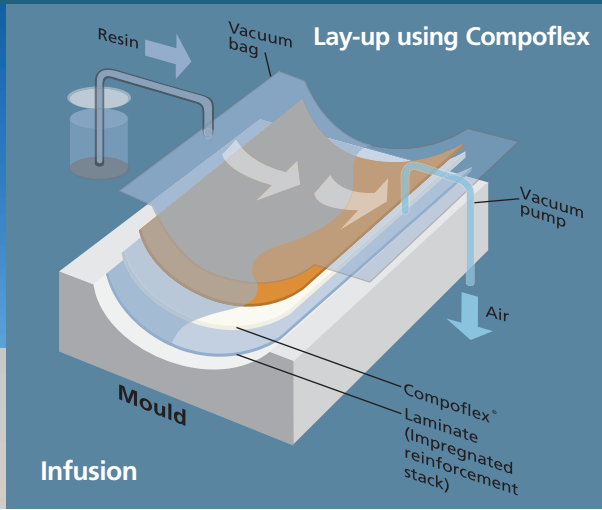


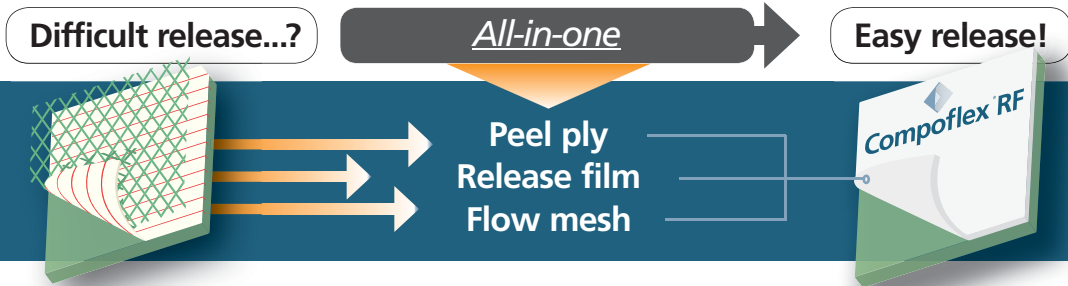


Compoflex®



- Optional
- Flow mesh incorporated
 - Secondary bonding surface

Vacuum Resin
Infusion



How can Compoflex® save daily production time and costs?

Standard Compoflex®
The Compoflex® products are breathable microporous peeling materials. For infusion, Compoflex is designed to replace up to three consumables with a single layer. In composite manufacturing, Compoflex® offers direct benefits:

- **Superior peeling properties**
The microporous surface and the low surface tension of PP nonwovens ensure that Compoflex® releases at one fifth of the force needed to peel conventional peel ply.
- **Easy release minimises resin dust**
Compoflex® RF releases easily so that hardened resin remains in the liner, reducing the amount of airborne resin dust. The release force required when not using Compoflex® generates intensive resin dust activity, causing an unhealthy working environment.

Resin Flow Compoflex® RF
• **Time and cost savings**
In the infusion process, Compoflex® RF replaces peel ply and flow mesh. Fewer consumables combined with easy release reduce costs and handling time, simplifying the process considerably. Compoflex® RF is easy to lay due to the integrated flexible grid.

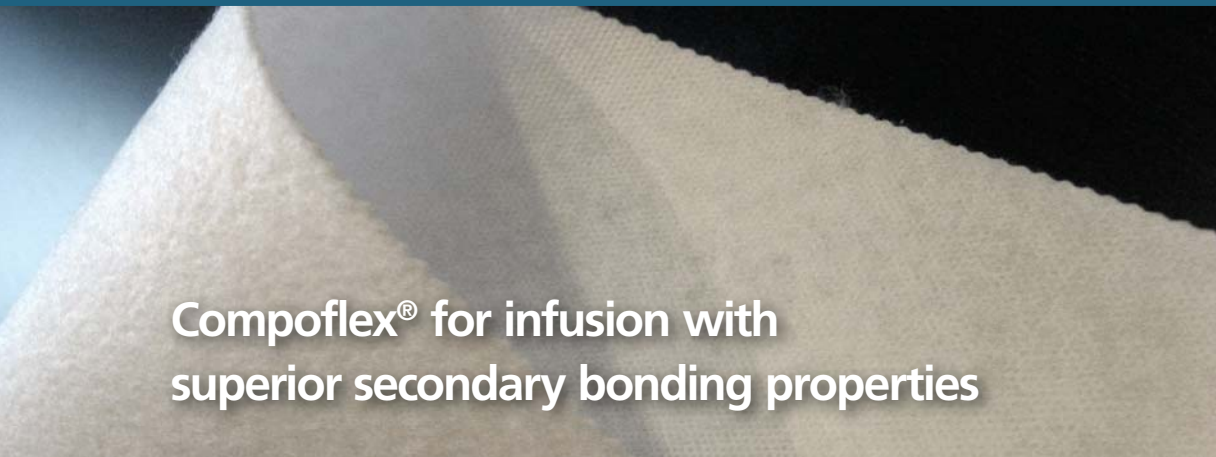
Secondary Bonding Compoflex® SB
• **Excellent secondary bonding surface**
Compoflex® SB is designed to produce a surface ready for secondary bonding while maintaining the superior peeling properties of the standard Compoflex™ products.

