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(54) Titre : STRUCTURES COMPOSITES UTILISANT DES ADHESIFS DE RESEAU DE POLYMERES IMBRIQUES

(54) Title: COMPOSITE STRUCTURES USING INTERPENETRATING POLYMER NETWORK ADHESIVES

(57) **Abrégé/Abstract:**

A composition is provided that consists essentially of a first polymer system and a second polymer system. The first polymer system has a first modulus of about 180 ksi to about 335 ksi. The first polymer system consists essentially of a thermosetting acrylate. The second polymer system consists essentially of a thermosetting epoxy system and an epoxy curing agent. The thermosetting epoxy system comprises a first epoxy.



ABSTRACT OF THE DISCLOSURE

A composition is provided that consists essentially of a first polymer system and a second polymer system. The first polymer system has a first modulus of
5 about **180** ksi to about **335** ksi. The first polymer system consists essentially of a thermosetting acrylate. The second polymer system consists essentially of a thermosetting epoxy system and an epoxy curing agent. The thermosetting epoxy system comprises a first epoxy.

COMPOSITE STRUCTURES USING INTERPENETRATING POLYMER NETWORK ADHESIVES

TECHNICAL FIELD

5 This disclosure generally relates to composite structures, and deals more particularly with adhesives used in such composites.

BACKGROUND

10 Composite structures comprising parts that have different coefficients of thermal expansion may induce residual stresses in the structure during thermal curing or other fabrication processes that cause the parts to thermally expand at different rates. For example, and without limitation, hybrid composite structures comprising a metal reinforced with carbon fiber polymers may be subject to thermal induced distortion while curing at elevated temperatures. In some cases, this
15 problem may be addressed by using fiber reinforced polymers that cure at room temperature, or which may be cured using various forms of radiation. However, room temperature cure polymers may have a short working life, long cure times, and require extra clean-up work. Room temperature cure polymers may also exhibit reduced performance characteristics compared to polymers that are cured at
20 elevated temperatures. Known radiation cured adhesives may be more brittle than desired and exhibit lower than desired toughness, which may render these adhesives unsuitable for some applications, particularly where resistance to impact loads is valued.

25 Interpenetrating polymer networks (IPN) have been used as an adhesive in composite structures. IPNs are based on polymer systems that cure at different temperatures using differing cure mechanisms, but may exhibit properties that are superior to those of their constituent polymer systems. However, IPNs have not

been adapted for solving the problem of residual stresses that are induced in composites by the differential expansion of the components of which the composite is formed.

Accordingly, there is a need for an IPN adhesive that may be used to reduce or eliminate residual stresses in composite structures that may be caused by differential expansion of differing components used in the structure, such as metals reinforced with carbon fiber polymers. There is also a need for a method of making composite structures that employ IPN adhesives to reduce or eliminate the residual stresses.

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SUMMARY

In one illustrative embodiment, a composition is presented. The composition consists essentially of a first polymer system and a second polymer system. The first polymer system has a first modulus of about **180** ksi to about **335** ksi. The first polymer system consists essentially of a thermosetting acrylate. The second polymer system consists essentially of a thermosetting epoxy system and an epoxy curing agent. The thermosetting epoxy system comprises a first epoxy.

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In another illustrative embodiment, a composition is present. The composition consists essentially of a first polymer system and a second polymer system. The first polymer system has a first modulus of about **180** ksi to about **335** ksi. The first polymer system consists essentially of a thermosetting acrylate and a trifunctional acrylate. The second polymer system consists essentially of a thermosetting epoxy system and an epoxy curing agent. The thermosetting epoxy system comprises a first epoxy.

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The features, functions, and advantages can be achieved independently in various embodiments of the present disclosure or may be combined in yet other embodiments in which further details can be seen with reference to the following description and drawings.

25

BRIEF DESCRIPTION OF THE ILLUSTRATIONS

The novel features believed characteristic of the illustrative embodiments are set forth in the appended claims. The illustrative embodiments, however, as well as a preferred mode of use, further objectives and advantages thereof, will best be understood by reference to the following detailed description of an illustrative embodiment of the present disclosure when read in conjunction with the accompanying drawings, wherein:

Figure 1 is an illustration of a functional block diagram of an IPN adhesive according to the disclosed embodiments.

Figure 2 is an illustration of the IPN adhesive of Figure 1, showing a bi-continuous structure formed by dual polymer adhesive systems.

Figure 3 is a sectional view of a hybrid composite structure, in which the parts are bonded together using the IPN adhesive.

Figure 4 is an illustration of a flow diagram of a method of bonding two parts of Figure 3 together using the IPN adhesive.

Figure 5 is an illustration of a sectional view of two co-cured composite laminates joined together by a layer of the IPN adhesive.

Figure 6 is an illustration of the area designated as Figure 6 in Figure 5.

Figure 7 is an illustration of a flow diagram of a method of fabricating the composite structure shown in Figures 5 and 6.

Figure 8 is an illustration of a fiber embedded in an IPN adhesive matrix in which a gradient interface has been formed around the fiber.

Figure 9 is an illustration of a graphical plot of stress-strain performance of the polymer systems used in a disclosed IPN adhesive.

Figure 10 is an illustration of a manufacturing environment in the form of a block diagram in accordance with an illustrative embodiment.

Figure **11** is an illustration of a graphical plot of compressive yield strength versus first polymer system content of an interpenetrating polymer network in accordance with illustrative embodiments.

Figure **12** is an illustration of a graphical plot of tensile strength versus first
5 polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments.

Figure **13** is an illustration of a graphical plot of fracture toughness versus first polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments.

10 Figure **14** is an illustration of a graphical plot of tensile strength and fracture toughness versus first polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments.

Figure **15** is an illustration of a graphical plot of degree of monomer conversion versus first polymer system content of interpenetrating polymer networks
15 in accordance with illustrative embodiments.

Figure **16** is an illustration of a graphical plot of loss modulus versus temperature of interpenetrating polymer networks in accordance with illustrative embodiments.

Figure **17** is an illustration of a graphical plot of density versus first polymer
20 system content of interpenetrating polymer networks in accordance with illustrative embodiments.

Figure **18** is an illustration of a graphical plot of an interpenetrating polymer network in contrast to its constituents.

Figure **19** is a flow diagram of aircraft production and service methodology in
25 which an illustrative embodiment may be implemented.

Figure **20** is a block diagram of an aircraft in accordance with an illustrative embodiment.

DETAILED DESCRIPTION

Illustrative examples provide an IPN adhesive that can be used to fabricate composite structures, and particularly hybrid structures employing both polymer resins and metals that may substantially reduce residual stresses in the structure caused by differential thermal expansion of the composite materials. The disclosed IPN adhesive comprises two polymer adhesive systems that may be cured at differing temperatures. One of the polymer systems may be cured at room temperature using a beam of radiation, such as an electron beam. Curing of the first polymer system at room temperature holds the composite parts together so that they are fixed relative to each other as the structure is being fully cured. Curing of the second polymer adhesive is achieved by thermal cycling at elevated temperatures. The second polymer adhesive, when cured, remains flexible which may renders the composite structure more tolerant of impact loads, and less susceptible to barely visible impact damage (BVID).

In addition to increasing strength and durability, use of the disclosed IPN adhesive may result in weight savings by providing an effective way to reinforce metal parts such as aluminum, and may reduce tooling costs complexity while reducing process flow times.

The illustrative examples recognize and take into account that previous attempts to increase a composite strength utilized a polyepoxide network such as diglycidyl ether of bisphenol A (DGEBA). In these previous attempts, toughness was developed through the incorporation of thermoplastic tougheners. Specifically, in some previous attempts, the thermoplastic tougheners were incorporated in the ratio of about **20** to about **40** parts per hundred epoxide. By using thermoplastic tougheners, the resulting epoxy network of previous attempts is toughened due to the presence of cure-induced phase separation of thermoplastic particles. The illustrative examples herein recognize and take into account that it may be desirable

to increase the toughness of an epoxy network without the use of thermoplastic tougheners.

The illustrative embodiments also recognize and take into account that creating an interpenetrating polymer network (IPN) uses two or more polymer components that have differing chemical properties. The result of incorporating two or more polymer components into an IPN results in an IPN with properties that vary significantly from those of the individual polymer components. For example, the illustrative embodiments recognize and take into account that polymer performance properties may be linked to the glass transition temperature, T_g . The individual components of an IPN typically have different, distinct glass transition temperatures. However, fully interpenetrating IPNs exhibit a single, broadened glass transition temperature.

A sequential IPN is an IPN which is formed by first curing a first polymer system and later curing a second polymer system. The illustrative embodiments further recognize and take into account that when a sequential IPN is created, the polymer system which cures first establishes the strength of the IPN. The second polymer system remains highly deformable. Accordingly, the monomer for the second polymer network may be rearranged to decrease the inner stresses in the forming IPN. Due to restrictions imposed by the cured first polymer system, the second polymer network cures at a low rate, reducing internal stresses. The illustrative embodiments thus take into account that the polymer system which cures second, therefore, plays the role of "plasticizer." A plasticizer may be a material which provides increased flexibility to a composition. Further, a plasticizer may increase the durability of a composition.

