

## PRODUCT DATA SHEET

### DESCRIPTION

Toray AmberTool® HX50 is a low temperature curing epoxy composite tooling prepreg. After a suitable post cure, an end use temperature of 180°C (356°F) is achieved. Toray AmberTool® HX50 achieves an excellent surface finish for small to medium sized autoclave tooling.

### FEATURES

- ▶ Low initial cure temperature
- ▶ High glass transition temperature
- ▶ Excellent drape for complex shapes
- ▶ 60 hours out life at 18°C (64°F)
- ▶ Capable of freestanding post cure
- ▶ Low prepreg volatile content
- ▶ Low coefficient of thermal expansion (CTE)
- ▶ Surface machinable following post cure

### PRODUCT TYPE

40–55°C (104–131°F) Low Temperature Curing Epoxy Tooling Prepreg

### TYPICAL APPLICATIONS

- ▶ Small-to-medium-sized autoclave tooling with fast cure and excellent surface finish

### SHELF LIFE

<b>Out Life:</b>	60 hours at 18°C (64°F)
<b>Storage Life:</b>	6 months at -18°C (0°F)

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

#### To avoid moisture condensation:

Following removal from cold storage, allow the prepreg to reach room temperature before opening the polythene bag. Typically, the thaw time for a full roll of material will be 4 to 6 hours.

### TYPICAL NEAT RESIN PROPERTIES

Density	1.23 g/cm <sup>3</sup> (77lbs/ft <sup>3</sup> ) at 23°C (73°F)
T <sub>g</sub> (DMTA) after 190°C (374°F) post cure	Onset: 190°C (374°F); Peak tan δ: 220°C (428°F)
Typical CTE for a carbon tool	3.1 (1.7) x10 <sup>-6</sup> /°C (°F)*
Typical CTE for a glass tool	12.7 (7) x10 <sup>-6</sup> /°C (°F)*

\*CTE is dependent on construction and processing. Figures quoted are based on standard 1-8-1 quasi-isotropic tooling laminates.



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**AmberTool®**

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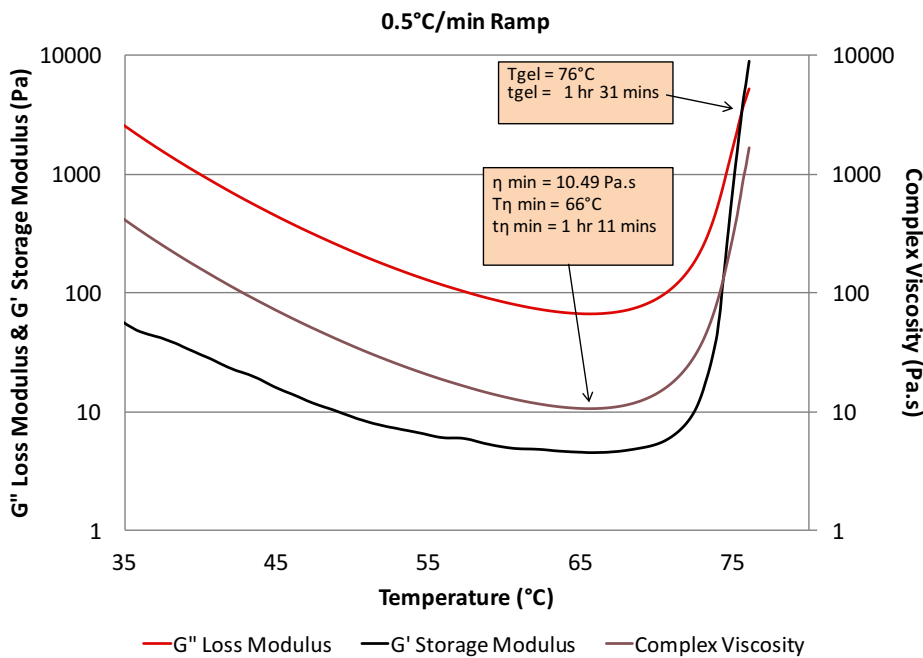
## PRODUCT DATA SHEET

### REINFORCEMENTS AVAILABLE

Fiber Type	Weight (gsm)	Weave Style	Standard Resin Content w/o
Standard modulus 3K carbon	205	2 x 2 twill	46 (surface ply)
Standard modulus 12K carbon	650	2 x 2 twill	35

Other fabrics and resin weights available on request

### RHEOLOGY

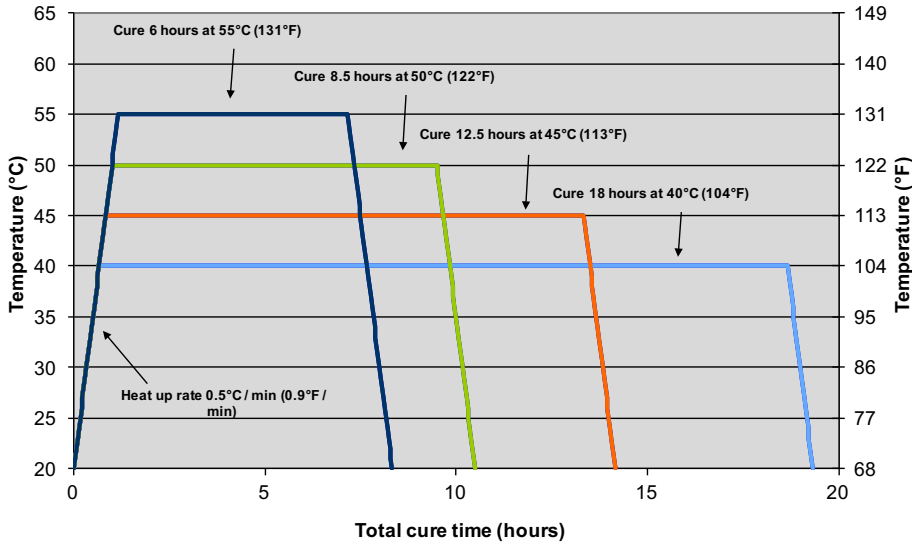


### INITIAL MINIMUM CURE TIMES

Temperature	Time (hrs)
40°C (104°F)	18
45°C (113°F)	12.5
50°C (122°F)	8.5
55°C (131°F)	6

