

## Sales Range January, 2008

ROHACELL®	Size [mm]	Standard sheet thickness [mm]	Possible sheet thickness [mm]
31 A	2500 x 1250	4 to 90	1 to 140
51 A	2500 x 1250	4 to 80	1 to 120
71 A	2500 x 1250	4 to 65	1 to 100
110 A	2160 x 1100	4 to 55	1 to 90

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
31 A	98.4 x 49.2	0.16 to 3.54	0.04 to 5.51
51 A	98.4 x 49.2	0.16 to 3.14	0.04 to 4.72
71 A	98.4 x 49.2	0.16 to 2.55	0.04 to 3.93
110 A	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54

Thickness tolerance +/- 0.008inch, others on request

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## Sales Range January, 2008

ROHACELL®	Size [mm]	Standard sheet thickness [mm]	Possible sheet thickness [mm]
31 HF	2500 x 1250	4 to 90	1 to 110
51HF	2500 x 1250	4 to 80	1 to 95
71 HF	2500 x 1250	4 to 65	1 to 75

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
31 HF	98.4 x 49.2	0.16 to 3.54	0.04 to 4.33
51 HF	98.4 x 49.2	0.16 to 3.14	0.04 to 3.74
71 HF	98.4 x 49.2	0.16 to 2.55	0.04 to 2.95

Thickness tolerance +/- 0.008inch, others on request

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ROHACELL®	Size [mm]	Standard sheet thickness [mm]	Possible sheet thickness [mm]
31 IG	2500 x 1250	4 to 90	1 to 140
51 IG	2500 x 1250	4 to 80	1 to 120
71 IG	2500 x 1250	4 to 65	1 to 100
110 IG	2160 x 1100	4 to 55	1 to 90

Thickness tolerance +/- 0.5mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
31 IG	98.4 x 49.2	0.16 to 3.54	0.04 to 5.51
51 IG	98.4 x 49.2	0.16 to 3.14	0.04 to 4.72
71 IG	98.4 x 49.2	0.16 to 2.55	0.04 to 3.93
110 IG	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54

Thickness tolerance +/- 0.02inch, others on request

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ROHACELL®	Size [mm]	Standard sheet thickness [mm]
51 RIMA	2500 x 1250	4 to 80
71 RIMA	2500 x 1250	4 to 65
110 RIMA	2160 x 1100	4 to 55

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]
51 RIMA	98.4 x 49.2	0.16 to 3.14
71 RIMA	98.4 x 49.2	0.16 to 2.55
110 RIMA	85.0 x 43.3	0.16 to 2.16

Thickness tolerance +/- 0.008inch, others on request

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## Sales Range January, 2008

ROHACELL®	Size [mm]	Standard sheet thickness [mm]
51 RIMA- HT	2500 x 1250	4 to 70
71 RIMA-HT	2500 x 1250	4 to 60
110 RIMA-HT	2160 x 1100	4 to 50

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]
51 RIMA-HT	98.4 x 49.3	0.16 to 3.14
71 RIMA-HT	98.4 x 49.3	0.16 to 2.55
110 RIMA-HT	85.0 x 43.3	0.16 to 2.16

Thickness tolerance +/- 0.008inch, others on request

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## Sales Range January, 2008

ROHACELL®	Size [mm]	Standard sheet thickness [mm]	Possible sheet thickness [mm]
51 RIST	2500 x 1250	4 to 80	1 to 120
71 RIST	2500 x 1250	4 to 65	1 to 100
110 RIST	2160 x 1100	4 to 55	1 to 90

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
51 RIST	98.4 x 49.2	0.16 to 3.14	0.04 to 4.72
71 RIST	98.4 x 49.2	0.16 to 2.55	0.04 to 3.93
110 RIST	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54

Thickness tolerance +/- 0.008inch, others on request

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51 RIST- HT	2500 x 1250	4 to 70	1 to 110
71 RIST-HT	2500 x 1250	4 to 60	1 to 100
110 RIST-HT	2160 x 1100	4 to 50	1 to 90