Referring first to Figure 1, the disclosed embodiments relate to a full-interpenetrating network (IPN) adhesive **16** which may be used as a bonding adhesive or as a matrix in composite structures. The IPN adhesive **16** broadly comprises a first polymer system **18** and a second flexible polymer system **20**. The first polymer system **18** may be cured at or near room temperature using a beam

(not shown) of radiation, such as an electron beam, however other forms of radiation including but not limited to UV (ultra violet) and X-ray radiation may be employed. The second polymer system **20** exhibits flexibility and toughness following curing, which is performed at elevated temperature during a suitable thermal cure cycle. As
5 will be described below in more detail, the first polymer system **18** is cured at or near room temperature during the fabrication process to adhesively bond and effectively lock two or more parts (not shown) together. The adhesive bond formed between the parts by the first polymer system **18** holds the parts in place and prevents them from differentially expanding while the second polymer system **20** is thermally
10 curing. Locking the parts together in this manner may reduce or eliminate the possibility of distortion of the parts during the fabrication process. The flexible second polymer system **20** provides the bond with both flexibility and toughness.

The first polymer system **18** may comprise an acrylated polymer such as acrylated epoxy. For example and without limitation, the acrylated epoxy may
15 comprise one of bisphenol A diacrylate (BPADA) with a trifunctional acrylate, and trimethylolpropane triacrylate (TMPTA) cross-linking agent. The second flexible polymer system **20** may be one selected from the group consisting of flexible epoxies and vinyl esters. For example and without limitation, the second flexible polymer system may be one of Bis(3,4-EpoxyCyclohexylmethyl) Adipate (BECA)
20 and the combination of a Diglycidyl ether of bisphenol A (DGEBA) with a Polypropylene Glycol Diglycidyl Ether (PPGDE) chain extender with an imidazole such as 2-Ethyl 4-Methylimidazole (EMI) or an anhydride as the curing catalyst.

Although not shown in the Figures, the second flexible polymer system **20** may include a suitable thermal cure initiator, such as, without limitation, imidazole or
25 anhydride for cross linking the second polymer system **20**. In one practical embodiment, the IPN adhesive **16** comprises about **67** percent acrylate and **33** percent flexible epoxy (including the curing agent). In another practical embodiment, the IPN adhesive **16** comprises about **40** percent acrylate, and about **60** percent flexible epoxy.

Figure 2 illustrates the IPN adhesive 16 in a fully cured state in which the two polymer systems 18, 20 respectively form bi-continuous structural networks 22, 24 that are intertwined to form what is sometimes referred to as a double gyroidal structure. The structural network 22 formed by the first polymer system 18 may function as a relatively high strength adhesive to bond parts together, but which may exhibit some degree of brittleness. The second structural network 24 formed by the second polymer system 20 is relatively flexible, providing the IPN adhesive 16 with resistance to impact loading.

Figure 3 illustrates a hybrid composite structure 25 comprising two parts 26, 28 which may respectively comprise for example and without limitation, a composite laminate, and a metal. The two parts 26, 28 may be bonded together using a layer 27 of the IPN adhesive 16. Referring also now to Figure 4, the hybrid composite structure 25 may be fabricated by a method that begins at step 30 in which the parts 26, 28 are placed together with the layer 27 of the IPN adhesive 16 therebetween.

Next, at step 32, the parts 26, 28 are bonded together by curing the first polymer system 18 (Figure 1) using a beam 45 of radiation (Figure 5) that is directed onto the structure 25 from a suitable radiation source 47. The curing process performed at step 32 may be carried out at or near room temperature, consequently the parts 26, 28 are initially bonded together without differential expansion that may be caused by curing at elevated temperatures. Finally, at step 34, the second polymer system 20 is thermally cured by subjecting the assembled composite structure 25 to a thermal cure cycle at elevated temperatures. During this thermal curing, differential thermal expansion of the parts 26, 28 is substantially reduced or eliminated due to the fact that the parts 26, 28 have already been bonded together, and thus are fixed relative to each other by the first polymer system.

FIGS. 5 and 6 illustrate another application of the IPN adhesive 16 (Figure 1). In this example, two multi-ply, fiber reinforced laminates 36, 38 are joined together by a layer 40 of a flexible polymer adhesive such as a flexible epoxy to form a composite structure 35. As shown in Figure 6, each of the laminates 36, 38

comprises a fiber reinforcement **41** held and embedded in a matrix comprising the IPN adhesive **16** described previously. Thus, each of the laminates **36**, **38** comprises bi-continuous first and second polymer systems **18**, **20** as described above in connection with FIGS. **1** and **2**, while the layer **40** comprises a thermally curable, flexible polymer such as a flexible epoxy which may be substantially the same as the second flexible polymer system **20** forming part of the IPN adhesive matrix **16**. As will be discussed below, when the composite structure **35** is fully cured, the second flexible polymer system **20** (Figure **1**) extends continuously from one laminate **36** through bond layer **40** to the other laminate **38**.

Figure **7** illustrates a method of fabricating the composite structure **35** shown in FIGS. **5** and **6**. Beginning at **44**, first and second laminates **36**, **38** are formed by laying up plies (not shown) of prepreg (not shown) using conventional processes and tooling suitable for the application. IPN adhesive **16** comprising the two unreacted, bi-continuous polymer systems **18**, **20** (Figure **1**) is used as the ply matrix into which the fiber reinforcement **41** is embedded. Next, at step **46**, each of the laminates **36**, **38** is cured to at least a stage that allows the laminates to be handled by directing a beam **45** of radiation produced by a suitable radiation source **47** onto each of the laminates **36**, **38**. The radiation beam **45** may comprise an electron beam (EB), a UV beam or a beam of X-rays, or any other suitable radiation beam. This radiation beam curing, which may be carried out at or near room temperature, results in curing of the first polymer system **18** which forms one component of the ply matrix, and cross linking, shown by the numeral **42** in Figure **6**, of the first polymer system **18**.

At this point, the second flexible polymer system **20** remains unreacted, however the curing of the first polymer system **18** stiffens the laminate **36**, **38** to at least a stage allowing them to be handled as necessary for further processing. In fact, the following the room temperature curing, the laminates **36**, **38** may have nearly as much rigidity as fully cured laminates, consequently, when placed together under pressure in tooling (not shown), the laminates **36**, **38** may exhibit little or no

deformation. At step **48**, the laminates **36**, **38** are assembled together using a bond layer **40** of a flexible, thermally curable polymer that may be substantially the same as that comprising the second flexible polymer system **20** forming part of the IPN adhesive **16**. With the laminates **36**, **38** having been assembled, then at step **50**, the
5 second flexible polymer system **20** along with the bond layer **40** are co-cured by subjecting the assembled laminates **36**, **38** to a thermal cure cycle. It should be noted here that when imidazol is used as a curing agent, it results in a **2**-step curing process. The first step is an epoxy adduct stage where the imidazole molecules simply attach themselves to the ends of epoxy molecules; this occurs at about **60**
10 degrees C and results in a significant increase in viscosity. The second step to the curing process is cross-linking of epoxies and epoxy adducts which occurs at about **160** degrees C.

Figure **8** illustrates the use of the previously described IPN adhesive **16** as a matrix for holding a reinforcement **54** which may comprise fibers, beads, particles or
15 other reinforcing media. As in previous examples, the IPN adhesive **16** comprises first and second polymer systems **18**, **20** (Figure **1**) which are respectively curable at differing temperatures. The second flexible polymer system **20** (Figure **1**) which may comprise a flexible epoxy, has a higher surface tension than the first polymer system **18** which may comprise an acrylated epoxy. This higher surface tension causes the
20 second flexible polymer system **20** to preferentially attach to the reinforcement **54**, resulting in a gradient interface **56** around the reinforcement **54** that is somewhat flexible. The flexibility provided by the gradient layer **56** may assist in better transferring shear forces from the reinforcement **54** to the IPN adhesive matrix **16**. Also, the gradient layer **56** may aid in establishing an improved bond between the
25 IPN adhesive matrix **16** and the reinforcement **54**. For example, where the IPN adhesive matrix **16** includes an acrylate that may not bond well to reinforcement **54** that is a carbon fiber, the flexible material forming the gradient layer **56** may improve the bond between the adhesive matrix **16** and the carbon fiber **54**.

Use of the IPN **16** resulting in the formation of the gradient layer **56** may be employed in fabricating filament wound products (not shown). At the conclusion of wet filament winding or an RTM (resin transfer molding) process, an electron beam head (not shown) can be swept over the part to provide the initial cure. The entire
5 structure will be dimensionally locked by this room temperature curing step, which may avoid the need for expensive tooling or autoclaves for the secondary thermal cure cycle.

Attention is now directed to Figure **9** which is a stress-strain performance plot that illustrates the improved performance provided by the systems **18**, **20** forming
10 the disclosed IPN adhesive **16**. Curve **62** shows the performance of a flexible epoxy comprising a **50/50** mixture of two typical flexible epoxy components, while curve **64** shows the performance of a typical acrylate that includes **20** percent a content of a trifunctional acrylate. Curve **66** represents the performance of the disclosed IPN adhesive **16**, which in this example, comprises a **50/50** combination of the flexible
15 epoxy mixture represented by curve **62** and the acrylate mixture represented by curve **64**.

