

P-670F Polyester Prepregs

Park's P-670F is a versatile, non-styrenated/low VOC polyester resin. P670F is used in a wide variety of applications including tooling and aircraft structures.

Key Features & Benefits

- Non-styrenated / low VOC resin system
- Meets requirements of MIL-R-7575C, grade B
- Self-extinguishing formulation

Product Forms

- Available on a wide variety of reinforcements
- Solution coated fabrics up to 60 inches wide
- Compatible with Autoclave, Vacuum Bag/Oven or Press Molding processes

Applications / Qualifications

- Tooling
- Aircraft Structures

For Information about Park's materials:

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Prepreg Physical Properties

Reinforcement	7781 E-glass
Fabric Area Weight (gsm)	300
Prepreg Resin Content (%)	35 – 41
Volatiles (220°F, 8 min) (%)	2.0 max
Flow (275°F, 15 psi) (%)	3 - 15
Gel Time (sec)	30 – 90

Processing Guidelines

Prepreg Storage Life

- Out Life: 30 days @ 75°F
- Shelf Life: 3 months @ 40°F
6 months @ 0°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 1 hour before beginning heat cycle
- Apply 40 - 50 psi autoclave pressure, vent vacuum at 15 – 20 psi
- Heat at 2 – 5 °F/min from room temperature to 250 - 325°F
- Cure product at 250 – 325°F for 90 minutes
- Cool to 150°F at no more than 8°F/min prior to releasing autoclave pressure

Laminate Physical Properties

Reinforcement	7781 E-glass
Hardness (Barcol)	75
Flammability	Self-Extinguishing

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.



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Laminate Physical Properties

Reinforcement	7781 E-glass
Tensile Strength, 0° (Ksi) 75°F Dry ASTM-D-638 Type 1	68
Tensile Modulus, 0° (Msi) 75°F Dry ASTM-D-638 Type 1	3.8
Compressive Strength (Ksi) 75°F Dry ASTM-D-695	55
Flexural Strength (Ksi) 75°F Dry ASTM-D-790	95
Flexural Modulus (Msi) 75°F Dry ASTM-D-790	3.7
Short Beam Shear (Ksi) 75°F Dry ASTM-D-695	8.0

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