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
51 RIST-HT	98.4 x 49.3	0.16 to 3.14	0.16 to 4.33
71 RIST-HT	98.4 x 49.3	0.16 to 2.55	0.16 to 3.93
110 RIST-HT	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54

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## Sales Range

### January, 2008

ROHACELL®	Size [mm]	Standard sheet thickness [mm]
51S	2500 x 1250	4 to 80
71 S	2500 x 1250	4 to 65
110 S	2160 x 1100	4 to 55

Thickness tolerance +/- 0.5mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]
51 S	98.4 x 49.2	0.16 to 3.14
71 S	98.4 x 49.2	0.16 to 2.55
110 S	85.0 x 43.3	0.16 to 2.16

Thickness tolerance +/- 0.02inch, others on request

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## Sales Range January, 2008

ROHACELL®	Size [mm]	Standard sheet thickness [mm]	Possible sheet thickness [mm]
51 WF	2500 x 1250	4 to 80	1 to 120
71 WF	2500 x 1250	4 to 65	1 to 100
110 WF	2160 x 1100	4 to 55	1 to 90
200 WF	1900 x 900	6 to 32	6 to 55

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
51 WF	98.4 x 49.3	0.16 to 3.14	0.04 to 4.72
71 WF	98.4 x 49.3	0.16 to 2.55	0.04 to 3.93
110 WF	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54
200 WF	74.8 x 35.4	0.23 to 1.25	0.23 to 2.16

Thickness tolerance +/- 0.008inch, others on request

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ROHACELL®	Size [mm]	Standard sheet thickness [mm]	Possible sheet thickness [mm]
51 WF- HT	2500 x 1250	4 to 70	1 to 110
71 WF-HT	2500 x 1250	4 to 60	1 to 100
110 WF-HT	2160 x 1100	4 to 50	1 to 90
200 WF-HT	1900 x 900	12.7 to 25.4	12.7 to 50

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
51 WF-HT	98.4 x 49.3	0.16 to 3.14	0.16 to 4.33
71 WF-HT	98.4 x 49.3	0.16 to 2.55	0.16 to 3.93
110 WF-HT	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54
200 WF-HT	74.8 x 35.4	0.23 to 1.25	0.5 to 1.96

Thickness tolerance +/- 0.008inch, others on request

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ROHACELL®	Size [mm]	Standard sheet thickness [mm]	Possible sheet thickness [mm]
71 XT	2500 x 1250	4 to 65	1 to 100
110 XT	2160 x 1100	4 to 55	1 to 90

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
71 XT	98.4 x 49.3	0.16 to 2.55	0.04 to 3.93
110 XT	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54

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71 XT-HT	2500 x 1250	4 to 60	1 to 100
110 XT-HT	2160 x 1100	4 to 50	1 to 90

Thickness tolerance +/- 0.2mm, others on request

ROHACELL®	Size [inch]	Standard sheet thickness [inch]	Possible sheet thickness [inch]
71 XT-HT	98.4 x 49.3	0.16 to 2.55	0.16 to 3.93
110 XT-HT	85.0 x 43.3	0.16 to 2.16	0.16 to 3.54

Thickness tolerance +/- 0.008inch, others on request

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## Product Info on ROHACELL® A

ROHACELL® A (Aircraft Grade) is a closed-cell rigid foam plastic, based on PMI (polymethacrylimide) chemistry, which does not contain any CFC's.

The field of application for ROHACELL® A is aircraft construction.

For processing up to temperature of 130°C (266°F) and maximum pressure up to 0,3 MPa (45 PSI).

Sandwich components using ROHACELL® A as core material can be realized in a single work step (co-curing).

Structural components can be manufactured by the following cure methods; autoclave, vacuum bagged, RTM, VARTM, press and others.

The thermoformability of ROHACELL® provides a tremendous manufacturing advantage.

The thermo-elastic properties make this unique to ROHACELL®.

ROHACELL® A is easy to shape and machine.

® = registered trademark

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## Product Info on ROHACELL® HF

ROHACELL® HF (High Frequency) is a closed-cell rigid foam plastic, based on PMI (polymethacrylimide) chemistry, which does not contain any CFC's.

