Selector Guide



HexPly® Prepreg Matrix

HOW TO USE THE CHART

The chart has been arranged to allow easy selection of the best matrix for a prepreg application.

Decide on the maximum dry Tg required for the application. This narrows the choice of matrices from which a more detailed inspection of the desired properties should be made. Specific matrix information is provided on individual data sheets, available from Hexcel on request.

HexPlv [®] Besin	Dry Tg Onset (DMA) °C (°F)	Typical Cu	re Cycle	Cure F	Cure Process		Self			Toughnes	s	Self	Outlife at Boom	Storage at	St	tandard I	Prepreg Fo	rms		HexPlv [®] Resin
Systems		Temp °C (°F)	Time (mins)	Autoclave/ Press	Vacuum Only	Adhesive	Controlled	High	High	Med	Low	Extinguishing	Temperature (days)	-18°C (0°F) (months)	UD Tape	Fabrio	c Tow Preg	Split Tape	Typical Applications	Systems
Ероху																				Ероху
ES15	85 (185)	120 (250)	9	Х			Х				Х		5	6	Х	Х			Ski/Snowboards/Sports Goods - Transparent Resin System	ES15
M44	90 (195)	140 (285)	13	Х	Х		Х		Х				21	12	Х				Tennis Rackets/Golf Shafts/Fishing Rods/Sports Goods	M44
M34	90 (195)	75 (165)	480	Х	Х	Х	Х				Х	Х	10	12		Х			Railway Fairings/Structures/Marine/General Industrial	M34
EF01	95 (200)	120 (250)	15	Х	Х	Х	Х		Х				14	14	Х	Х			Bicycle Wheels/Sports Goods/General Industrial/Snowboards	EF01
M32	100 (210)	120 (250)	9	Х		Х	Х			Х			7	6	Х	Х			Ski/Snowboard/Industrial	M32
M26T	115 (235)	125 (255)	90	Х	Х	Х	Х		Х			Х	30	12	Х	X			Floor Panels/Fairings/Sandwich Structures	M26T
M9.1F/M9.6F	125 (255)	120 (250)	30	Х	Х			X		Х			42	12	Х	Х			Large Industrial Components/Wind Turbine Blades	M9.1F/M9.6F
M10	125 (255)	120 (250)	60	Х	Х			X		Х			60	12	Х	Х			General Industrial/Wind Turbine Blades/Leaf Springs/Boat Hulls	M10
EH04	125 (255)	130 (265)	8	Х	Х			X		Х			14	12	Х	X			Bike Components/Golf Shafts/Fishing Rods/Kayak Paddles/Hockey Sticks & Blades	EH04
M35-4	135 (275)	135 (275)	90	Х	Х		Х		Х				60	12	Х	X			UAV's, Motorsport Components - Flexible Curing Matrix, Tg of 200°C after post-cure	M35-4
M76	135 (275)	135 (275)	180	Х		Х	Х		Х				21	12	Х	Х			Motorsport/Space Applications - Flexible Curing Matrix	M76
M47 (1947)	145 (295)	135 (275)	90	Х			Х			Х		Х	30	12	Х	X			Automotive Parts, eg Bonnets & Body Panels - Excellent Surface Finish	M47 (1947)