Rather than lying half way between the curves, **62**, **64**, as might be normally expected, the performance of the dual system IPN **16** shown by curve **66** indicates that the IPN **16** has a modulus that approaches that of the stiffer acrylate (curve **64**),
20 and an elongation that approaches that of the flexible epoxy (curve **62**). Thus, the first polymer system **18** (Figure **1**) provides the strength necessary for holding parts together but may have limited ability to deform upon an impact load, while the second flexible polymer system **20** provides the IPN **16** with the flexibility required to withstand impact loads. The second flexible polymer system **20** effectively allows
25 the first polymer system **18** to move around and flex.

Figure **10** is an illustration of a manufacturing environment in the form of a block diagram in accordance with an illustrative embodiment. In this illustrative example, manufacturing environment **1000** may be used to form interpenetrating polymer network adhesive **1002**.

As depicted, interpenetrating polymer network adhesive **1002** comprises first polymer system **1004** and second polymer system **1006**. First polymer system **1004** may be first polymer system **18** of Figure 1. Second polymer system **1006** may be second flexible polymer system **20** of Figure 1.

5 Interpenetrating polymer network adhesive **1002** may comprise a variety of different percentages of first polymer system **1004** and second polymer system **1006**. In various illustrative examples, interpenetrating polymer network (IPN) adhesive **1002** may comprise about **10** weight percent, about **20** weight percent, about **30** weight percent, about **38** weight percent, about **40** weight percent, about
10 **48** weight percent, about **50** weight percent, about **58** weight percent, about **60** weight percent, about **65** weight percent, about **70** weight percent, about **75** weight percent, about **80** weight percent, and about **90** weight percent of first polymer system **1004**. Although a number of illustrative examples have been presented, these are non-limiting.

15 As depicted, first polymer system **1004** comprises thermosetting acrylate **1008** and trifunctional acrylate **1010**. As depicted, both thermosetting acrylate **1008** and trifunctional acrylate **1010** are dashed. Both thermosetting acrylate **1008** and trifunctional acrylate **1010** are dashed as first polymer system **1004** comprises at least one of thermosetting acrylate **1008** and trifunctional acrylate **1010**.

20 Thermosetting acrylate **1008** comprises an acrylate material which hardens when heated. An acrylate material comprises a vinyl group attached to a carbonyl carbon. Trifunctional acrylate **1010** comprises a monomer having three acrylate groups. A monomer having three acrylate groups has three vinyl groups, each attached to a respective carbonyl carbon.

25 First polymer system **1004** may be selected to provide modulus **1012**. In some illustrative examples, modulus **1012** may be about **180** ksi (kilopounds per square inch) to about **335** ksi. Modulus **1012** is a modulus after cure of first polymer system **1004**.

In one illustrative example, first polymer system **1004** comprises bisphenol a diacrylate **1014**, and has modulus **1012** of about **312** ksi. In another illustrative example, first polymer system **1004** comprises **80** weight percent bisphenol a diacrylate **1014** and **20** weight percent trimethylolpropane triacrylate **1026**, and has
 5 modulus **1012** of about **287** ksi. In yet another illustrative example, first polymer system **1004** comprises **60** weight percent bisphenol a diacrylate **1014** and **40** weight percent trimethylolpropane triacrylate **1026**, and has modulus **1012** of about **333** ksi.

The phrase “at least one of,” when used with a list of items, means different
 10 combinations of one or more of the listed items may be used or only one item in the list may be needed. For example, “at least one of item A, item B, or item C” may include, without limitation, only item A, item A and item B, or item B alone. This example also may include item A, item B, and item C or item B and item C. Of course, any combinations of these items may be present. In other examples, “at
 15 least one of” may be, for example, without limitation, two of item A, one of item B, and ten of item C; four of item B and seven of item C; and other suitable combinations. The item may be a particular object, thing, or a category. In other words, “at least one of” means any combination of items and/or number of items may be used from the list but not all of the items in the list are required.

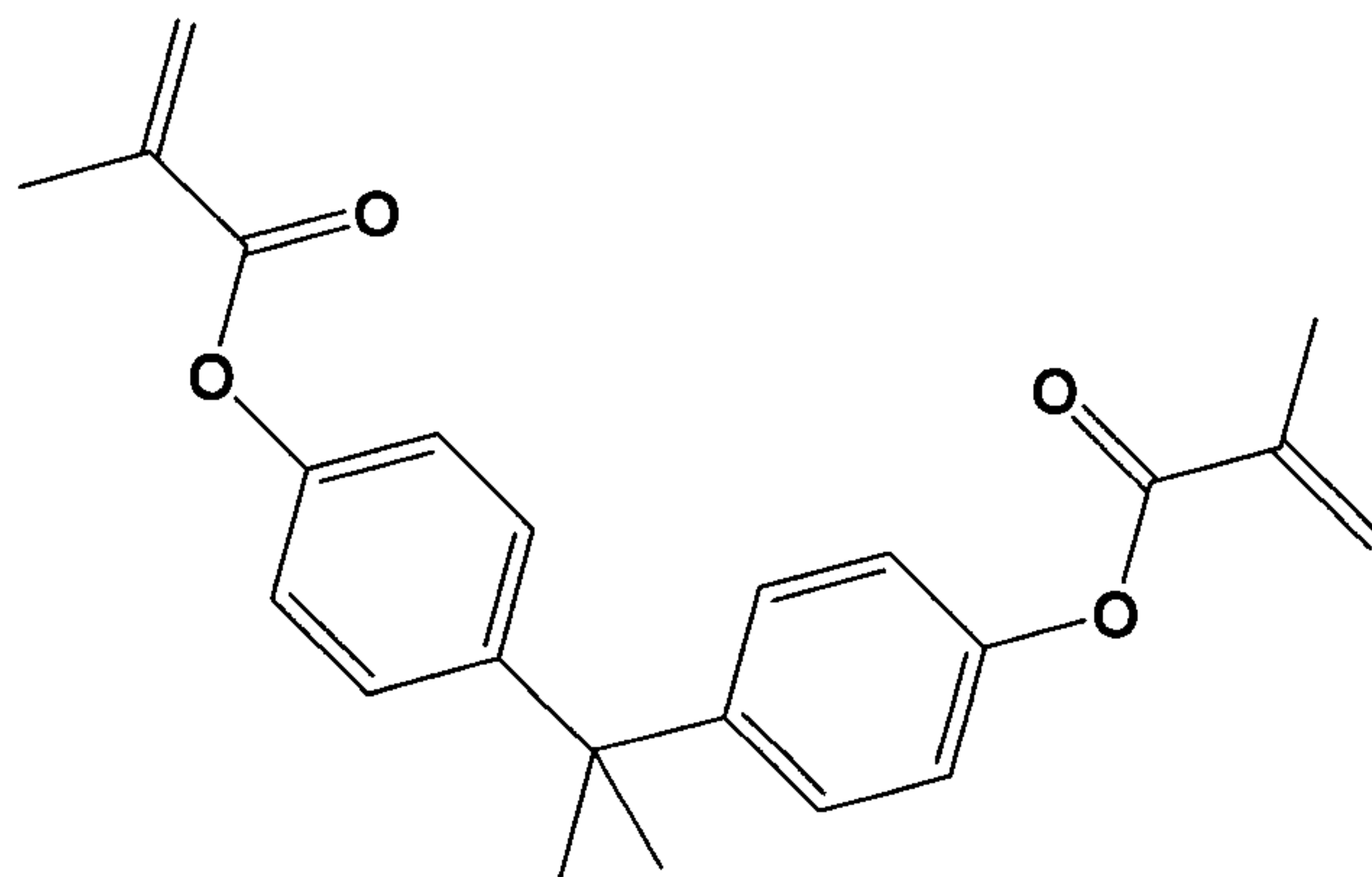
20 In some illustrative examples, first polymer system **1004** only has thermosetting acrylate **1008**. In some illustrative examples, first polymer system **1004** only has trifunctional acrylate **1010**. In other illustrative examples, first polymer system **1004** has both thermosetting acrylate **1008** and trifunctional acrylate **1010**. First polymer system **1004** may be selected such that initiator molecules are not required for
 25 curing of first polymer system **1004** using a radiation source such as radiation source **47** of Figure 3.

When first polymer system **1004** comprises both thermosetting acrylate **1008** and trifunctional acrylate **1010**, first polymer system **1004** may comprise different percentages of thermosetting acrylate **1008** and trifunctional acrylate **1010**. In one

illustrative example, first polymer system **1004** comprises about **80** weight percent thermosetting acrylate **1008** and about **20** weight percent trifunctional acrylate **1010**. In other illustrative examples, first polymer system **1004** comprises about **60** weight percent thermosetting acrylate **1008** and about **40** weight percent trifunctional acrylate **1010**. In other words, first polymer system **1004** comprises a ratio of the thermosetting acrylate to the trifunctional acrylate which is about **3:2** by weight.

Thermosetting acrylate **1008** is selected to provide properties **1013**. Properties **1013** of thermosetting acrylate **1008** may include at least one of yield strength, glass transition temperature, miscibility parameter compared to second polymer system **1006**, chemical structure, and modulus. Properties **1013** may be selected to provide desirable properties to resultant interpenetrating polymer network adhesive **1002**. In some illustrative examples, thermosetting acrylate **1008** may be bisphenol a diacrylate **1014**.