The fields of application for ROHACELL® HF include, but are not limited to; Antennas (no corrosive effect on materials), radomes and x-ray tables. For processing up to temperature of 130°C (266°F) and maximum pressure up to 0,3 MPa (45 PSI).

Sandwich structures using ROHACELL® HF as a core material can be realized in a single work step (co-curing). By means of hand/wet lay up, VARTM, low pressure RTM, autoclave, SCRIMP, and others.

ROHACELL® is thermoformable, which is a big advantage over other core materials.

ROHACELL® HF is easy to shape and machine.

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## Properties of ROHACELL® IG/IG-F

Properties	Unit	ROHACELL® 31 IG/IG-F	ROHACELL® 51 IG/IG-F	ROHACELL® 71 IG/IG-F	ROHACELL® 110 IG/IG-F	Standard
Density	kg/m <sup>3</sup>	32	52	75	110	ISO 845
	lbs./cu.ft.	2.0	3,25	4,68	6,87	ASTM D 1622
Compressive strength	MPa	0,4	0,9	1,5	3,0	ISO 844
	psi	58	130	217	435	ASTM D 1621
Tensile strength	MPa	1,0	1,9	2,8	3,5	ISO 527-2
	psi	145	275	406	507	ASTM D 638
Shear strength	MPa	0,4	0,8	1,3	2,4	DIN 53294
	psi	58	116	188	348	ASTM C 273
Elastic modulus	MPa	36	70	92	160	ISO 527-2
	psi	5,220	10,150	13,340	23,200	ASTM D 638
Shear modulus	MPa	13	19	29	50	DIN 53294
	psi	1,885	2,755	4,205	7,250	ASTM C 273
Elongation at break	%	3,0	3,0	3,0	3,0	ISO 527-2
						ASTM D 638
Heat distortion temperature	°C	180	180	180	180	DIN 53424
	°F	356	356	356	356	

Technical data of our products are typical values for the nominal density.

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## Product Info on ROHACELL® RIMA

ROHACELL® RIMA (**R**esin **I**nfusion for **M**inimized surface resin **A**bsorption) is a closed-cell rigid foam plastic, based on PMI (polymethacrylimide) chemistry, which does not contain any CFC's.

ROHACELL® RIMA is designed to combine the excellent mechanical and thermomechanical properties of ROHACELL® WF with virtually zero resin absorption, particularly suitable for the resin infusion process.

For processing up to temperature of 130°C (266°F) and maximum pressure up to 0,7 MPa (100 PSI).

ROHACELL® RIMA-HT (heat treated) can be processed up to temperature of 180°C (356°F) and maximum pressure up to 0,7 MPa (100 PSI).

The core can be net-shaped by thermoforming and/or machining to perfectly fit the cavity of RTM tooling.

Of course ROHACELL® RIMA is also very suitable for vacuum processes such as VARTM and SCRIMP.

The thermoformability of ROHACELL® provides a tremendous manufacturing advantage.

The thermo-elastic properties make this unique to ROHACELL® .

ROHACELL® RIMA is easy to shape and machine.

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## Product Info on ROHACELL® RIST

ROHACELL® RIST (Resin Infusion for Structural applications) is a closed-cell rigid foam plastic, based on PMI (polymethacrylimide) chemistry, which does not contain any CFC's.

ROHACELL® RIST is designed to combine the excellent mechanical and thermomechanical properties of ROHACELL® WF with a 50% less surface resin absorption, particularly suitable for the resin infusion process.

For processing up to temperature of 130°C (266°F) and maximum pressure up to 0,7 MPa (100 PSI).

ROHACELL® RIST-HT (heat treated) can be processed up to temperature of 180°C (356°F) and maximum pressure up to 0,7 MPa (100 PSI).

The core can be net-shaped by thermoforming and/or machining to perfectly fit the cavity of RTM tooling.

Of course ROHACELL® RIST is also very suitable for vacuum processes such as VARTM and SCRIMP.

The thermoformability of ROHACELL® provides a tremendous manufacturing advantage.