913	150 (300)	125 (255)	60	Х			Х				Х		30	12	Х	X			Aerospace Structural Components/Fin Box/Belly Fairings/Helicopter Blades	913
M20	150 (300)	130 (265)	120	Х	Х		Х				Х		30	12	Х	X			Aerospace Composite Repair/Motorsport Components	M20
8551-7	155 (315)	180 (350)	120	Х	Х		Х		Х				30	12	Х	Х	Х	Х	Structural Applications Requiring Extreme Damage Resistance	8551-7
M73	185 (365)	180 (350)	360	Х			Х		Х				10	12	Х	Х			Aerospace Primary & Secondary Structures/Space Applications	M73
M74	190 (375)	180 (350)	120	Х				X		Х			10	12	Х	Х	Х		Aerospace Structural Components/Critical Space Structures	M74
M21	195 (385)	180 (350)	120	Х			Х		Х				30	12	Х	Х			Aerospace Primary Structures	M21
8552	195 (385)	180 (350)	120	Х	Х		Х			Х			21	12	Х	Х	Х	Х	Aerospace Structural Parts/Empennage/Fighter Wings	8552
M18	200 (390)	180 (350)	120	Х			Х			Х			30	12	Х	X	Х		Space Applications/Antennae/Solar Panels	M18
M18/1	200 (390)	180 (350)	120	Х			Х			X		Х	30	12		Х			Helicopter Structural Parts	M18/1
M36	200 (390)	180 (350)	120	Х	Х		Х			Х			14	10	He	eavy Weig	ght Films fo	r RFI	Aerospace Structural Components - Resin Film Infusion	M36
922-1	210 (410)	180 (350)	120	Х				X			Х		10	12	Х	Х			Engine/Nacelle Structures - High Service Temperature	922-1
Phenolic																				Phenolic
HT93	[80 (175) in service]	125 (255)	120	Х		Х	X				Х	Х	30	14		X	_		Aircraft Interior Panels/Partitions (Low FST)	НТ93
M41	[80 (175) in service]	135 (275)	30	Х		Х	X				X	Х	30	12		X			Aircraft Interior Panels/Partitions/Crush Core Process (Low FST)	M41
200	[200 (390) in service]	150 (300)	60	Х		Х	X				Х	Х	30	12		X			Fire Proof Panels & Components	200
BMI										-										BMI
F655	290 (550)	190 (375)	240+PC	Х			Х			Х			30	12	Х	X			High Temperature Primary/Secondary Structures/Engine Components Toughened	F655
F650	315 (600)	190 (375)	240+PC	Autoclave				X			X	Х	30	12	Х	X	X	Х	High Temperature Primary/Secondary Structures/Engine Components	F650
Cyanates																				Cyanates
954-6	145 (295)	120 (250)	180	Х			Х		Х				14	6	Х	Х			Satellite Antennae/Solar Array/Support Structures/Radomes	954-6
996	165 (330)	180 (350)	120	Х				Х		Х			14	6	Х	X			Satellite Antennae/Solar Array/Support Structures	996
954-3A	195 (385)	180 (350)	120	Х	X		Х			Х			14	12	Х	Х			Satellite Antennae/Solar Array/Support Structures/Radomes	954-3A