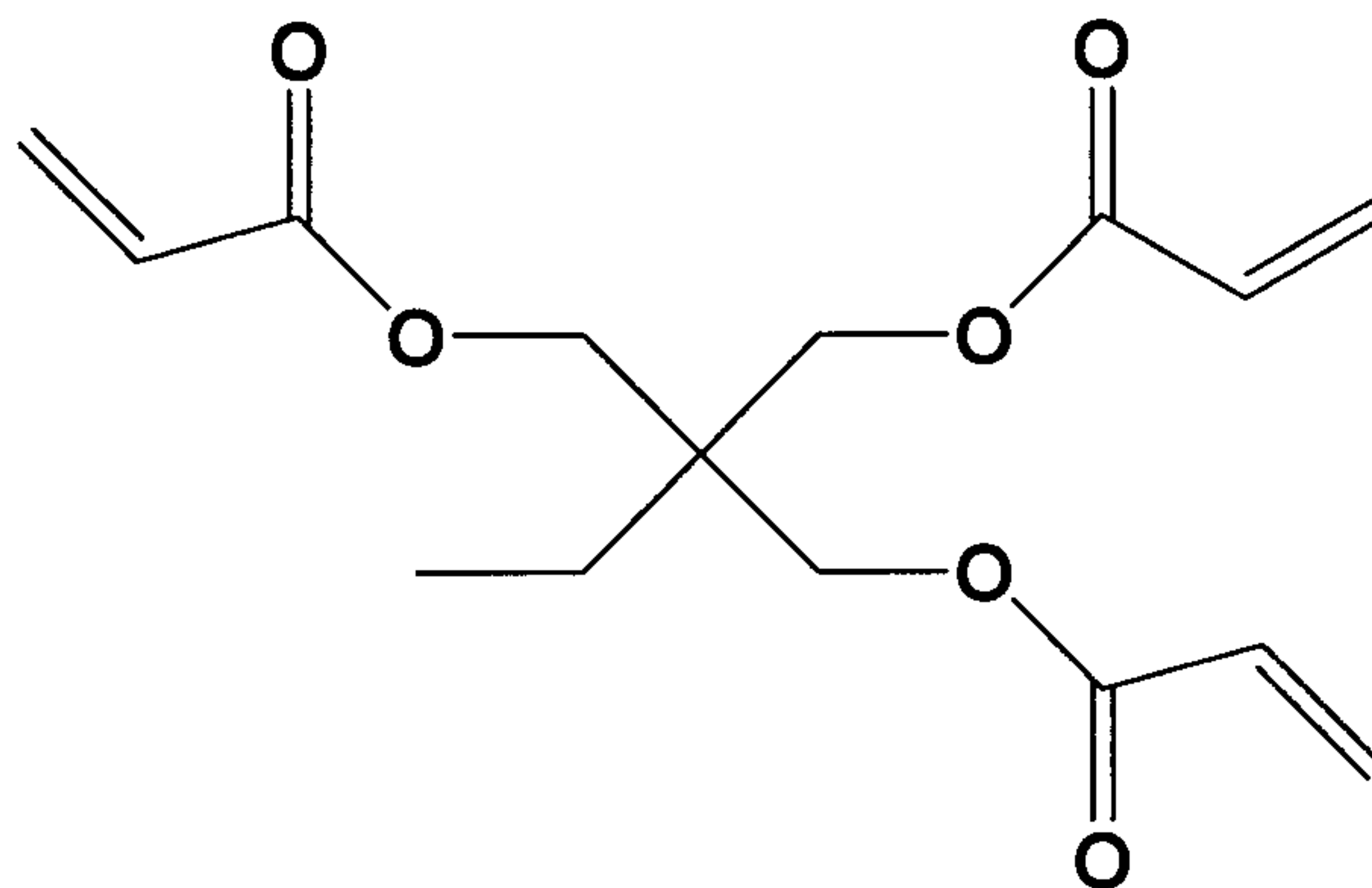
Bisphenol a diacrylate **1014** may be denoted chemically as



One illustrative example of commercially available bisphenol a diacrylate **1014** is cytec ebecryl® **600 1018**. Bisphenol a diacrylate **1014** may be obtained from other manufacturers and under other marketed product names.

Trifunctional acrylate **1010** may be selected to provide desirable properties to interpenetrating polymer network adhesive **1002**. In some illustrative examples, trifunctional acrylate **1010** may be selected to modify a miscibility mismatch between thermosetting acrylate **1008** and second polymer system **1006**. In some illustrative

examples, trifunctional acrylate **1010** may be selected to modify the viscosity of the uncured mixture of first polymer system **1004** and second polymer system **1006**. In one illustrative example, trifunctional acrylate **1010** may be trimethylolpropane triacrylate **1026**. Trimethylolpropane triacrylate **1026** may be denoted chemically as



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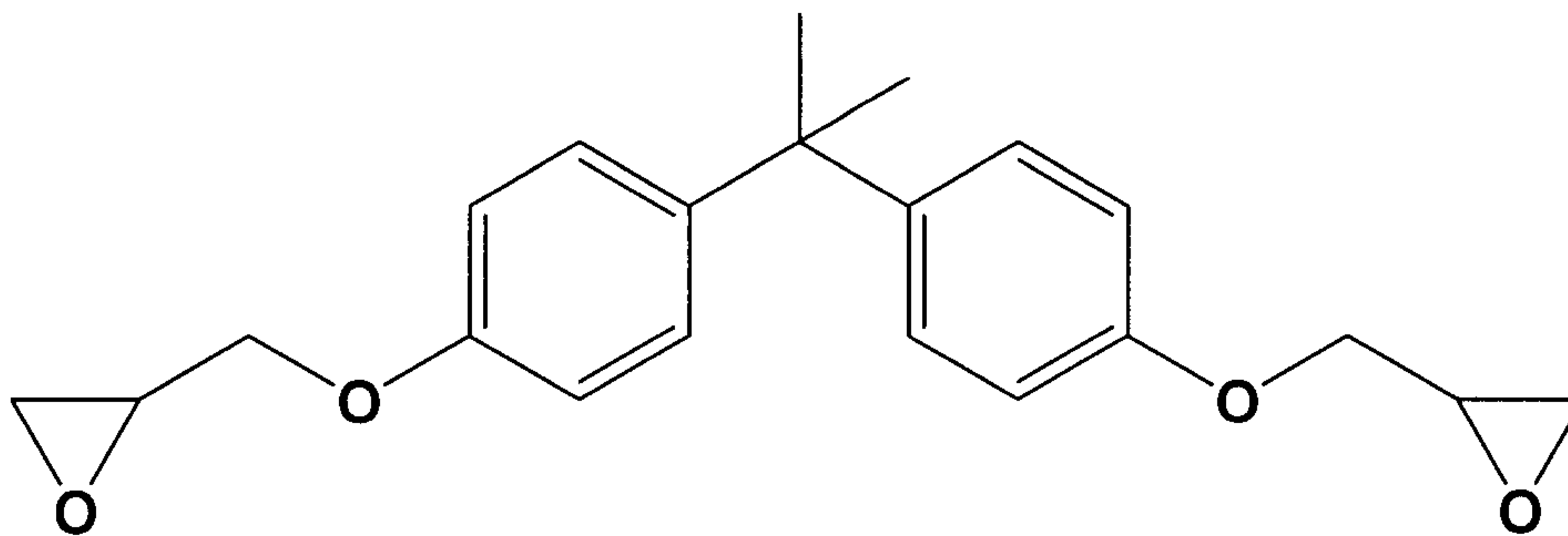
One manufacturer of trimethylolpropane triacrylate **1026** is Sigma Aldrich. However, trifunctional acrylate **1010** may be obtained from other manufacturers.

Second polymer system **1006** having modulus **1035** comprises thermosetting epoxy system **1030** and epoxy curing agent **1032**. Thermosetting epoxy system **1030** contains first epoxy **1034**. Further, in some illustrative examples, thermosetting epoxy system **1030** also includes second epoxy **1036**.

Thermosetting epoxy system **1030** may be selected to have properties **1050**. Properties **1050** may include at least one of miscibility mismatch with first polymer system **1004**, chemical structure similarity with first polymer system **1004**, and modulus. Thermosetting epoxy system **1030** may be selected such that the viscosity of the uncured mixture of first polymer system **1004** and second polymer system **1006** has a desirable value.

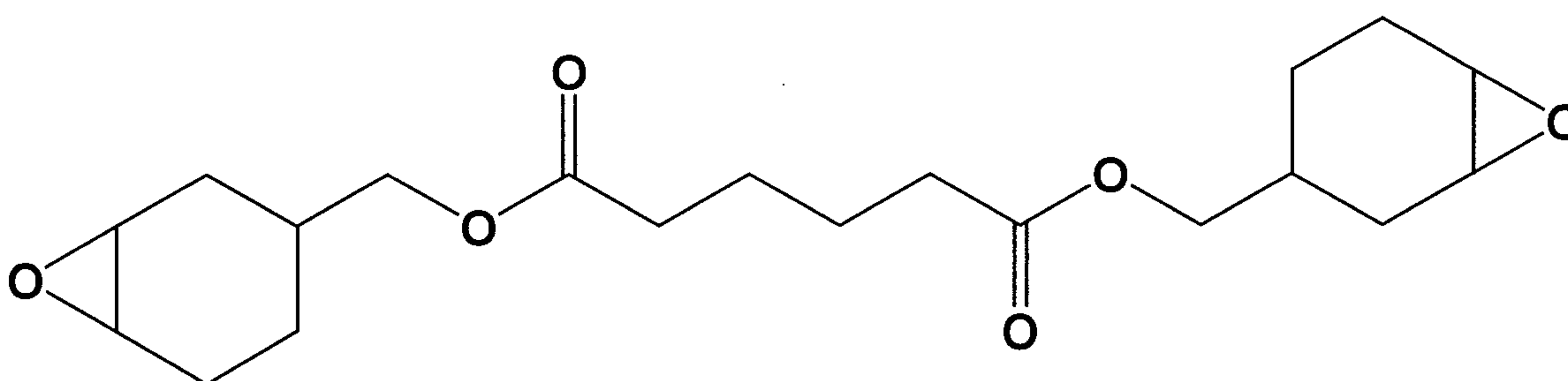
In some illustrative examples, first epoxy **1034** may be one of diglycidyl ether of bisphenol a **1044**, or bis((3,4-epoxy cyclohexyl)methyl) adipate a **1046**.

