4.1 7 70°F Dry 3.7 3.7 Short Beam Shear (Ksi) 5 -65°F Dry 7 10 70°F Dry <	Tensile Strength, 0° (Ksi)				
180°F Dry 61 180°F Wet 50 ASTM-D-3039-95 Tensile Modulus (Msi) -65°F Dry 3.9 70°F Dry 3.6 180°F Dry 3.4 ASTM-D-3039-95 3.4 Compressive Strength (Ksi) -65°F Dry 63 73 180°F Dry 61 180°F 52 Compressive Modulus (Msi) -65°F Dry 4.1 70°F 0.7 4.1 70°F 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 <	-65°F Dry		73		
180°F Wet 50	70°F Dry	53	65		
180°F Wet 50	180°F Dry		61		
Tensile Modulus (Msi) 65°F Dry 3.9 70°F Dry 2.4 3.7 180°F Dry 3.6 180°F Wet 3.4 ASTM-D-3039-95 Compressive Strength (Ksi) 85 -65°F Dry 85 70°F Dry 61 180°F Wet 52 SACMA 1-94 Short Board (Msi) 3.7 -65°F Dry 4.1 70°F Dry 3.7 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 7 180°F Wet 5 ASTM-D-2344 In-plane Shear Strength, 5 In-plane Shear Strength,			50		
-65°F Dry 2.4 3.7 180°F Dry 2.4 3.7 180°F Dry 3.6 180°F Wet 3.4 ASTM-D-3039-95 Compressive Strength (Ksi) -65°F Dry 85 180°F Dry 61 180°F Dry 61 180°F Wet 52 SACMA 1-94 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 2.6 3.8 180°F Dry 3.7 180°F Wet 3.7 180°F Wet 3.7 Short Beam Shear (Ksi) -65°F Dry 10 70°F Dry 9 8 180°F Dry 7 180°F Wet 5 ASTM-D-2344 In-plane Shear Strength, V- notched (Ksi) -65°F Dry 24 70°F Dry 18 180°F Dry 18 180°F Wet 5 ASTM-D-2344 In-plane Shear Strength, V- notched (Ksi) -65°F Dry 18 180°F Dry 18 180°F Dry 15 180°F Wet 15					
70°F Dry 2.4 3.7 180°F Dry 3.6 180°F Wet 3.4 ASTM-D-3039-95 3.4 Compressive Strength (Ksi) -65°F Dry 63 73 180°F Dry 61 180°F 180°F	Tensile Modulus (Msi)				
180°F Dry 3.6 180°F Wet 3.4 ASTM-D-3039-95 3.4 Compressive Strength (Ksi) -65°F Dry 61 180°F Dry 61 180°F Wet 52 SACMA 1-94 4.1 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 3.7 180°F Dry 3.7 Short Beam Shear (Ksi) -65°F Dry 10 70°F Dry 7 180°F Wet 5 ASTM-D-2344 5 In-plane Shear Strength, V- 18 180°F Dry 24 70°F Dry 15 180°F Wet	,				
180°F Wet 3.4 ASTM-D-3039-95 3.4 Compressive Strength (Ksi) 85 70°F Dry 61 180°F Dry 61 180°F Wet 52 SACMA 1-94 52 Compressive Modulus (Msi) 52 -65°F Dry 4.1 70°F Dry 3.8 180°F Dry 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3.7 3	70°F Dry	2.4	3.7		
ASTM-D-3039-95 Compressive Strength (Ksi) -65°F Dry 85 73 180°F Dry 61 180°F Wet 52 SACMA 1-94 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 2.6 3.8 180°F Dry 3.7 180°F Wet 3.7 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 9 8 180°F Dry 9 8 180°F Dry 9 8 180°F Dry 9 8 180°F Dry 180°F Wet 5 ASTM-D-2344 In-plane Shear Strength, V- notched (Ksi) -65°F Dry 24 70°F Dry 18 180°F Dry 15 180°F Dry 15 180°F Dry 15 180°F Wet 11 11 11 11 11 11 1	180°F Dry		3.6		
Compressive Strength (Ksi) 65°F Dry 85 70°F Dry 63 73 180°F Dry 61 180°F Wet 52 SACMA 1-94 52 Compressive Modulus (Msi) 4.1 -65°F Dry 4.1 70°F Dry 3.7 180°F Wet 3.7 Short Beam Shear (Ksi) 10 70°F Dry 7 180°F Dry 7 180°F Wet 5 ASTM-D-2344 5 In-plane Shear Strength, v-notched (Ksi) 24 70°F Dry 18 180°F Dry 15 180°F Wet 15	180°F Wet		3.4		
-65°F Dry 85 70°F Dry 63 73 180°F Dry 61 180°F Wet 52 SACMA 1-94 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 2.6 3.8 180°F Dry 3.7 180°F Wet 3.7 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 9 8 180°F Dry 9 8 180°F Dry 70°F Dry 9 8 180°F Dry 7 180°F Wet 5 ASTM-D-2344 In-plane Shear Strength, V- notched (Ksi) -65°F Dry 24 70°F Dry 18 180°F Dry 18 180°F Dry 15 180°F Wet 15					
70°F Dry 63 73 180°F Dry 61 180°F Wet 52 SACMA 1-94 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 3.7 180°F Dry 3.7 SACMA 1-94 Short Beam Shear (Ksi) 3.7 Short Beam Shear (Ksi) 10 70°F Dry 7 180°F Dry 7 180°F Dry 5 ASTM-D-2344 In-plane Shear Strength, V-notched (Ksi) 24 70°F Dry 24 70°F Dry 15 180°F Dry 15 180°F Wet 11					
180°F Dry 61 180°F Wet 52 SACMA 1-94 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 3.7 180°F Dry 3.7 SACMA 1-94 3.7 Short Beam Shear (Ksi) -65°F Dry 10 70°F Dry 7 180°F Dry 5 ASTM-D-2344 5 In-plane Shear Strength, v-notched (Ksi) 24 70°F Dry 24 70°F Dry 18 180°F Dry 15 180°F Wet 15	J				
180°F Wet 52 Compressive Modulus (Msi) -65°F Dry 4.1 70°F Dry 2.6 3.8 180°F Dry 3.7 180°F Wet 3.7 SACMA 1-94 Short Beam Shear (Ksi) -65°F Dry 10 70°F Dry 9 8 180°F Dry 7 180°F Wet 5 ASTM-D-2344 24 70°F Dry 24 70°F Dry 18 180°F Dry 15 180°F Wet 15 180°F Wet 11	,	63			
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All test data provided are typical values and not intended to be specification values. For review of critical specification tolerances, please contact a Park representative directly. Park reserves the right to change these typical values as a natural process of refining our testing equipment and techniques.