HexPlv [®] Resin	Drv Tg	Typical Cu	re Cycle	Cure I	Process	Self	Flow	Flow		1	Toughness		Self	Outlife at Boom	Storage at	St	andard Pro	repreg	Forms		HexPlv [®] Resin
Systems	Onset (DMA) °C (°F)	Temp °C (°F)	Time (mins)	Autoclave/ Press	Vacuum Only	Adhesive	Controlled	High		High	Med	Low	Extinguishing	Temperature (days)	-18°C (0°F) (months)	UD Tape	Fabric	Tov Pre	w Split eg Tape	iypical Applications	Systems
Ероху																					Ероху
ES15	85 (185)	120 (250)	9	Х			Х					Х		5	6	Х	Х			Ski/Snowboards/Sports Goods - Transparent Resin System	ES15
M44	90 (195)	140 (285)	13	Х	Х		Х			Х				21	12	Х				Tennis Rackets/Golf Shafts/Fishing Rods/Sports Goods	M44
M34	90 (195)	75 (165)	480	Х	Х	Х	Х					Х	Х	10	12		Х			Railway Fairings/Structures/Marine/General Industrial	M34
EF01	95 (200)	120 (250)	15	Х	Х	Х	Х			Х				14	14	Х	Х			Bicycle Wheels/Sports Goods/General Industrial/Snowboards	EF01
M32	100 (210)	120 (250)	9	Х		Х	Х				Х			7	6	Х	Х			Ski/Snowboard/Industrial	M32
M26T	115 (235)	125 (255)	90	Х	Х	Х	Х			Х			Х	30	12	Х	Х			Floor Panels/Fairings/Sandwich Structures	M26T
M9.1F/M9.6F	125 (255)	120 (250)	30	Х	Х			X			Х			42	12	Х	Х			Large Industrial Components/Wind Turbine Blades	M9.1F/M9.6F
M10	125 (255)	120 (250)	60	Х	Х			X			Х			60	12	Х	Х			General Industrial/Wind Turbine Blades/Leaf Springs/Boat Hulls	M10
EH04	125 (255)	130 (265)	8	Х	Х			X			Х			14	12	Х	Х			Bike Components/Golf Shafts/Fishing Rods/Kayak Paddles/Hockey Sticks & Blades	EH04
M35-4	135 (275)	135 (275)	90	Х	Х		Х			Х				60	12	Х	Х			UAV's, Motorsport Components - Flexible Curing Matrix, Tg of 200°C after post-cure	M35-4
M76	135 (275)	135 (275)	180	Х		Х	Х			Х				21	12	Х	Х			Motorsport/Space Applications - Flexible Curing Matrix	M76
M47 (1947)	145 (295)	135 (275)	90	Х			Х				Х		Х	30	12	Х	Х			Automotive Parts, eg Bonnets & Body Panels - Excellent Surface Finish	M47 (1947)
913	150 (300)	125 (255)	60	Х			Х					Х		30	12	Х	Х			Aerospace Structural Components/Fin Box/Belly Fairings/Helicopter Blades	913
M20	150 (300)	130 (265)	120	Х	Х		Х					Х		30	12	Х	Х			Aerospace Composite Repair/Motorsport Components	M20
8551-7	155 (315)	180 (350)	120	Х	Х		Х			Х				30	12	Х	Х	X	X	Structural Applications Requiring Extreme Damage Resistance	8551-7
M73	185 (365)	180 (350)	360	Х			Х			Х				10	12	Х	Х			Aerospace Primary & Secondary Structures/Space Applications	M73
M74	190 (375)	180 (350)	120	Х				X			Х			10	12	Х	Х	X		Aerospace Structural Components/Critical Space Structures	M74
M21	195 (385)	180 (350)	120	Х			Х			Х				30	12	Х	Х			Aerospace Primary Structures	M21
8552	195 (385)	180 (350)	120	Х	Х		Х				Х			21	12	Х	Х	X	X	Aerospace Structural Parts/Empennage/Fighter Wings	8552
M18	200 (390)	180 (350)	120	Х			Х				Х			30	12	Х	Х	X		Space Applications/Antennae/Solar Panels	M18
M18/1	200 (390)	180 (350)	120	Х			Х				Х		Х	30	12		Х			Helicopter Structural Parts	M18/1
M36	200 (390)	180 (350)	120	Х	Х		Х				Х			14	10	He	eavy Weigh	ht Films	for RFI	Aerospace Structural Components - Resin Film Infusion	M36
922-1	210 (410)	180 (350)	120	Х				X				Х		10	12	Х	Х			Engine/Nacelle Structures - High Service Temperature	922-1
Phenolic		1					1								1						Phenolic
HT93	[80 (175) in service]	125 (255)	120	Х		Х	Х					Х	Х	30	14	_	Х			Aircraft Interior Panels/Partitions (Low FST)	HT93
M41	[80 (175) in service]	135 (275)	30	Х		Х	Х					Х	Х	30	12		Х			Aircraft Interior Panels/Partitions/Crush Core Process (Low FST)	M41
200	[200 (390) in service]	150 (300)	60	Х		Х	Х					Х	Х	30	12		Х			Fire Proof Panels & Components	200
BMI																					BMI
F655	290 (550)	190 (375)	240+PC	Х			Х				Х			30	12	Х	Х			High Temperature Primary/Secondary Structures/Engine Components Toughened	F655
F650	315 (600)	190 (375)	240+PC	Autoclave				X				X	Х	30	12	Х	X	X	X	High Temperature Primary/Secondary Structures/Engine Components	F650
Cyanates																					Cyanates
954-6	145 (295)	120 (250)	180	Х			Х			Х				14	6	Х	Х			Satellite Antennae/Solar Array/Support Structures/Radomes	954-6
996	165 (330)	180 (350)	120	Х				X			Х			14	6	Х	Х			Satellite Antennae/Solar Array/Support Structures	996
954-3A	195 (385)	180 (350)	120	Х	Х		Х				Х			14	12	X	Х			Satellite Antennae/Solar Array/Support Structures/Radomes	954-3A