Diglycidyl ether of bisphenol a **1044** may be denoted chemically as



One example of commercially available diglycidyl ether of bisphenol a **1044** is Dow DER 332 **1052**.

Bis((3,4-epoxy cyclohexyl)methyl) adipate a **1046** may be denoted chemically as



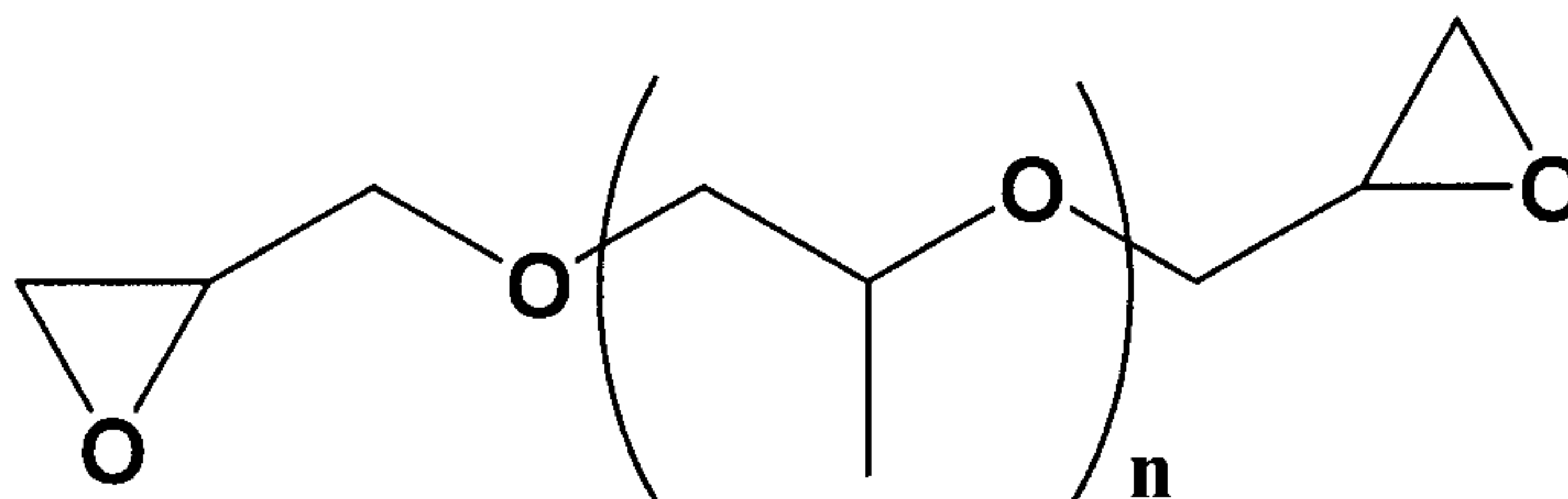
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One example of commercially available bis((3,4-epoxy cyclohexyl)methyl) adipate a **1046** is synasia syna epoxy **28 1054**.

In some illustrative examples, thermosetting epoxy system **1030** includes second epoxy **1036**. In these illustrative examples, different concentrations of second epoxy **1036** within thermosetting epoxy system **1030** are desirable. In one illustrative example, thermosetting epoxy system **1030** includes about **50** weight percent of second epoxy **1036**. In another illustrative example, thermosetting epoxy system **1030** includes about **30** weight percent second epoxy **1036**. In yet another illustrative example, thermosetting epoxy system **1030** includes about **40** weight percent of second epoxy **1036**.

Second epoxy **1036** may be selected to affect properties **1050**. In some examples, second epoxy **1036** may be selected to decrease the viscosity of thermosetting epoxy system **1030** prior to cure. In other examples, second epoxy **1036** may be selected to decrease modulus **1035** of second polymer system **1006**.

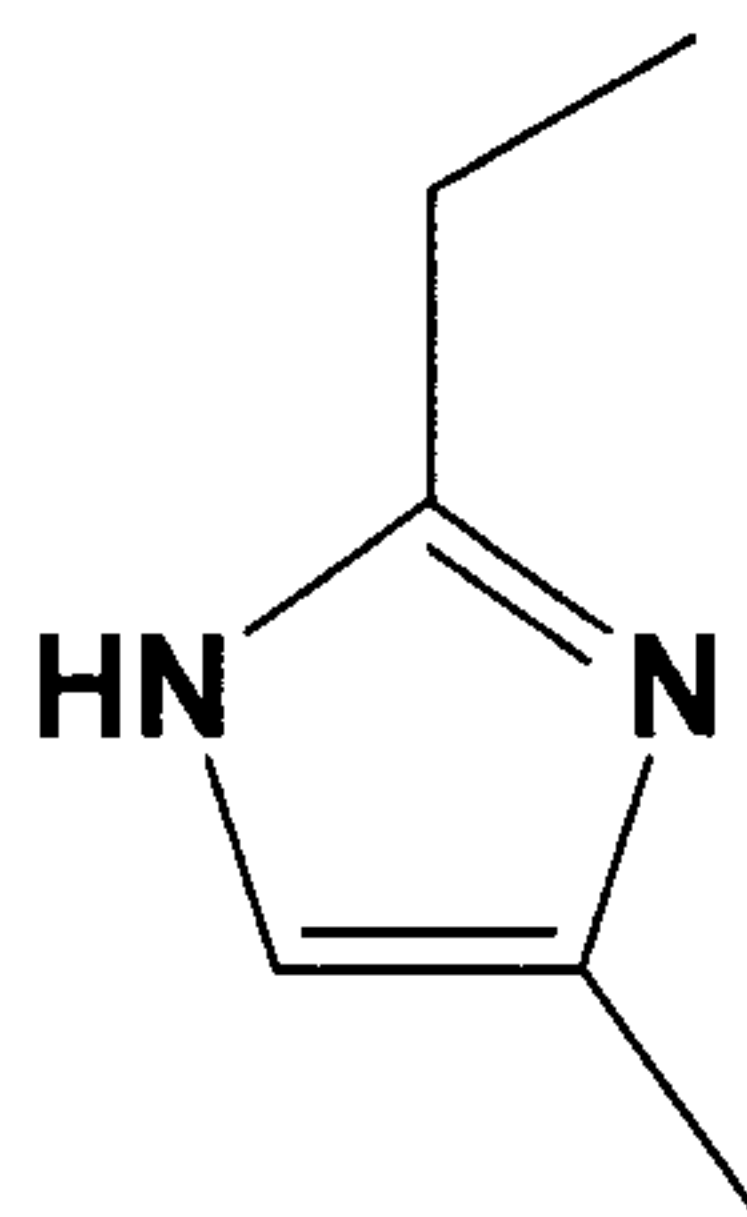
In some illustrative examples, second epoxy **1036** may be polypropylene glycol diglycidyl ether **1058**. Polypropylene glycol diglycidyl ether **1058** may be denoted chemically as