Processing Guidelines

E-765 Epoxy Prepregs

Prepreg Storage Life

Out Life: 30 days @ 75°F Shelf Life: 6 months @ 0°F Tack Life: 21 days @ 75°F Note: The following guidelines are provided to assist Park material users with general recommendations for successful processing. The recommendations are for general review purposes only and process adjustments may be required to achieve optimum results in your specific manufacturing environment.

Autoclave Cure Cycle

- Apply 24"Hg vacuum (minimum) for a minimum of 1 hour before cure
- Apply 40 -100 psi autoclave pressure, vent vacuum when pressure reaches 15 20 psi
- Ramp product temp to $270-280^{\circ}F$ at $1-5^{\circ}F$ ($0.05-3^{\circ}C$)/min
 - For Laminates > 0.125" thick, hold at 180°F for 60 minutes
- Hold product at 270-280°F for 110-130 minutes
- Cool to 150°F at 3 10°F/min prior to releasing autoclave pressure

Vacuum/Oven Cure Cycle

- Apply 25"Hg vacuum (minimum) for a minimum of 1 hour before cure
- Ramp product temp to $270-280^{\circ}F$ at $1-5^{\circ}F$ ($0.05-3^{\circ}C$)/min
 - For laminates > 0.125" thick, hold at 180°F for 60 minutes
- Hold product at 270-280°F for 110-130 minutes
- Cool to 150°F at 3 10°F/min

Thick Laminate Cure Cycle

- Slower ramp rate and multiple dwell times below 190°F are critical to remove excess energy from the system and avoid dangerous exotherms.
- Contact your Park representative to discuss specific part process requirements to optimize processing of E-765.
- Failure to properly control the exotherm can lead to a potential safety hazard and/or degradation of final material performance.

All test data provided are typical values and not intended to be specification values. For review of critical specification tolerances, please contact a company representative directly.

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