		1				1								0.486							
HexPly [®] Resin	Dry Tg	Typical Cu	re Cycle	Cure Process		Self		/	_	1	Toughness		Self	Room	Storage at	St	andard Pr	repreg	Forms	Typical Applications	HexPly [®] Resin
Systems	Onset (DMA) °C (°F)	Temp °C (°F)	TimeAutoclave/Vacuum(mins)PressOnly	Adhesive	Controlled	High		High	Med	Low	Extinguishing	Temperature (days)	(months)	UD Tape	Fabric	To Pre	w Split eg Tape	Typical Applications	Systems		
Ероху																					Ероху
ES15	85 (185)	120 (250)	9	Х			Х					Х		5	6	Х	Х			Ski/Snowboards/Sports Goods - Transparent Resin System	ES15
M44	90 (195)	140 (285)	13	Х	Х		Х			Х				21	12	Х				Tennis Rackets/Golf Shafts/Fishing Rods/Sports Goods	M44
M34	90 (195)	75 (165)	480	Х	Х	X	Х					Х	Х	10	12		Х			Railway Fairings/Structures/Marine/General Industrial	M34
EF01	95 (200)	120 (250)	15	Х	Х	Х	Х			Х				14	14	Х	Х			Bicycle Wheels/Sports Goods/General Industrial/Snowboards	EF01
M32	100 (210)	120 (250)	9	Х		Х	Х				Х			7	6	Х	Х			Ski/Snowboard/Industrial	M32
M26T	115 (235)	125 (255)	90	Х	Х	X	Х			Х			Х	30	12	Х	Х			Floor Panels/Fairings/Sandwich Structures	M26T
M9.1F/M9.6F	125 (255)	120 (250)	30	Х	Х			Х			Х			42	12	Х	Х			Large Industrial Components/Wind Turbine Blades	M9.1F/M9.6F
M10	125 (255)	120 (250)	60	Х	Х			X			Х			60	12	Х	Х			General Industrial/Wind Turbine Blades/Leaf Springs/Boat Hulls	M10
EH04	125 (255)	130 (265)	8	Х	Х			Х			Х			14	12	Х	Х			Bike Components/Golf Shafts/Fishing Rods/Kayak Paddles/Hockey Sticks & Blades	EH04
M35-4	135 (275)	135 (275)	90	Х	Х		Х			Х				60	12	Х	Х			UAV's, Motorsport Components - Flexible Curing Matrix, Tg of 200°C after post-cure	M35-4
M76	135 (275)	135 (275)	180	Х		Х	Х			Х				21	12	Х	Х			Motorsport/Space Applications - Flexible Curing Matrix	M76
M47 (1947)	145 (295)	135 (275)	90	Х			Х				Х		Х	30	12	Х	Х			Automotive Parts, eg Bonnets & Body Panels - Excellent Surface Finish	M47 (1947)
913	150 (300)	125 (255)	60	Х			Х					Х		30	12	Х	Х			Aerospace Structural Components/Fin Box/Belly Fairings/Helicopter Blades	913
M20	150 (300)	130 (265)	120	Х	Х		Х					Х		30	12	Х	Х			Aerospace Composite Repair/Motorsport Components	M20
8551-7	155 (315)	180 (350)	120	Х	Х		Х			Х				30	12	Х	Х	X	Х	Structural Applications Requiring Extreme Damage Resistance	8551-7
M73	185 (365)	180 (350)	360	Х			Х			Х				10	12	Х	Х			Aerospace Primary & Secondary Structures/Space Applications	M73
M74	190 (375)	180 (350)	120	Х				X			Х			10	12	Х	Х	X		Aerospace Structural Components/Critical Space Structures	M74
M21	195 (385)	180 (350)	120	Х			Х			Х				30	12	Х	Х			Aerospace Primary Structures	M21
8552	195 (385)	180 (350)	120	Х	Х		Х				Х			21	12	Х	Х	X	Х	Aerospace Structural Parts/Empennage/Fighter Wings	8552
M18	200 (390)	180 (350)	120	Х			Х				Х			30	12	Х	Х	X		Space Applications/Antennae/Solar Panels	M18
M18/1	200 (390)	180 (350)	120	Х			Х				Х		Х	30	12		Х			Helicopter Structural Parts	M18/1
M36	200 (390)	180 (350)	120	Х	Х		Х				Х			14	10	He	eavy Weigh	ht Films	for RFI	Aerospace Structural Components - Resin Film Infusion	M36
922-1	210 (410)	180 (350)	120	Х				X				Х		10	12	Х	Х			Engine/Nacelle Structures - High Service Temperature	922-1
Phenolic				1																	Phenolic
HT93	[80 (175) in service]	125 (255)	120	Х		Х	Х					Х	Х	30	14	_	Х			Aircraft Interior Panels/Partitions (Low FST)	HT93
M41	[80 (175) in service]	135 (275)	30	Х		Х	Х					Х	Х	30	12		Х			Aircraft Interior Panels/Partitions/Crush Core Process (Low FST)	M41
200	[200 (390) in service]	150 (300)	60	Х		Х	Х					Х	Х	30	12		Х			Fire Proof Panels & Components	200
BMI																					BMI
F655	290 (550)	190 (375)	240+PC	Х			Х				Х			30	12	Х	Х			High Temperature Primary/Secondary Structures/Engine Components Toughened	F655
F650	315 (600)	190 (375)	240+PC	Autoclave				X				Х	Х	30	12	X	Х	X	Х	High Temperature Primary/Secondary Structures/Engine Components	F650
Cyanates																					Cyanates
954-6	145 (295)	120 (250)	180	Х			Х			Х				14	6	Х	Х			Satellite Antennae/Solar Array/Support Structures/Radomes	954-6
996	165 (330)	180 (350)	120	Х				X			Х			14	6	Х	Х			Satellite Antennae/Solar Array/Support Structures	996
954-3A	195 (385)	180 (350)	120	Х	Х		Х				Х			14	12	Х	Х			Satellite Antennae/Solar Array/Support Structures/Radomes	954-3A