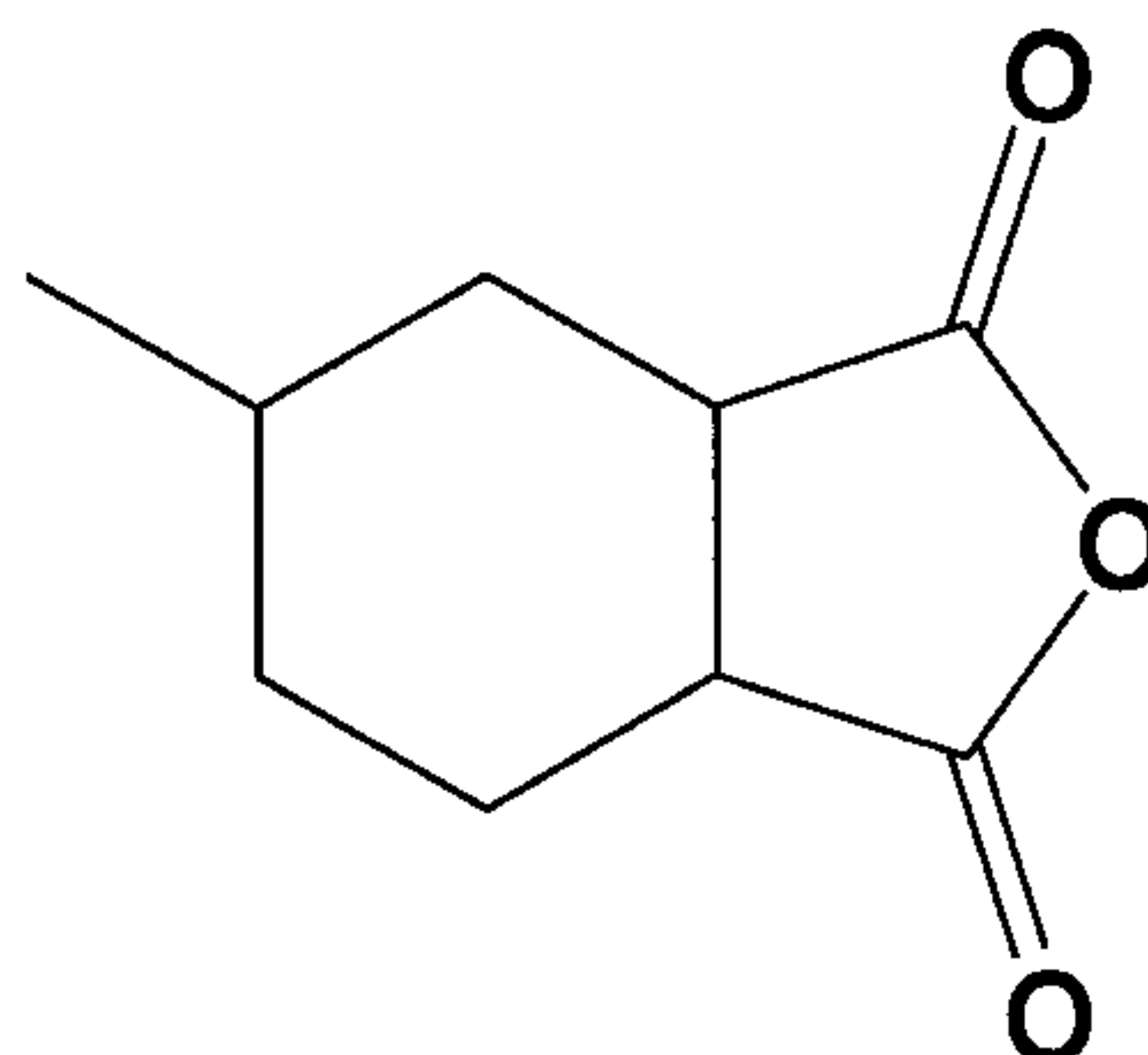
- 5 One example of commercially available polypropylene glycol diglycidyl ether **1058** is Dow DER 736 **1062**.

Epoxy curing agent **1032** may be selected from 2-ethyl-4-methyl imidazole **1038** and methylhexhydrophthalic anhydride **1040**. Epoxy curing agent **1032** is selected based on properties **1042**. Specifically, epoxy curing agent **1032** may be selected such that epoxy curing agent **1032** does not initiate the cure of first polymer system **1004** under room temperature. Additionally, epoxy curing agent **1032** may be selected such that epoxy curing agent **1032** does not cross-link second polymer system **1006** until after cure of first polymer system **1004** by one of a radiation source or an elevated temperature such as **140** degrees Fahrenheit.

- 15 When epoxy curing agent **1032** is 2-ethyl-4-methyl imidazole **1038**, the ratio of epoxy curing agent **1032** to thermosetting epoxy system **1030** may be about **9** mol percent to about **31** mol percent. In some illustrative examples, when epoxy curing agent **1032** is 2-ethyl-4-methyl imidazole **1038**, the ratio of epoxy curing agent **1032** to thermosetting epoxy system **1030** may be about **1:10** by weight. In other
20 illustrative examples, the ratio of 2-ethyl-4-methyl imidazole **1038** to thermosetting epoxy system **1030** may be different. 2-ethyl-4-methyl imidazole **1038** may be denoted chemically as



When epoxy curing agent **1032** is methylhexhydrophthalic anhydride **1040**, the ratio of epoxy curing agent **1032** to thermosetting epoxy system **1030** may be about **45** weight percent to about **70** weight percent of epoxy curing agent **1032** per
 5 hundred weight percent thermosetting epoxy system **1030**. In some illustrative examples, when epoxy curing agent **1032** is methylhexhydrophthalic anhydride **1040**, the ratio of epoxy curing agent **1032** to thermosetting epoxy system **1030** is about **7:10** by weight. In other illustrative examples, the ratio of methylhexhydrophthalic anhydride **1040** to thermosetting epoxy system **1030** may
 10 be different. Methylhexhydrophthalic anhydride **1040** may be denoted chemically as



In some illustrative examples, interpenetrating polymer network adhesive **1002** may be used to join first part **1064** and second part **1066**. First part **1064** may be formed of composite **1068** or metal **1070**. Second part **1066** may be formed of composite
 15 **1072** or metal **1074**.

In some illustrative examples, interpenetrating polymer network adhesive **1002** may be used as a resin within at least one of first part **1064** and second part **1066**. For example, interpenetrating polymer network adhesive **1002** may form part of composite **1068** for first part **1064**.

In curing interpenetrating polymer network adhesive **1002**, first polymer system **1004** may be cured first. First polymer system **1004** may be cured using a radiation beam, such as radiation beam **45** of Figure 3. As first polymer system **1004** is cured first, interpenetrating polymer network adhesive **1002** will develop strength using first polymer system **1004**. In other words, at least one of thermosetting acrylate **1008** and trifunctional acrylate **1010** develops the strength of interpenetrating polymer network adhesive **1002**. At least one of properties **1013** and properties **1028** may be selected to provide a desired strength to interpenetrating polymer network adhesive **1002** after the second curing of interpenetrating polymer network adhesive **1002**.

Second polymer system **1006** may be cured second. As a result, second polymer system **1006** may provide flexibility to interpenetrating polymer network adhesive **1002**. In other words, thermosetting epoxy system **1030** provides the flexibility of interpenetrating polymer network adhesive **1002**. Properties **1050** may be selected such that a desired flexibility results after the second curing of interpenetrating polymer network adhesive **1002**.

In some examples, toughness of interpenetrating polymer network adhesive **1002** may be developed through a mismatch between modulus **1012** and modulus **1035**. Specifically, toughness of interpenetrating polymer network adhesive **1002** may be developed when modulus **1035** is 60% or less of the value of modulus **1012**.

In one illustrative example, thermosetting epoxy system **1030** comprises 50 weight percent diglycidyl ether of bisphenol a **1044** and 50 weight percent polypropylene glycol diglycidyl ether **1058**, and has modulus **1035** of about 141 ksi. In another illustrative example, thermosetting epoxy system **1030** comprises 70 weight percent diglycidyl ether of bisphenol a **1044** and 30 weight percent polypropylene glycol diglycidyl ether **1058**, and has modulus **1035** of about 399 ksi.

In some examples, toughness of interpenetrating polymer network adhesive **1002** may also be developed through chemical cross-linking of first polymer system **1004** and thermosetting epoxy system **1030**. Specifically, during a thermal cure,

unreacted acrylate groups of first polymer system **1004** may react with thermosetting epoxy system **1030** to provide chemical linkages. Thermoplastic tougheners are not used in interpenetrating polymer network adhesive **1002**.

Several phenomena may occur due to selecting materials for first polymer system **1004** and second polymer system **1006**. In one illustrative example, the presence of thermosetting epoxy system **1030** monomer reduces the rate of the normally fast first polymer system **1004** reaction. The presence of thermosetting epoxy system **1030** monomer may enable more diffusion than if thermosetting epoxy system **1030** monomer were not present. This increased diffusion may increase the degree of monomer conversion in first polymer system **1004**.

In some illustrative examples, the selection of bisphenol a diacrylate **1014** and diglycidyl ether of bisphenol a **1044** may enhance compatibility and reduce the tendency of first polymer system **1004** and second polymer system **1006** to separate within interpenetrating polymer network adhesive **1002**.

Although sequential interpenetrating polymer network adhesives are discussed above, in some illustrative examples, interpenetrating polymer network adhesive **1002** may be formed as a simultaneous interpenetrating polymer network adhesive. In sequential interpenetrating polymer network adhesives, cure of first polymer system **1004** may be initiated first and cure of second polymer system **1006** may be initiated second. A simultaneous interpenetrating polymer network adhesive has cure of first polymer system **1004** and second polymer system **1006** initiated at substantially the same time. In a simultaneous interpenetrating polymer network adhesive, cure of first polymer system **1004** cures at a significantly faster rate than second polymer system **1006**. As a result, second polymer system **1006** may still be in the initial stages of curing after curing of first polymer system **1004** is complete. In such illustrative examples, epoxy curing agent **1032** may be 2-ethyl-4-methyl imidazole **1038**. In one illustrative example, a simultaneous interpenetrating polymer network adhesive may be formed at a slightly elevated temperature such as about **140** degrees Fahrenheit. In this illustrated example, first polymer system **1004** may

be cured in about a minute or less while second polymer system **1006** may be cured in about two to four hours.

The illustration of manufacturing environment **1000** in Figure **10** is not meant to imply physical or architectural limitations to the manner in which an illustrative embodiment may be implemented. Other components in addition to, or in place of, the ones illustrated may be used. Some components may be unnecessary. Also, the blocks are presented to illustrate some functional components. One or more of these blocks may be combined, divided, or combined and divided into different blocks when implemented in an illustrative embodiment. For example, without limitation, composite panel forming environment **1000** may further include a radiation source, such as radiation source **47** of Figure **3**.

