



Designation: **E1556 – 08 E1556 – 12**

Standard Specification for Epoxy Resin System for Composite Skin, Honeycomb Sandwich Panel Repair¹

This standard is issued under the fixed designation E1556; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

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

1. Scope

1.1 This specification covers the requirements for an epoxy resin system intended for the repair of sandwich panels for durable, rigidwall, relocatable structures. It must be usable in a field environment and shall not require the use of special equipment such as autoclaves or presses. The epoxy system covered by this specification shall be usable for simultaneous impregnation of a wet-layup composite skin and bonding of that skin to a substrate honeycomb core. The material shall withstand exposure to temperatures from -54 to 93°C (-65 to 199°F) and high relative humidity, and also the combination of stress, temperature, and relative humidity that are expected to be encountered in service.

1.2 The values stated in SI units are to be regarded as standard where only SI units are given or where SI units are given first followed by inch-pound units; where inch-pound units are given first followed by SI units, the inch-pound units are to be regarded as the standard.

1.3 The following safety hazards caveat refers only to the test methods described in this specification. *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

[D297/C297M Test Method for Flatwise Tensile Strength of Sandwich Constructions](#)

[D792 Test Methods for Density and Specific Gravity \(Relative Density\) of Plastics by Displacement](#)

[D2344/D2344M Test Method for Short-Beam Strength of Polymer Matrix Composite Materials and Their Laminates](#)

[D2584 Test Method for Ignition Loss of Cured Reinforced Resins](#)

[D2734 Test Methods for Void Content of Reinforced Plastics](#)

[E874 Practice for Adhesive Bonding of Aluminum Facings to Nonmetallic Honeycomb Core for Shelter Panels](#)

[D3165 Test Method for Strength Properties of Adhesives in Shear by Tension Loading of Single-Lap-Joint Laminated Assemblies](#)

[E631 Terminology of Building Constructions](#)

[E1091 Specification for Nonmetallic Honeycomb Core for Use in Shelter Panels](#)

[E1749 Terminology Relating to Rigid Wall Relocatable Shelters](#)

2.2 Military Specifications:³

[MIL-I-24768 Insulation, Plastic, Laminated, Thermosetting, Glass-Cloth, Epoxy-Resin](#)

2.3 Military Standards:³

[MIL-STD-129 Military Marking for Shipping and Storage](#)

[MIL-STD-1916 DOD Preferred Methods for Acceptance of Product](#)

2.4 Commercial Standards:⁴

[SAE-AMS-C-9084 Cloth, Glass, Finished for Epoxy Resin Laminates](#)

¹ This specification is under the jurisdiction of ASTM Committee E06 on Performance of Buildings and is the direct responsibility of Subcommittee E06.53 on Materials and Processes for Durable Rigidwall Relocatable Structures.

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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.

³ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

⁴ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

3. Terminology

3.1 *Definitions*—See Terminologies E631 and E1749 for definitions of general terms used in this specification.

4. Physical Requirements

4.1 Working Characteristics:

4.1.1 *Application*—The components of the epoxy resin shall be readily hand-mixed to a smooth consistency suitable for application. It shall be uniform and free of lumps. The resin components, once mixed, shall not settle out. The epoxy material shall be suitable for the wet-layup impregnation of SAE-AMS-C-9084 glass cloth and for application to core materials over the temperature range of 16 to 38°C (60 to 100°F) and at relative humidities of 30 to 75 %.

4.1.2 *Application Life*—The application life of a 200-g kit of the mixed epoxy system shall be at least 60 min when tested in accordance with 3.1-54.1.5. The epoxy shall be considered to have reached the end of its application life when the viscosity of this 200-g quantity of mixed adhesive exceeds 20 000 centipoise.

4.1.3 *Curing*—The epoxy system shall be capable of curing at 23 ± 2°C (73 ± 4°F) in 7 days, or for no longer than 3 h at a temperature of 60 to 66°C (140 to 151°F), with a curing pressure not to exceed 14 psig. In a 23 ± 3°C cure, the curing pressure is not required to be maintained after the first 24 h. In a 23 ± 2°C cure, the epoxy material shall develop the property levels listed in Table 1 within the first 24 h of cure (see 7.3.58.3.5). In order to meet the requirements of this specification, the property levels listed in Tables 2-4 must be achieved with the 7-day cure at 23 ± 2°C (73 ± 4°F).

4.1.4 *Storage Life*—The storage life period of the two parts of the epoxy resin system, when stored in airtight containers at 23°C (73°F), shall be at least 12 months from the date of shipment when tested in accordance with 7.3.58.3.5.

4.1.5 *Viscosity*—The viscosity of a 200-g kit of the mixed resin system shall be determined at 23 ± 2°C (73 ± 4°F) using a Brookfield viscometer with a No. 3 spindle at 20 rpm. A viscosity curve shall be determined by taking a reading immediately after mixing, and every 5 min thereafter until the viscosity exceeds 20 000 centipoise. The viscosity immediately after mixing shall not exceed 14 000 centipoise.

4.2 *Mechanical Properties*—Mechanical properties of test specimens prepared and tested as specified in Section 78 shall meet the respective requirements listed in Tables 2-4.

4.3 *Instruction Sheet*—The manufacturer shall provide a dated, coded, and titled instruction sheet outlining instructions for use of the epoxy system in impregnating and bonding SAE-AMS-C-9084 glass composite skins to honeycomb cores (Specification E1091, Types I or II). These instructions shall be supplied by the manufacturer with the test report when requesting qualification (see 6.37.3) and also with each shipment of epoxy material (see 9.210.2). The following information shall be included:

4.3.1 All of the information listed in 5.3.1-6.3.1-5.3.11-6.3.11.

4.3.2 The application life of the mixed epoxy system at 23 ± 2°C (73 ± 4°F) and 38 ± 2°C (100 ± 4°F).

4.3.3 Mixing instructions shall be stated in detail for the epoxy resin system in the particular container supplied.

4.3.4 Application, impregnating, and curing instructions, including the spreading method, thickness range, and temperature/relative humidity working limitations.

4.3.5 Material Safety Data Sheets and necessary safety precautions to be observed throughout all operations.

4.3.6 Any other pertinent information relative to the use and storage of the two-part system (resin and curing agent) package (see 9.210.2).

5. Significance and Use

5.1 Epoxy resin systems used in the repair of composite skin sandwich panels for durable, rigidwall, relocatable shelters must have a combination of mechanical property levels and environmental resistance that will assure long-term durability of the skins

TABLE 1 Property Requirements for 24-h, 23°C Cure

Property	Test Condition	Number of Specimens	Average Must Exceed		Minimum Must Exceed, ^A	
			MPa	(psi)	MPa	(psi)
Tensile Lap Shear Strength in accordance with 7.2.1, 7.3.1	23°C (73°F), dry	5	6.9	(1000)	5.85	(850)
Apparent Horizontal Shear Strength in accordance with 7.2.2, 7.3.2	23°C (73°F), dry	5	15.5	(2250)	13.15	(1910)

TABLE 1 Property Requirements for 24-h, 23°C Cure

Property	Test Condition	Number of Specimens	Average Must Exceed		Minimum Must Exceed, ^A	
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Tensile Lap Shear Strength in accordance with 8.2.1, 8.3.1	23°C (73°F), dry	5	6.9	(1000)	5.85	(850)
Apparent Horizontal Shear Strength in accordance with 8.2.2, 8.3.2	23°C (73°F), dry	5	15.5	(2250)	13.15	(1910)

^A All specimens tested must exceed these minimum values.