HexPly [®] Resin	Dry Ta	Typical Cu	re Cycle	cle Cure Process		Self	Flow		Toughness	Self		Outlife at Room	Storage at	St	tandard	Prepreg Fo	rms		HexPly [®] Resin
Systems	Onset (DMA) °C (°F)	Temp ℃ (°F)	Time (mins)	Autoclave/ Press	Vacuum Only	Adhesive	Controlled High	High	Med	Low	Extinguishing	Temperature (days)	(months)	UD Tape	Fabri	ic Tow Preg	Spli Tape	Iypical Applications	Systems
Ероху																			Ероху
ES15	85 (185)	120 (250)	9	Х			X			Х		5	6	Х	X			Ski/Snowboards/Sports Goods - Transparent Resin System	ES15
M44	90 (195)	140 (285)	13	Х	Х		X	X				21	12	Х				Tennis Rackets/Golf Shafts/Fishing Rods/Sports Goods	M44
M34	90 (195)	75 (165)	480	Х	Х	Х	X			Х	Х	10	12		Х			Railway Fairings/Structures/Marine/General Industrial	M34
EF01	95 (200)	120 (250)	15	Х	Х	Х	X	X				14	14	Х	Х			Bicycle Wheels/Sports Goods/General Industrial/Snowboards	EF01
M32	100 (210)	120 (250)	9	Х		Х	X		Х			7	6	Х	Х			Ski/Snowboard/Industrial	M32
M26T	115 (235)	125 (255)	90	Х	Х	Х	X	X			Х	30	12	Х	X			Floor Panels/Fairings/Sandwich Structures	M26T
M9.1F/M9.6F	125 (255)	120 (250)	30	Х	Х		X		Х			42	12	Х	Х			Large Industrial Components/Wind Turbine Blades	M9.1F/M9.6F
M10	125 (255)	120 (250)	60	Х	Х		X		Х			60	12	Х	Х			General Industrial/Wind Turbine Blades/Leaf Springs/Boat Hulls	M10
EH04	125 (255)	130 (265)	8	Х	Х		X		Х			14	12	Х	Х			Bike Components/Golf Shafts/Fishing Rods/Kayak Paddles/Hockey Sticks & Blades	EH04
M35-4	135 (275)	135 (275)	90	Х	Х		X	X				60	12	Х	Х			UAV's, Motorsport Components - Flexible Curing Matrix, Tg of 200°C after post-cure	M35-4
M76	135 (275)	135 (275)	180	Х		Х	X	X				21	12	Х	X			Motorsport/Space Applications - Flexible Curing Matrix	M76
M47 (1947)	145 (295)	135 (275)	90	Х			X		Х		Х	30	12	Х	Х			Automotive Parts, eg Bonnets & Body Panels - Excellent Surface Finish	M47 (1947)
913	150 (300)	125 (255)	60	Х			X			Х		30	12	X	X			Aerospace Structural Components/Fin Box/Belly Fairings/Helicopter Blades	913
M20	150 (300)	130 (265)	120	Х	Х		X			X		30	12	X	X			Aerospace Composite Repair/Motorsport Components	M20
8551-7	155 (315)	180 (350)	120	Х	Х		X	X				30	12	Х	Х	Х	Х	Structural Applications Requiring Extreme Damage Resistance	8551-7
M73	185 (365)	180 (350)	360	Х			X	X				10	12	X	X			Aerospace Primary & Secondary Structures/Space Applications	M73
M74	190 (375)	180 (350)	120	Х			X		X			10	12	X	X	X		Aerospace Structural Components/Critical Space Structures	M74
M21	195 (385)	180 (350)	120	Х			X	X				30	12	Х	X			Aerospace Primary Structures	M21
