

Y. K. Hamidi<sup>1,2\*</sup>, M. C. Altan<sup>1</sup>

<sup>1</sup>School of Aerospace and Mechanical Engineering, University of Oklahoma, Norman, OK, USA

<sup>2</sup>Ecole Nationale Supérieure des Mines de Rabat, Rabat, Morocco

# Process Induced Defects in Liquid Molding Processes of Composites

*Liquid Composite Molding (LCM) processes are cost efficient manufacturing alternatives to traditional autoclave technology for producing near-net shape structural composite parts. However, process induced defects often limit wider usage of LCM in structural applications. Thorough knowledge of these defects, as well as their formation mechanisms and prevention techniques is essential in developing improved LCM processes. In this article, process induced defects in liquid molding processes of composites, categorized into preform, flow induced and cure induced defects, are reviewed. Preform defects are further presented as fiber misalignment and fiber undulation (waviness and wrinkling). The respective causes, detrimental effects, and possible prevention methods of these defects are presented. Thereafter, flow induced defects are classified as voids and dry spots. Dry spot formation mechanisms in LCM processes and available prevention techniques are summarized. In addition, void formation mechanisms, adverse effects on composite properties, and removal techniques are presented. Cure induced defects include microcracks, void growth and geometrical distortions (warpage and spring-in). Each of these defects are discussed along with their underlying causes as well as their control and reduction schemes.*

## 1 Introduction

Advanced composites have been traditionally utilized as structural parts where high performance is essential at reduced weight, such as aeronautical, aerospace and defense applications (Carlone and Palazzo, 2015; Costa et al., 2006; Muric-Nesic et al., 2009; Villière et al., 2015). Following the success of such applications, there has been increased interest in using advanced composites for higher production rate and cost sensitive fields such as automotive, marine and wind energy applications, among others (Altmann et al., 2016; Gourichon et al., 2006; Kedari et al., 2011; Wang et al., 2013). In this context, significant attention has been placed on developing lower-cost, higher performance Liquid Composite Molding (LCM) processes that can produce medium to large composites structures.

\* Mail address: Youssef K. Hamidi, Ecole Nationale Supérieure des Mines de Rabat, Avenue Hadj Ahmed Cherkaoui, B.P. 753 Agdal, Rabat, Morocco  
E-mail: hamidi@ou.edu

In addition to being less expensive, LCM processes offer major advantages over autoclave processing which primarily uses prepregs or wet lay-ups. These advantages include high attainable fiber volume fraction, ability to produce complex near-net-shape parts, relatively short cycle times, and low labor requirements (Gourichon et al., 2006; Kaynak et al., 2008; Yang et al., 2010).

During initial development of LCM processes, their limited application in the production of structural components was associated to the low degree of process automation, thus resulting in large variations of material properties and low productivity (Kaynak et al., 2008; Yang et al., 2010). Recently, significant developments of robotized preform placement allowed LCM processes to be more competitive (Fedulov et al., 2015; Heuer et al., 2015; Lukaszewicz et al., 2012). Currently, LCM variants, such as Resin Transfer Molding (RTM) and Vacuum Assisted Resin Transfer Molding (VARTM), are increasingly used to fabricate structural parts in a wide variety of industrial applications.

A typical LCM process can be divided into several steps. First, the dry fiber reinforcement, often referred to as preform, is cut to size and placed into a mold cavity. After the mold is closed, the reacting resin is either injected under positive pressure or pulled in the mold cavity due to the applied vacuum. In both cases, the resin impregnates the dry fibrous network by displacing the air initially present in the preform pores. After the preform is impregnated, matrix crosslinking and complete cure are achieved within minutes or hours, depending on the cure kinetics of the resin and the temperature profile used. During LCM, various process parameters affect the quality of resulting composite parts, such as fiber volume fraction, resin injection pressure/applied vacuum level, fiber architecture, location of injection and ventilation gates, resin viscosity, and molding temperature (Gourichon et al., 2006; Kaynak et al., 2008; Yang et al., 2010).

One remaining key challenge that limits a wider usage of LCM is the presence of process induced defects. LCM processes, like any other composite manufacturing technique, are associated with a number of specific defects. LCM induced defects can be grouped into three main types: (i) preform defects, (ii) flow induced defects, and (iii) cure induced defects. Preform defects often refer to the deformation of fiber tows and preforms that are supposed to be spatially uniform, straight and properly aligned in the composite. On the other hand, flow induced defects are flaws caused by the resin flow during im-

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*Date received: February 15, 2017*

*Date accepted: June 21, 2017*

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DOI 10.3139/217.3444  
Intern. Polymer Processing  
XXXII (2017) 5; page 1–18  
© Carl Hanser Verlag GmbH & Co. KG  
ISSN 0930-777X