Figure. **11** is an illustration of a graphical plot of compressive yield strength versus first polymer system content of an interpenetrating polymer network in accordance with illustrative embodiments. As can be seen from Figure **11**, compressive yield strength **1102** is plotted against first polymer system content **1103** for interpenetrating polymer network adhesives. Interpenetrating polymer network adhesives in this example comprise formulations in which the thermosetting acrylate comprises bisphenol a diacrylate and the thermosetting epoxy system comprises **50** weight percent of diglycidyl ether of bisphenol a and **50** weight percent of polypropylene glycol diglycidyl ether. As depicted, compressive yield strength data **1104** for interpenetrating polymer network adhesives does not follow linear rule of mixtures **1106**. The linear rule of mixtures states that a composite's properties are the combination of properties in its two constituent materials. The composite property equals the sum of the respective volume percentage of a constituent multiplied by the value of the material property of the constituent. As depicted, linear rule of mixtures **1106** for a mixture of bisphenol a diacrylate, diglycidyl ether of bisphenol a, and polypropylene glycol diglycidyl ether consists of upper bound **1108** and lower bound **1110**. In the cases where a composition has a value outside of

linear rule of mixtures **1106**, the composition has an unexpected value for compressive yield strength **1102**.

Figure **12** is an illustration of a graphical plot of tensile strength versus thermosetting first polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments. As can be seen from Figure **12**, tensile strength **1202** is plotted against first polymer system content **1203** for interpenetrating polymer network adhesives. Interpenetrating polymer network adhesives in this example comprise formulations in which the first polymer system comprises **80** weight percent of a thermosetting acrylate and **20** weight percent of a trifunctional acrylate. In other words, the first polymer system comprises a ratio of the thermosetting acrylate to the trifunctional acrylate where the ratio is about **4:1** by weight. The thermosetting acrylate comprises bisphenol a diacrylate, the trifunctional acrylate is trimethylolpropane triacrylate, and the thermosetting epoxy system comprises **50** weight percent of diglycidyl ether of bisphenol a and **50** weight percent of polypropylene glycol diglycidyl ether. As depicted, tensile strength data **1204** for interpenetrating polymer network adhesives does not follow linear rule of mixtures **1206**. As depicted, linear rule of mixtures **1206** for a mixture of bisphenol a diacrylate, trimethylolpropane triacrylate, diglycidyl ether of bisphenol a, and polypropylene glycol diglycidyl ether consists of upper bound **1208** and lower bound **1210**. In the cases where a composition has a value outside of linear rule of mixtures **1206**, the composition has an unexpected value for normalized tensile strength **1202**. As can be seen in Figure **12**, interpenetrating polymer network adhesives have greater tensile strength **1202** than linear rule of mixtures **1206**. Accordingly, interpenetrating polymer network adhesives exhibit a desirably greater strength than their constituents.

Figure **13** is an illustration of a graphical plot of fracture toughness versus first polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments. As can be seen from Figure **13**, fracture toughness **1302** is plotted against first polymer system content **1303** for interpenetrating polymer

network adhesives. Like in Figure 12, the interpenetrating polymer network adhesives in this example comprise formulations in which the first polymer system comprises 80 weight percent of a thermosetting acrylate and 20 weight percent of a trifunctional acrylate. The thermosetting acrylate comprises bisphenol a diacrylate, the trifunctional acrylate is trimethylolpropane triacrylate, and the thermosetting epoxy system comprises 50 weight percent of diglycidyl ether of bisphenol a and 50 weight percent of polypropylene glycol diglycidyl ether. As depicted, fracture toughness data 1304 for interpenetrating polymer network adhesives does not follow linear rule of mixtures 1306. As depicted, linear rule of mixtures 1306 for a mixture of bisphenol a diacrylate, trimethylolpropane triacrylate, diglycidyl ether of bisphenol a, and polypropylene glycol diglycidyl ether consists of upper bound 1308 and lower bound 1310. In the cases where a composition has a value outside of linear rule of mixtures 1306, the composition has an unexpected value for fracture toughness 1302.

As can be seen in Figure 13, interpenetrating polymer network adhesives have greater fracture toughness 1302 than linear rule of mixtures 1306. Accordingly, interpenetrating polymer network adhesives exhibit a desirably greater toughness than their individual constituents.

Figure 14 is an illustration of a graphical plot of tensile strength and fracture toughness versus first polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments. Specifically, Figure 14 is an overlay of Figures 12 and 13.

Fracture toughness data 1304 from Figure 13 for interpenetrating polymer networks is presented with toughness trend 1402. Toughness trend 1402 is a trend line for the points of toughness data for interpenetrating polymer networks. Tensile strength data 1204 for interpenetrating polymer networks is presented with tensile strength trend 1404. Tensile strength trend 1404 is a trend line for the points of tensile strength data 1204.

In most conventional materials, there is a trade-off between strength and toughness. Specifically, in most conventional materials, when strength increases, toughness decreases. Further, in most conventional materials, when toughness increases, strength decreases.

5 As can be seen from Figure **14**, toughness trend **1402** increases until about **70%** first polymer system content **1303**. As depicted, tensile strength trend **1404** increases until about **70%** first polymer system content **1303**. In this illustrative example, interpenetrating polymer networks having first polymer system contents between about **60%** first polymer system content and about **80%** first polymer system content may be desirable. These interpenetrating polymer networks may be desirable based on intersecting desirable fracture toughness and desirable tensile strength. As can be seen in Figure **14**, between about **60%** first polymer system content and about **80%** first polymer system content, toughness trend **1402** and tensile strength trend **1404** have highest values.

15 Figure **15** is an illustration of a graphical plot of degree of monomer conversion versus first polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments. As can be seen from Figure **15**, degree of monomer conversion **1502** is plotted against first polymer system content **1503** for interpenetrating polymer network adhesives. In Figure **15**, the interpenetrating polymer network adhesives in this example comprise formulations in which the thermosetting acrylate comprises bisphenol a diacrylate and the thermosetting epoxy system comprises **50** weight percent of diglycidyl ether of bisphenol a and **50** weight percent of polypropylene glycol diglycidyl ether.

20 In curing a material, a degree of monomer conversion near **1.0** is desirable. Lower degrees of monomer conversion are less desirable. A degree of monomer conversion may also be referred to as a degree of cure.

Degree of monomer conversion data **1504** for interpenetrating polymer network adhesives is depicted. As can be seen from Figure **15**, degree of monomer conversion data **1504** for interpenetrating polymer network adhesives having first

polymer system content **1503** between about **20** weight percent and about **80** weight percent exhibit the highest, and therefore most desirable, degrees of monomer conversion.

Figure **16** is an illustration of a graphical plot of loss modulus versus temperature of interpenetrating polymer networks in accordance with illustrative embodiments. As can be seen from Figure **16**, the compositions exhibit a single glass transition temperature. A single glass transition temperature is indicative of an interpenetrating polymer network when the composition is a mixture of two different components.

As can be seen in Figure **16**, first composition **1604** exhibits a single glass transition temperature. First composition **1604** is a composition having about **48** weight percent first polymer system. In this example, the first polymer system is about **80** weight percent bisphenol a diacrylate and about **20** weight percent trimethylolpropane triacrylate. In this example, the second polymer system has a thermosetting epoxy system that is about **50** weight percent diglycidyl ether of bisphenol a and about **50** weight percent polypropylene glycol diglycidyl ether. First composition also includes **2-ethyl-4-methyl** imidazole as a cure agent.

As can be seen from Figure **16**, second composition **1606** exhibits a single glass transition temperature. Second composition **1606** is a composition having bisphenol a diacrylate as the first polymer system. Second composition has Bis(**3,4**-epoxy cyclohexyl)methyl)adipate as a thermosetting epoxy system. Second composition also includes methylhexahydroPhthalic Anhydride as a cure agent.

As can be seen in Figure **16**, third composition **1608** exhibits a single glass transition temperature. Third composition **1608** is a composition having about **48** weight percent first polymer system. In this example, the first polymer system is bisphenol a diacrylate. In this example, the second polymer system has a thermosetting epoxy system that is about **70** weight percent diglycidyl ether of bisphenol a and about **30** weight percent polypropylene glycol diglycidyl ether. Third composition also includes **2-ethyl-4-methyl** imidazole as a cure agent.

Figure **17** is an illustration of a graphical plot of density versus first polymer system content of interpenetrating polymer networks in accordance with illustrative embodiments. In Figure **17**, density **1702** is plotted against first polymer system content **1703** for interpenetrating polymer network adhesives **1704**. In this
 5 illustrative example, interpenetrating polymer network adhesives **1704** have bisphenol a diacrylate as the first polymer system. In this illustrative example, the second polymer system is about **50** weight percent diglycidyl ether of bisphenol a and about **50** weight percent polypropylene glycol diglycidyl ether.

As can be seen, densities of interpenetrating polymer network adhesives
 10 **1704** follows the linear rule of mixtures. As the densities of interpenetrating polymer network adhesives **1704** follows the linear rule of mixtures, improved packing factor is not the source of the improved toughness and strength of interpenetrating polymer network adhesives **1704**.

Figure **18** is an illustration of a graphical plot of short beam shear results for
 15 an interpenetrating polymer network in contrast to its constituents. In Figure **18**, force **1802** of an interpenetrating polymer network adhesive **1804** is greater than its constituents. Specifically, the force of an interpenetrating polymer network is greater than both its first polymer system **1806** and second polymer system **1808**.