8552	195 (385)	180 (350)	120	Х	Х		X		Х			21	12	Х	Х	Х	X	Aerospace Structural Parts/Empennage/Fighter Wings	8552
M18	200 (390)	180 (350)	120	Х			Х		Х			30	12	Х	Х	Х		Space Applications/Antennae/Solar Panels	M18
M18/1	200 (390)	180 (350)	120	Х			X		Х		Х	30	12		X			Helicopter Structural Parts	M18/1
M36	200 (390)	180 (350)	120	Х	Х		X		Х			14	10	He	eavy We	ight Films fo	r RFI	Aerospace Structural Components - Resin Film Infusion	M36
922-1	210 (410)	180 (350)	120	Х			X			Х		10	12	Х	Х			Engine/Nacelle Structures - High Service Temperature	922-1
Phenolic HT93	[80 (175) in service]	125 (255)	120	X		X	x			x	×	30	14		x		1	Aircraft Interior Panels/Partitions (Low FST)	Phenolic HT93
M41	[80 (175) in service]	135 (275)	30	X		Х	X			X	Х	30	12		X			Aircraft Interior Panels/Partitions/Crush Core Process (Low FST)	M41
200	[200 (390) in service]	150 (300)	60	X		Х	X			Х	Х	30	12		X		_	Fire Proof Panels & Components	200
ВМІ				1						<u> </u>			1						BMI
F655	290 (550)	190 (375)	240+PC	Х			X		Х			30	12	Х	Х			High Temperature Primary/Secondary Structures/Engine Components Toughened	F655
F650	315 (600)	190 (375)	240+PC	Autoclave			X			Х	Х	30	12	Х	Х	Х	Х	High Temperature Primary/Secondary Structures/Engine Components	F650
Cyanates					1														Cyanates
954-6	145 (295)	120 (250)	180	Х			X	X				14	6	X	Х			Satellite Antennae/Solar Array/Support Structures/Radomes	954-6
996	165 (330)	180 (350)	120	Х			X		Х			14	6	X	X			Satellite Antennae/Solar Array/Support Structures	996
954-3A	195 (385)	180 (350)	120	Х	Х		X		X			14	12	Х	X			Satellite Antennae/Solar Array/Support Structures/Radomes	954-3A
954-3	205 (400)	180 (350)	120	Х			X		X			14	12	Х	X		X	Satellite Antennae/Solar Array/Support Structures/Radomes	954-3



Flow - a measure of matrix viscosity i.e. a low flow matrix has a high viscosity. Toughness - the ability to resist delamination on impact.

Notes Dry Tg Onset - the temperature at which glass transition starts, representing the initial drop in modulus, E¹, of the component, as measured directly after curing.





TYPICAL PREPREG PROCESSING TECHNIQUES



Important

All information is believed to be accurate but is given without acceptance of liability. Users should make their own assessment of the suitability of any product for the purposes required. All sales are made subject to our standard terms of sale which include limitations on liability and other important terms.

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