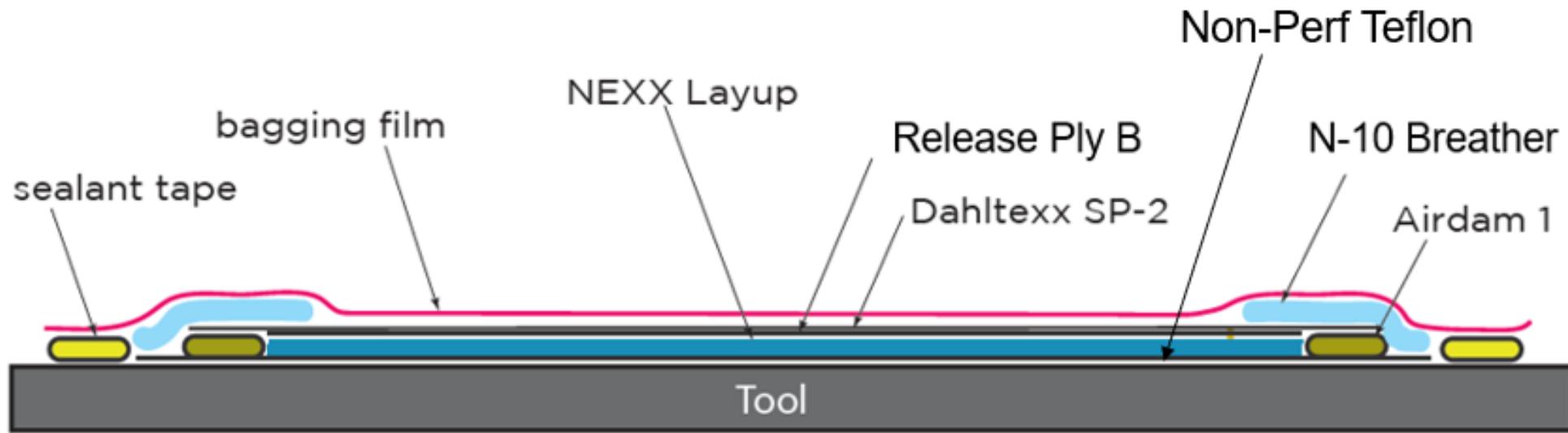




NTB-500 BMI VBO Processing Guide

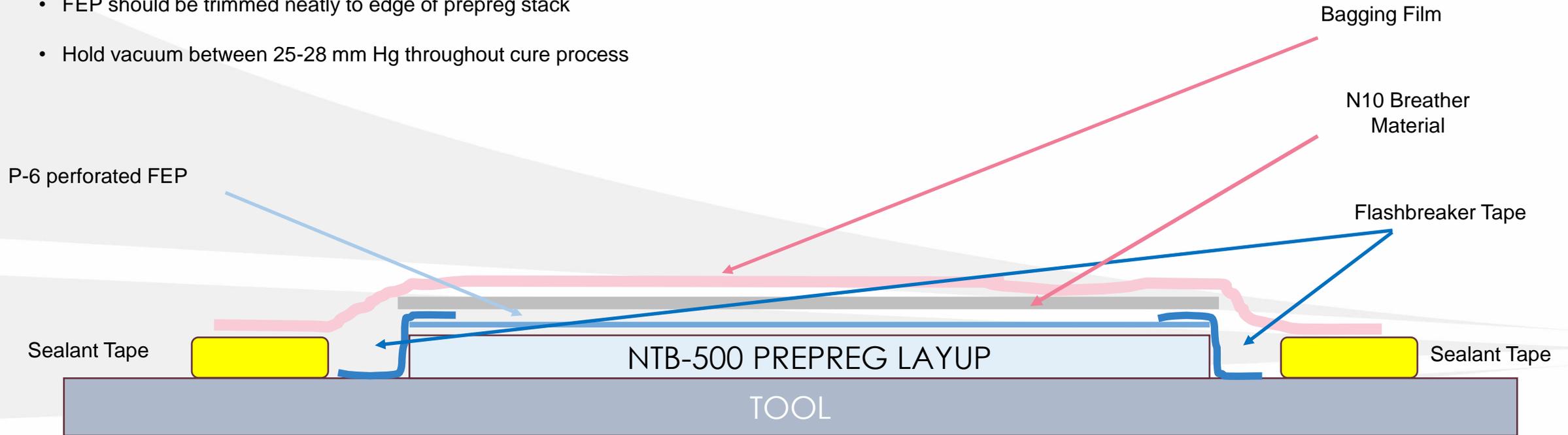
Bagging Scheme Opt 1



Note: Wrap Release Ply B around edge of Panel and sandwich it between the Airdam

Bagging Scheme Opt 2

- For Ply counts greater than 10 plies use Airdam between laminate stack and sealant tape to contain resin flow.
- FEP should be trimmed neatly to edge of prepreg stack
- Hold vacuum between 25-28 mm Hg throughout cure process



1. Ramp from RT to 250°F at 3-5°/min
2. Soak at 250°F for 5 hours
3. Ramp to 350°F at 3-5°/min
4. Soak at 350°F for 2 hours
5. End (Let Panel Cool to Ambient in Oven)
6. Post-cure temperatures can be varied from a post-cure of 200°C to 220°C to achieve higher toughness and glass transition temperature.

