

TECHNICAL DATA SHEET

Resin System	EF13
Applications	Ballistic Applications; hard body armour
Key Features	High toughness, high energy transfer
Cure Temperature	130°C - 175°C
Work Life	4 Months @ RT
Storage Life	6 Months @ +4°C or lower
Fiber	Aramid
Weaving Style	Plain
Dry Fabric Areal Weight (gsm)	400
%Resin Content (by weight)	11
Prepreg Areal Weight (gsm)	455
Service Temperature (°C)	-50°C to 95°C

Storage Requirements of EF13 PVB Aramid Prepreg

EF 13 Prepreg must be stored protected from light, dust, water or other contaminants before processing.

Shelf life of the prepreg system is more than 6 months from date of shipment when storage condition is kept constant at 4°C or below temperatures.

Working life is 4 months at ambient temperatures (25°C).

Recommended Curing Cycle

The prepreg is compatible for vacuum-bag, platen press, and autoclave processes.

For hard ballistic purposes, each customers should run some trials to establish their own proprietary processing conditions.

Below steps can be followed for press curing:

- Heat the mold to 160-170°C
- Load stacked material in mold
- Apply 10 bar pressure
- When the temperature of the stacked material is higher than 155 °C, degas for at least 3 times to remove excess volatiles
- Apply pressure 20 bar
- Hold for at least 20 min at 165 °C or higher (170 °C)
- open press (still at 165 °C)
- Remove consolidated panel

Temperature 1-3 °C heat up and cool down under pressure is recommended, but not mandatory.

Thawing and Repacking	
Thawing	
<ol style="list-style-type: none"> 1. Store unopened rolls at room temperature for a minimum of 12 hours prior to opening plastic bag 2. Cut open plastic bag 3. Remove shipping flanges 4. Unroll tape and use 	
Refreezing	
<ol style="list-style-type: none"> 1. Reattach original shipping flanges to tape roll 2. Place unused desiccant inside tape roll (inside core) 3. Place roll with attached flanges inside plastic bag 4. Remove air from bag (manually/vacuum seal unit) 5. Seal bag to keep air from infiltrating back into the bag 	
Reshipping	
<ol style="list-style-type: none"> 1. Follow "Refreezing" steps 2. Refreeze bagged tape 3. Place bagged tape into shipping container 4. Pack with approx. 5kg of dry ice 	

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