



**NATIONAL  
AEROSPACE  
LABORATORIES**

Class : Restricted

No. of Copies : 3

**Title :** Post curing of Hansa-3 (VT- HNW) Components.

**Author / s :** M. Rajendra Prakash, K. Mohan Kumar, R.Pasupathi,  
RMVGK Rao

**Division :** FRP Division.

**NAL Project No. :** ---

**Document No. :** PDRP0308

**Date of Issue :** May 2003

<i>Contents</i>	1	<i>Pages</i>	10	<i>Figures</i>	3	<i>Tables</i>	1	<i>Annexures: ---</i>
-----------------	---	--------------	----	----------------	---	---------------	---	-----------------------

**External Participation :** Nil

**Sponsor :** ----

**Approval:** Head, FRP Division

**Remarks :** --

**Keywords:** Post cure, Large post cure oven,  $T_g$ , Travel coupon.

**Abstract:**

This report contains the details of post curing of Hansa-3 (VT- HNW) all composite airframe components provided by C-CADD, carried out using an in-house designed and fabricated large hot air oven (17mts × 2.0mts × 2.0mts). It details an optimum post cure cycle implemented, the temperature accuracy's, the various innovative approaches adapted to ensure the safety of the full scale components undergoing post cure in the oven.

All the Hansa-3 (VT-HNW) airframe composite components post cured as per the standard optimum post cure cycle and the oven temperature monitored throughout around  $\pm 3^\circ\text{C}$  to ensure uniform post curing of components