

## Product Information

## ROHACELL® WF/WF-HT

**STRUCTURAL FOAM FOR THE MOST DEMANDING MANUFACTURING PROCESS CONDITIONS**

ROHACELL® WF foam core has been specifically designed for the use in the aerospace industry.

Based on polymethacrylimide (PMI) chemistry, it is engineered to meet demanding requirements from aircraft manufacturers and has led to many specifications for more than 30 years, including MIL-PRF-46194A, WL 5.1460, WL 5.1461 and others.

**PROCESSING AND PRODUCTION**

ROHACELL® core makes it possible to produce sandwich components in a single process step (co-curing), resulting in reduced overall production time and reduced costs up to 25 % over other sandwich composites solutions.

ROHACELL® WF can take curing temperatures up to 130 °C (266°F) and pressures up to 0.7 MPa (102 psi). After a heat treatment (HT) process, ROHACELL® WF-HT can even be used at curing temperatures of 180 °C (356 °F) and at pressures of 0.7 MPa (102 psi).

ROHACELL® WF/ WF-HT is highly suitable with autoclave technologies and vacuum infusion processes, including RTM and VARTM.

**WEIGHT SAVINGS**

When building composite sandwich components, lightweight ROHACELL® WF/ WF-HT has a closed cell structure that ensures the resin stays exactly where you want it – in the interface between the core and face sheet. This eliminates excess and unnecessary resin that adds undesirable weight to the finished part.

Additionally, ROHACELL® WF/ WF-HT offers high thermal/mechanical properties in all three dimensions to be considered as isotropic behaviour, resulting in no need for any kind of potting or reinforcement in the area of load introductions and edges.

Overall, ROHACELL® can contribute to reducing the weight of the entire sandwich composite part by up to 20 % in comparison to other composite solutions.

**THERMOFORMING AND SHAPING**

ROHACELL® WF/ WF-HT can be easily thermoformed or CNC machined to meet customer requirements, bringing tremendous manufacturing advantages.

High precision, pre-shaped and ready-to-use foam cores in complex or simple geometries can also be directly supplied by the ROHACELL® Shapes Department.

Property	Test Method	Unit	51 WF	71 WF	110 WF	200 WF	300 WF*
Density	ISO 845	kg/m <sup>3</sup>	52 ± 12	75 ± 15	110 ± 21	205 ± 35	300 ± 60
	ASTM D 1622	lbs/ft <sup>3</sup>	3.25	4.68	6.87	12.81	18.7
Compressive Strength	ISO 844	MPa	0.6 (0.4)	1.3 (1.05)	3.1 (2.2)	9.0 (6.4)	17.8 (7.9)
	ASTM D 1621	psi	87 (58)	188 (152)	449 (319)	1305 (928)	2580 (1150)
Tensile Strength	ISO 527-2	MPa	1.6 (0.88)	2.2 (1.56)	3.7 (2.5)	6.8 (5.37)	12.0 (8.1)
	ASTM D 638	psi	232 (128)	319 (227)	536 (369)	986 (780)	1740 (1180)
Elastic Modulus	ISO 527-2	MPa	75 (45)	105 (75)	180 (135)	350 (270)	580 (300)
	ASTM D 638	ksi	10.9 (6.5)	15.2 (10.8)	26.1 (19.5)	50.8 (39.1)	84.1 (43.5)
Shear Strength	DIN 53294	MPa	0.8 (0.5)	1.3 (1.0)	2.2 (1.75)	5.0 (3.6)	8.3 (5.2)
	ASTM C 273	psi	116 (72)	188 (145)	348 (253)	725 (426)	1203 (760)
Shear Modulus	DIN 53294	MPa	20 (14)	34 (24.1)	60 (40)	120 (100)	360 (200)
	ASTM C 273	ksi	2.9 (2.0)	4.9 (3.5)	8.7 (5.8)	17.4 (14.5)	52.2 (19.0)
Strain at Break	ISO 527-2 ASTM D 638	%	3.0	3.0	2.5	3.0	2.8
Coefficient of Thermal Expansion		1/K*10E-5	3.1	3.1	3.1	3.8	3.5
Compressive Creep Resistance ≤ 4 % for Non-HT Material	Temperature	°C	130	130	130	130	130
	Pressure	MPa	0.2	0.3	0.4	0.7	0.7
	Time	h	2	2	4	2	2
Compressive Creep Resistance ≤ 4 % for HT Material	Temperature	°C	180	180	190	180	180
	Pressure	MPa	0.25	0.5	0.7	0.7	0.7
	Time	h	2	2	4	2	2

Technical data of our products are typical values for nominal density and minimum values in ().  
**\*300 WF is only available in Americas region.**

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#### Evonik Operations GmbH

High Performance Polymers  
 Performance Foams  
 64293 Darmstadt, Germany  
 Phone +49 6151 18-1005

#### Evonik Corporation

Theodore, Alabama USA  
 Phone +1 866 764-6235

#### Evonik Specialty Chemicals (Shanghai) Co., Ltd.

Shanghai, China  
 Phone +86 21 6119 3788