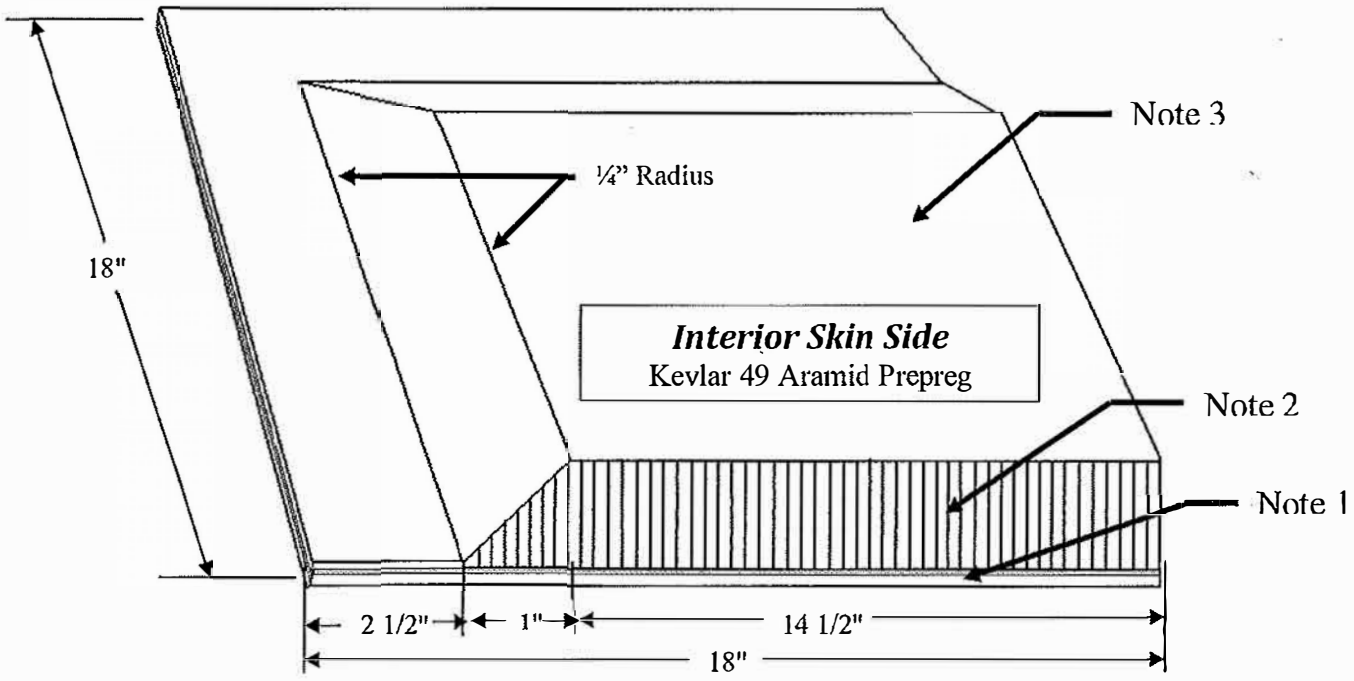
CLIN0002

SPECIFICATIONS FOR MANUFACTURE OF COMPOSITE TRAINING PANELS, Panel Composite, Panel part number/NSN: 9390-CO-MPO-SITE
(Panels are used by ASM, Supplemental Advanced Composite Repair course)

See Notes 1 – 4 for materials requirements. Panel overall width and length dimensions +/- .125 tolerances.

1. Exterior skin 8 Plies, quasi-isotropic lay-up unidirectional graphite epoxy tape, Hexcel number T2C-190-12-F263-2, or equal to (Boeing Material Specification) BMS8-212 TY3 CL1 GR190. Balanced ply orientation [(+45 / -45 / 0 / 90)] [(90 / 0 / -45 / +45)]
2. Fiberglass / Phenolic honeycomb core, 3/16-4.0, 1" thick HRP, (height 1" continuous, with no splices or butts) HRP-3/16-4.0. Transition angles to be uniform.
3. Interior skin Kevlar 49 Aramid prepreg. Cytec number MXM-7880-/285, or equal to BMS8-218 ST285, 4 plies (crowfoot) cross ply lay-up.
4. Internal and external skins to core, bond with film adhesive equivalent to BMS5-154 TY2 CL1 GR5.

NOTE: All surfaces must be wrinkle free with no seams or butted joints.



Specification sheet/drawing for all specific design requirements.
Advanced composite training panel, composite FFP-Panel, Composite 1" thick core X18" X18".
Side 1 (exterior Skin), 8 plies BMS8-212 TY3 CL1 GR 190 equivalent, balanced ply lay-up, {[(+45, -45, 0, 90)][(90, 0, -45, +45)]} Fiberglass/Phenolic Honeycomb Core 3/16-4.0, 1.0" Thick HRP. Side 2, (Interior Skin) is Kevlar 49 aramid prepreg. Equal to Boeing spec BMS8-218 ST285, 4 plies (crowfoot weave) cross ply lay-up. 2 sides with transition edges as per specification sheet with ¼" radiuses; core height continuous, with no splices or butts. Skin to core bond with film adhesive equivalent to BMS5-154 TY2 CL1 GR5