The thermo-elastic properties make this unique to ROHACELL®.

ROHACELL® RIST is easy to shape and machine.

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## Product Info on ROHACELL® S

ROHACELL® S is a closed-cell rigid foam plastic, based on PMI (polymethacrylimide) chemistry, which does not contain any CFC's.

The fields of application for ROHACELL® S include, but are not limited to; vehicle and aircraft applications.

Cure temperatures up to 130°C (266°F) and cure pressures up to 0.35 MPa (50 PSI) .

Sandwich structures using ROHACELL® S as a core material can be realized in a single work step (co-curing). By means of hand/wet lay up, VARTM, low pressure RTM, autoclave, SCRIMP, and others.

ROHACELL® is thermoformable, which is a big advantage over other core materials.

ROHACELL® S is easy to shape and machine.

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## Product Info on ROHACELL® S

ROHACELL® S meets following standards:

ASTM D 1692-59	“self-extinguishing”
AFNOR NF 16-101	“M1/F2” (ROHACELL® 51S)
	“M2/F3” (ROHACELL® 71S)
ASTM D 2863 (LOI)	“23.8%” (ROHACELL® 51S)
	“23.2%” (ROHACELL® 71S)
UL 94	“94V-2” (ROHACELL® 51S)

It can be ordered tested in accordance with following specifications:

<b>-FAR 25.853 (a)(1)(i)</b>	<b>AITM 2.0002 Small Burner Test vertical (60s)</b>
<b>-FAR 25.853 (a)(1)(ii)</b>	<b>AITM 2.0002 Small Burner Test vertical (12s)</b>
<b>-FAR 25.853 (a)(1)(iv)</b>	<b>AITM 2.0003 Small Burner Test horizontal (15s)</b>
<b>-FAR 25.853 (a)(1)(v)</b>	<b>AITM 2.0003 Small Burner Test horizontal (15s)</b>
<b>-FAR 25.853 (d)</b>	<b>AITM 2.0007 Determination of the specific optical moke density of aircraft interior materials</b>
	<b>AITM 3.0005 Determination of gas components of smoke, generated by aircraft interior materials</b>

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## Product Info on ROHACELL® WF

ROHACELL® WF (Grade with increased heat distortion resistance) is a closed-cell rigid foam based on PMI (polymethacrylimide) chemistry, which does not contain any CFC's.

ROHACELL® WF (dry condition) can be processed up to temperature of 130°C (266°F) and maximum pressure up to 0,7 MPa (100 PSI).

ROHACELL® WF-HT (heat treated) can be processed up to temperature of 180°C (356°F) and maximum pressure up to 0,7 MPa (100 PSI).

ROHACELL® WF is utilized in manufacturing advanced composite components such as; aircraft / spacecraft structures.

Structural components can be manufactured by the following cure methods; autoclave, vacuum bagged, RTM, VARTM, press and others.

The thermoformability of ROHACELL® provides a tremendous manufacturing advantage. The thermo-elastic properties make this unique to ROHACELL®.

ROHACELL® WF is easy to shape and machine.

® = registered trademark

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## Product Info on ROHACELL® XT

ROHACELL® XT (Extended Temperature) is a closed-cell rigid foam plastic, based on PMI (polymethacrylimide) chemistry, which does not contain any CFC's.

ROHACELL® XT serves as a core material in advanced BMI-sandwich parts used in aircraft, space components and other higher temperature structures.

ROHACELL® XT can be processed up to temperature of 180°C (356°F) and maximum pressure up to 0,45 MPa (65 PSI).

ROHACELL® XT-HT (heat treated) can be processed up to temperature of 190°C (374°F) and maximum pressure up to 0,7 MPa (100 PSI).

ROHACELL® XT-HT in a free standing process can be post cured up to temperature of 240°C (464°F).

Sandwich structures using ROHACELL® XT as core material can be realized in a single work step (co-curing). The structural can be manufactured in an autoclave, press, RTM, VARTM or other methods.

ROHACELL® is thermoformable, which is a big advantage over other core materials.

ROHACELL® XT is easy to shape and machine.

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