



Designation: **D3532/D3532M – 12 D3532/D3532M – 19**

Standard Test Method for Gel Time of Carbon Fiber-Epoxy Prepreg¹

This standard is issued under the fixed designation D3532/D3532M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This test method covers the determination of gel time of carbon fiber-epoxy tape and sheet. The test method is suitable for the measurement of gel time of resin systems having either high or low viscosity.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system ~~may~~ are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other. ~~Combining other, and~~ values from the two systems ~~may result in non-conformance with the standard; shall not be combined.~~

1.2.1 Within the text, inch-pound units are shown in brackets.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and ~~health~~ environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D3531/D3531M Test Method for Resin Flow of Carbon Fiber-Epoxy Prepreg](#)

[D4473 Test Method for Plastics: Dynamic Mechanical Properties: Cure Behavior](#)

[D7750 Test Method for Cure Behavior of Thermosetting Resins by Dynamic Mechanical Procedures using an Encapsulated Specimen Rheometer](#)

3. Summary of Test Method

3.1 A specimen of prepreg material approximately 5 mm [0.25 in.] square is placed between microscope ~~cover glasses~~ coverglasses on a hot plate preheated to either of two test temperatures, 120 or ~~175°C~~ 175 °C [250 or ~~350°F~~ 350 °F]. Pressure is applied to the specimen through the coverglass with a wood pick to ~~form a bead of resin at the edge of the cover glass. manipulate the resin.~~ The time from the application of heat until the resin ceases to ~~form strings~~ flow by contact with the pick is noted and reported as the gel time.

4. Significance and Use

4.1 This test method can be used to obtain the gel time of resin squeezed from prepreg tape or sheet material. This test is a useful measure for material acceptance.

4.2 The gel time will vary with the test temperature. The temperatures specified in this test method are two of many temperatures often used in processing epoxy prepreg material. If other test temperatures are used, this is to be clearly noted as indicated in ~~9.1.2~~ 10.1.2.

¹ This test method is under the jurisdiction of ASTM Committee D30 on Composite Materials and is the direct responsibility of Subcommittee D30.03 on Constituent/Precursor Properties.

Current edition approved May 1, 2012; Sept. 1, 2019. Published June 2012; September 2019. Originally approved in 1976. Last previous edition approved in 2009 as D3532 – 99; D3532/D3532M – 12 (2009); DOI: 10.1520/D3532-D3532M-12; 10.1520/D3532-D3532M-19.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.