## PRODUCT DATA SHEET

### INITIAL MINIMUM CURE SCHEDULE

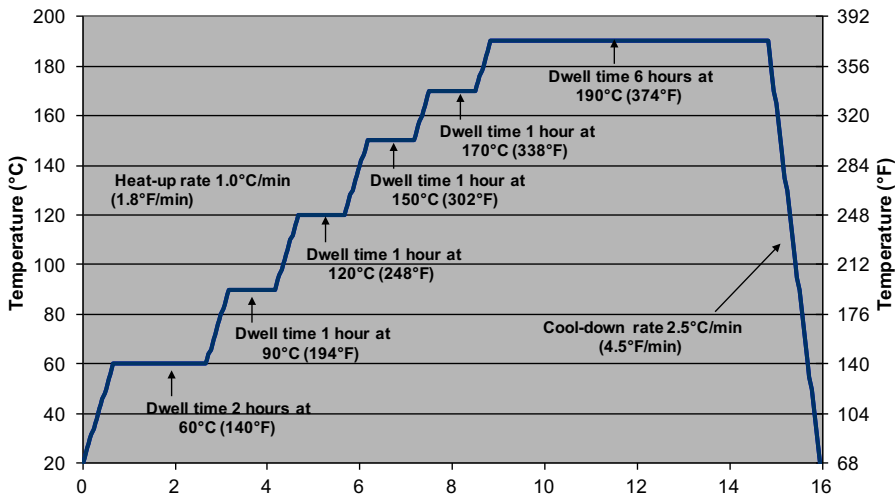


Alternative cure cycles at higher temperature may be used e.g., 4 hours at 60°C (140°F)  
 Caution: Toray AmberTool® HX50 prepreg contains a reactive resin system and care must be taken to avoid exothermic heating during the initial cure. Avoid exceeding 65°C (149°F) during the initial cure.

### POST CURE TIME

Post Cure Schedule A		
Ramp	1°C (1.8°F)/min to 60°C (140°F)	Dwell for 2 hours
Ramp	1°C (1.8°F)/min to 90°C (194°F)	Dwell for 1 hour
Ramp	1°C (1.8°F)/min to 120°C (248°F)	Dwell for 1 hour
Ramp	1°C (1.8°F)/min to 150°C (302°F)	Dwell for 1 hour
Ramp	1°C (1.8°F)/min to 170°C (338°F)	Dwell for 1 hour
Ramp	1°C (1.8°F)/min to 190°C (374°F)	Dwell for 6 hours
Cool to 50°C (122°F) at 2.5°C/min (4.5°F/min)		

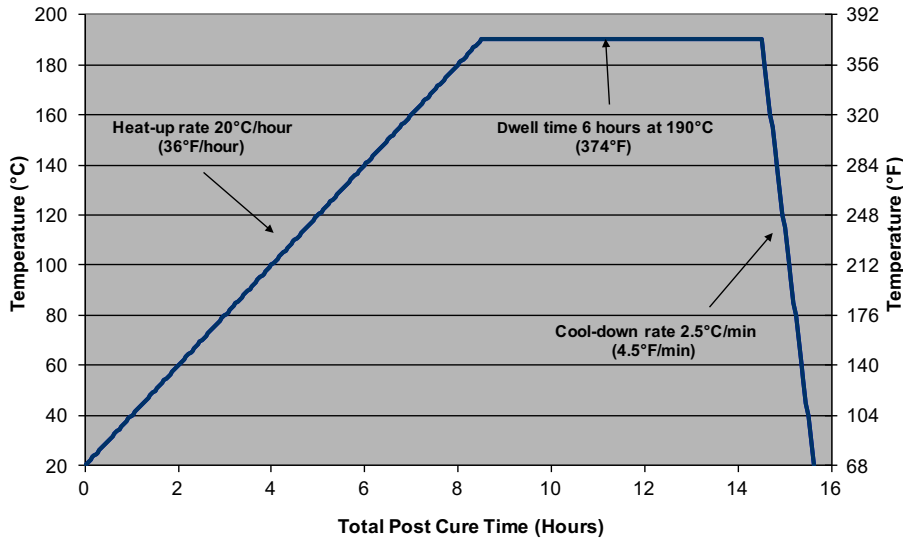
### POST CURE SCHEDULE A



## PRODUCT DATA SHEET

### POST CURE SCHEDULE B

An alternative post cure schedule may also be used as follows.



### HANDLING SAFETY

Observe established precautions for handling epoxy resins and fibrous materials. Ensure adequate ventilation and wear gloves and protective clothing. For further information, refer to our Safety Data Sheet available from Toray Advanced Composites.

### PROCESSING

Processing parameters and instructions are provided in the Toray AmberTool® material processing information guide from Toray Advanced Composites at [www.toraytac.com/tooling](http://www.toraytac.com/tooling).

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