

Superior peeling properties
No resin dust
Time and cost savings

V a c u u m B a g g i n g

Pre-preg and hand lay-up



How can Compoflex® save daily production time and costs?

Standard Compoflex®: All-in-one!

The Compoflex® products are breathable microporous peeling materials. 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® peels at one fifth of the force needed to peel conventional peel ply.

- **Time and cost savings**

In vacuum bagging, Compoflex® can replace three consumables – peel ply, release film and breather. Fewer consumables combined with easy peeling reduce costs and handling time, simplifying the process considerably.

- **Easy peeling minimises resin dust**

Compoflex® peels easily and hardened resin remains in the liner reducing the amount of airborne resin dust. Traditional peel ply generates intensive resin dust activity, causing an unhealthy working environment.

Secondary Bonding Compoflex® SB

- **Compoflex® SB with secondary bonding properties**

Compoflex® SB is designed to produce a surface ready for secondary bonding while maintaining the superior peeling properties of the standard Compoflex® products. Compoflex® SB is offered in two versions for pre-preg and hand lay-up.

- **Simplifying the process**

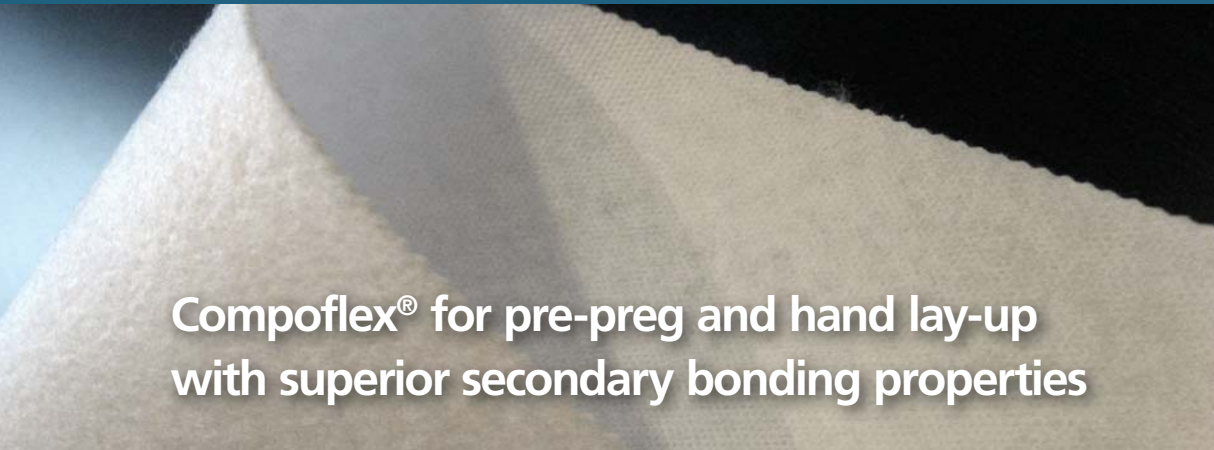
Compoflex® SB 250 replaces low capacity breather fabrics while SB 400 replaces high capacity breather fabrics.

Moreover, both products replace peel ply and release film, simplifying and streamlining your production.



Please see next page for technical data >>

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Compoflex® for pre-preg and hand lay-up with superior secondary bonding properties

Property	Standard	Unit	Compoflex® 250	Compoflex® SB 250	Compoflex® 400	Compoflex® SB 400
Thickness at 2 kPa	ISO 9863-1	mm	1.0	1.0	1.5	1.5
Tear resistance MD/CD	ISO 9073-4	N	305 / 195	305 / 195	460 / 275	460 / 275
Resin capacity	-	cm ³ /m ²	810	810	1135	1135
Pore size	ISO 12956	µm	< 10	< 10	< 10	< 10
Composition	-	-	100% PP	100% PP	100% PP	100% PP
Process	-	-	Vacuum bagging	Vacuum bagging	Vacuum bagging	Vacuum bagging

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

Compoflex® for pre-preg replaces peel ply, breather and release film

Compoflex® 250 • 150g breather (5oz)	Compoflex® SB 250 • 150g breather (5oz) • better surface for secondary bonding	Compoflex® 400 • 300g breather (10oz)	Compoflex® SB 400 • 300g breather (10oz) • better surface for secondary bonding
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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



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.

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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