

# PRODUCT DATA SHEET



TENCATE ADVANCED COMPOSITES

## MS-1H

### PRODUCT TYPE

280°F (138°C) Fast Cure Intermediate Modulus Compression Molding System

### SHELF LIFE

#### Out Life

14 days out life at 77°F (25°C)

#### Frozen Storage Life

6 months storage life at <0°F (-18°C)

Out life is the maximum time allowed at room temperature before cure.

### PRODUCT DESCRIPTION

MS-1H is a carbon fiber/epoxy resin compression molding system using a high modulus PAN carbon fiber. This is an excellent high stiffness molding compound that has been qualified to military and commercial applications. It has excellent out time stability and processes very well in small and thin cross section parts. It is the performance alternative to MS-4H-1" molding compound. MS-1H is offered with 1" carbon fibers, or for smaller parts, a 1/2" fiber version is available.

### MS-1H PHYSICAL PROPERTIES

Fiber Length ..... 1/2" and 1"

Density ..... 1.48-1.52 g/cc

Thermal Expansion X ,Y ..... 4-7 ppm/°F (7.2- 12.6 ppm/°C)

Tg (by DSC)..... 375°F (191°C) Post Cured at 350°F (177°C)

### MS-1H MECHANICAL PROPERTIES. (1/2" FIBER LENGTH)

Properties	Condition (RTD, ETD, ETW)	Method	Results	
Tensile Strength 0°	RTD	ASTM D 3039	37.1 ksi	255.8 MPa
Tensile Modulus 0°	RTD	ASTM D3039	10 Msi	68.9 GPa
Compressive Strength 0°	RTD	ASTM D6484	32.8 ksi	226.1 MPa
Compressive Modulus 0°	RTD	ASTM D6484	9.2 Msi	63.4 GPa
Flexural Strength 0°	RTD	ASTM D6272	63.7 ksi	439.2 MPa
Flexural Modulus 0°	RTD	ASTM D6272	10 Msi	68.9 GPa
Open Hole Comp. Strength	RTD	ASTM D6484	30.4 ksi	209.6 MPa
Compression After Impact	RTD	ASTM D7137**	19.9 ksi	137.2 MPa
Notched Shear Strength	RTD	ASTM D7079	24.2 ksi	166.9 MPa
Notched Shear Modulus	RTD	ASTM D7079	2.6 Msi	17.9 GPa
Bolt Bearing Str. (Single Shear)	RTD	ASTM D5961	96.3 ksi	664.0 MPa

- All items are net molded coupons unless noted

\*\* Machine Molded

- All properties based on a fiber volume of 48-50%

- All properties based on the average of a 3 batch qualification. Full details are available upon request.

- Actual molding technique and conditions, fiber length, and part geometry will affect properties obtained.

- Above values derived after post cure of 350°F/177°C for 1-2 hours.

### PROCESS PARAMETERS

\* Pre-weigh the desired amount of molding compound.

\* Pre-heat molding compound in 160°F ± 10°F (71°C ± 8°C) oven for 10 minutes. Form mold charge to approximately fit cavity. Charge cavity with molding compound.

\* Cure temperature: 280°F-310°F (138°C-154°C). Pinch pressure: 250 psi for 15-30 seconds. Close mold to 2,000 psi, hold for 15-30 minutes depending on part thickness.

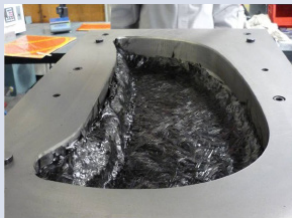
\* Post cure at 350°F/177°C for 1-2 hours for full properties.

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All data given is based on representative samples of the materials in question. Since the method and circumstances under which these materials are processed and tested are key to their performance, and TenCate Advanced Composites has no assurance of how its customers will use the material, the corporation cannot guarantee these properties.

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### BMC MOLDING GUIDELINES:

1. Pre-weigh the desired amount of molding compound
2. Pre-heat the molding compound at  $160^{\circ}\text{F} \pm 10^{\circ}\text{F}$  ( $71^{\circ}\text{C} \pm 5.5^{\circ}\text{C}$ ) for 10 minutes
3. Form a mold charge to approximately fit the mold cavity
4. Place the charge in the mold cavity
5. Cure:  $280\text{-}310^{\circ}\text{F}$ . Pinch pressure 250 psi for 15-30 seconds.  
Close mold to 2000 psi for 15-30 minutes depending on part thickness.
6. Post cure at  $350^{\circ}\text{F}$  /  $177^{\circ}\text{C}$  for 1-2 hours.

### TROUBLE SHOOTING:

#### BLISTERING OR BUBBLES:

- Check mold surface temperature
- Increase molding pressure
- Check for moisture in the material

#### CRACKS OR STRESS MARKS:

- Check mold surface temperature
- Check cure time
- Clean mold surface and re-apply mold release
- Check ejection pressure, slow down ejection

#### FLOW MARKS:

- Close press sooner after charge has been placed in the cavity
- Increase press closure speed
- Check mold surface temperature

#### RESIN STARVATION:

- Check material out-time and staging temperature, Keep charge material covered and in plastic bags
- Adjust charge weight
- Clean mold surface and re-apply mold release

#### VOIDS:

- Check charge set-up, shape and weight
- Check mold surface temperature
- Check pre-heat time and temperature
- Check press closure time
- Clean mold surface and re-apply mold release

#### THICK PART – UNEVEN DISTRIBUTION OF MATERIAL

- Pre-consolidate thick sections
- Spread molding compound in measured increments
- Evaluate if press capacity is large enough for even pressure across part

### GENERAL NOTES:

Note that 1", ½", and ¼" material will be slightly different with the longer chop length showing as bulkier than the shorter chop lengths. Generally the material does not brick up (unless exposed to heat or warmth) and is typically free flowing as received once broken free of the packaging. Some centering or clumping is not uncommon, however when cool, the material should crumble out of the packaging. The bulk volume of the uncured uncompressed material is ~5X that of the compressed/ cured part.

When pre-heated, a pre-formed charge will shrink maybe 10% if no pressure of any kind is applied other than gravity. It may debulk down 20-30% if pressure is applied, even hand pressure.

- The calculated cured density of the material is ~1.483 g/cc or ~92.6 lb/ft<sup>3</sup>.
- A 3 lb bag of 1" material will measure out to a football shape when in a bag of ~12"x10"x5".
- This loosely calculates to a 10 to 1 ratio, however the bagged material is not rectangular in shape.

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