Secondary Bonding + Resin Flow Compoflex® SB RF
• **Excellent combined surface advantages**
Compoflex® RF is also available in an SB RF version – secondary bonding and resin flow. Compoflex® SB RF creates a surface which is ready for bonding without the need for grinding.

Important: Due to the microporous surface of the Compoflex®, more and/or bigger valves may need to be installed depending on laminate size and thickness.

Please see next page for technical data >>

Distributed by:



Compoflex® for infusion with superior secondary bonding properties

Property	Standard	Unit	Compoflex® 150	Compoflex® SB 150	Compoflex® RF 150	Compoflex® SB RF 150
Weight	-	g/m ²	150	150	250	250
Thickness at 2 kPa	ISO 9863-1	mm	0.6	0.6	0.9	0.9
Tear resistance MD/CD	ISO 9073-4	N	170 / 100	170 / 100	280 / 188	280 / 188
Resin capacity	-	cm ³ /m ²	305	305	530	530
Pore size	ISO 12956	µm	< 10	< 10	< 10	< 10
Composition	-	-	100% PP	100% PP	67% PP (non woven), 33% PET (grid)	67% PP (non woven), 33% PET (grid)
Process	-	-	Resin infusion	Resin infusion	Resin infusion	Resin infusion

Above technical values are indicative
MD = machine direction CD = cross direction

Compoflex® Infusion replaces peel ply and distribution mesh

Compoflex® 150 • standard	Compoflex® SB 150 • gives better surface for secondary bonding than peel ply or grinding	Compoflex® RF 150 • mesh for resin flow incorporated	Compoflex® SB RF 150 • combines the benefits of SB and RF products
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Conclusions from Risø National Laboratory for Sustainable Energy [Risø DTU / May 2009]

Initiation (starting of a fracture)

- 50% more energy is required when using Compoflex® SB compared to using standard peel ply
- 130% more energy is required when using Compoflex® SB compared to hand grinding

Propagation (continuation of an already started fracture)

- Approximately the same energy is required when using Compoflex® SB as standard peel ply

Risø - 1 - 2868 (EN) The bonding performance of a glass/polyester composite surface when vacuum is injected using Compoflex® 150 or Compoflex® SB 150 has been compared with a typical "standard" peel ply fabric surface. The effect of grinding the Compoflex® 150 surface by hand or using a random orbit grinder was also investigated. Test results are summarised in the following table:

	Initiation fracture energy [J/m ²]	Standard deviation [J/m ²]
Compoflex®	41	12
+ Hand grinding	173	57
+ Random orbit grinding *	231	19
Compoflex® SB	399	73
Peel ply	272	38

Working temperature

The melting point for polypropylene is 165 °C (329 °F) and our recommended working temperature is approx. 145 °C (293 °F). However, we do have customers using Compoflex® at 200 °C (392 °F). This is because Compoflex® performs before the temperature exceeds the melting point. Peeling is just as easy and the material becomes stable again. We recommend conducting a test on a small part first.

Certified

Fibertex A/S is certified according to EN ISO 9001 and ISO 14001, and Compoflex® is manufactured according to current European technical and environmental regulations.

Contact us

For specific input on how Compoflex® will optimise your production time and costs, please contact your local distributor or Fibertex:

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Risø is the National Laboratory for Sustainable Energy at the Technical University of Denmark - DTU. Risø carries out scientific and technical-scientific research that can provide Danish society with new opportunities for technological development and takes responsibility for the results to be used.

Please contact us at fibertex@fibertex.com if you would like to receive the full report.