In this example, first polymer system **1806** comprises **80** weight percent of a
 20 thermosetting acrylate and **20** weight percent of trifunctional acrylate. In this example, the thermosetting acrylate is bisphenol a diacrylate. In this example, the trifunctional acrylate is trimethylolpropane triacrylate. In this example, second polymer system **1808** comprises a thermosetting epoxy system and epoxy curing agent. In this example, the thermosetting epoxy system comprises **50** weight
 25 percent diglycidyl ether of bisphenol a and **50** weight percent polypropylene glycol diglycidyl ether. In this example, the epoxy curing agent comprises 2-ethyl-4-methyl imidazole. The second polymer system **1808** comprises **10** parts per hundred of the epoxy curing agent. The interpenetrating polymer network adhesive **1804** comprises

50 weight percent of the first polymer system **1806** and **50** weight percent of the second polymer system **1808**.

Using the linear rule of mixtures, an expected value for force for a combination of first polymer system **1806** and second polymer system **1808** would
5 be between about **22** MPa and **11** MPa. Specifically, for a combination of about **50** weight percent of first polymer system **1806** and about **50** weight percent of second polymer system **1808**, an expected value for force would be about **17** MPa.

In Figure **18**, interpenetrating polymer network adhesive **1804** has an unexpected force **1802** as interpenetrating polymer network adhesive **1804** has a higher force
10 **1802** than either of its constituents. Accordingly, interpenetrating polymer network adhesive **1804** exhibits more desirable adhesive characteristics than its constituents.

Referring next to FIGS. **19** and **20**, embodiments of the disclosure may be used in the context of an aircraft manufacturing and service method **68** as shown in Figure **19** and an aircraft **70** as shown in Figure **20**. During pre-production,
15 exemplary method **68** may include specification and design **72** of the aircraft **70** and material procurement **74**. During production, component and subassembly manufacturing **76** and system integration **78** of the aircraft **70** takes place. The disclosed IPN adhesive **16** may be used to assemble parts and subassemblies as part of the manufacturing process step **76**. Thereafter, the aircraft **70** may go
20 through certification and delivery **80** in order to be placed in service **82**. While in service by a customer, the aircraft **70** may be scheduled for routine maintenance and service **166** (which may also include modification, reconfiguration, refurbishment, and so on), in which the IPN adhesive **16** may be used to repair or refurbish parts and assemblies.

25 Each of the processes of method **68** may be performed or carried out by a system integrator, a third party, and/or an operator (e.g., a customer). For the purposes of this description, a system integrator may include without limitation any number of aircraft manufacturers and major-system subcontractors; a third party may include without limitation any number of vendors, subcontractors, and suppliers;

and an operator may be an airline, leasing company, military entity, service organization, and so on.

As shown in Figure 20, the aircraft 70 produced by exemplary method 68 may include an airframe 86 with a plurality of systems 88 and an interior 90. Examples of
5 high-level systems 88 include one or more of a propulsion system 92, an electrical system 94, a hydraulic system 96, and an environmental system 98. Any number of other systems may be included. The disclosed IPN adhesive 16 may be used to fabricate parts used in the airframe 86 and in the interior 90. Although an aerospace
10 example is shown, the principles of the invention may be applied to other industries, such as the automotive industry.

The apparatus embodied herein may be employed during any one or more of the stages of the method 68. For example, components or subassemblies corresponding to production process 78 may be fabricated or manufactured in a manner similar to components or subassemblies produced while the aircraft 70 is in
15 service. Also, one or more apparatus embodiments may be utilized during the production stages 76 and 78, for example, by substantially expediting assembly of or reducing the cost of an aircraft 152. Similarly, one or more apparatus embodiments may be utilized while the aircraft 70 is in service, for example and without limitation, to maintenance and service 84.

20 In one illustrative embodiment, a method of bonding two parts together is present. The method comprises placing the parts together with a layer of an interpenetrating polymer network (IPN) adhesive between the parts; attaching the parts to each other by curing a first polymer system of the IPN adhesive using radiation energy; and thermally curing a second flexible polymer system of the IPN adhesive after the first
25 polymer system has been cured. In some illustrative examples, curing the first adhesive system is performed substantially at room temperature using a beam of the radiation energy, and thermally curing the second adhesive system is performed at a temperature above room temperature. In one illustrative example, the first polymer system is cured to a stage that allows handling of the parts. In another illustrative

example, the first polymer system is an acrylated epoxy forming a first substantially continuous structure when cured that attaches and holds the parts together until the second polymer system is cured. In another illustrative example, the second polymer system is selected from the group consisting of: a substantially flexible epoxy, and a substantially flexible vinyl ester. In yet another illustrative example, the parts have respectively different coefficients of thermal expansion. In yet a further illustrative example, one of the parts is a fiber reinforced composite and the other of the parts includes metal.

In another illustrative embodiment, a method of fabricating a composite structure is present. The method comprises laying up first and second composite laminates each having a fiber reinforced interpenetrating polymer network (IPN) matrix including a first polymer adhesive system and a flexible second polymer adhesive system; curing the first polymer adhesive system; assembling the first and second laminates together with a layer of the second polymer adhesive system therebetween; and curing the second polymer adhesive system. In one illustrative example, curing the first polymer adhesive system is performed at substantially room temperature by a beam of radiation. In another illustrative example, curing the first polymer adhesive system is performed at substantially room temperature by a beam of radiation, and curing the second polymer adhesive system is performed by co-curing the assembled laminates and the layer of adhesive during a thermal cure cycle after the first polymer adhesive system has been cured. In one illustrative example, curing of the first polymer adhesive system is performed before the first and second laminates are assembled together and provides the laminates with sufficient rigidity to allow handling of the laminates. In a further illustrative example, the curing of the second polymer adhesive system produces a substantially continuous flexible polymer structure extending through the first and second laminates and the bond.

In one illustrative embodiment, an interpenetrating polymer network (IPN) adhesive is presented. The interpenetrating polymer network (IPN) adhesive

comprises an acrylated polymer system curable by radiation; and a flexible epoxy system thermally curable after the acrylated polymer system is cured. In one illustrative example, the acrylated polymer system is an acrylated epoxy. In another illustrative example, the acrylated polymer system is an acrylated epoxy and the acrylated epoxy is curable by radiation selected from the group consisting of an electron beam, ultraviolet light and x-rays. In another illustrative example, the flexible polymer system is one selected from the group consisting of: a flexible epoxy, and a flexible vinyl ester. In yet another illustrative example, the acrylated polymer system is an acrylated epoxy and the acrylated epoxy includes at least one of: bisphenol, a diacrylate (BPADA) with A trifunctional acrylate, trimethylolpropane, and a triacrylate (TMPTA) cross-linking agent. In yet another illustrative example, the acrylated polymer system is an acrylated epoxy and the flexible epoxy system is selected from the group consisting of: Bis(3,4-EpoxyCyclohexylmethyl) Adipate(BECA), and a combination of a Diglycidyl ether of bisphenol A (DGEBA) with a Polypropylene Glycol Diglycidyl Ether (PPGDE) chain extender. In a further illustrative example, the flexible polymer system includes a thermal cure initiator.

In one illustrative embodiment, a reinforced composite structure is present. The reinforced composite structure comprises a reinforcement; and a matrix in which the reinforcement is embedded, the matrix including an interpenetrating polymer network (IPN) forming a gradient interface around the reinforcement resulting in improved shear force transfer from the matrix to the reinforcement. In one illustrative example, the IPN is a bi-continuous structure including an acrylated polymer and a flexible epoxy, and the reinforcement includes fibers selected from the group consisting of carbon, fiberglass and an aramid.

In yet a further illustrative embodiment, a method of bonding metal and composite parts together is present. This method comprises placing the parts together with a layer of an interpenetrating polymer network (IPN) adhesive between the parts; attaching the parts to each other by curing a first polymer system of the IPN adhesive at room temperature using an electron beam of radiant energy until

the parts have sufficient rigidity to be handled, wherein the first polymer system is an acrylated epoxy forming a first substantially continuous structure when cured that attaches and locks the parts together until the second polymer system is cured; and thermally curing a second flexible polymer system of the IPN adhesive after the first
5 polymer system has been cured using a thermal cure cycle above room temperature, wherein the second polymer system is selected from the group consisting of a substantially flexible epoxy, and a substantially flexible vinyl ester.

In yet another illustrative embodiment, an interpenetrating polymer network (IPN) adhesive is present. The interpenetrating polymer network (IPN) adhesive
10 comprises an acrylated epoxy system curable by radiation selected from the group consisting of an electron beam, ultraviolet light and x-rays, wherein the acrylated epoxy system includes at least one of - bisphenol, a diacrylate (BPADA) with A trifunctional acrylate, trimethylolpropane, and a triacrylate (TMPTA) cross-linking agent; and a flexible epoxy system thermally curable after the acrylated epoxy
15 system is cured, wherein the flexible epoxy system includes a thermal cure initiator and is selected from the group consisting of Bis(3,4-EpoxyCyclohexylmethyl) Adipate(BECA), and a combination of a Diglycidyl ether of bisphenol A (DGEBA) with a Polypropylene Glycol Diglycidyl Ether (PPGDE) chain extender.

An interpenetrating polymer network (IPN) adhesive comprises an acrylated polymer
20 system curable by radiation, and a flexible epoxy system thermally curable after the acrylated polymer system is cured. According to one disclosed embodiment, a method is provided of bonding two parts together. The method comprises placing the parts together with a layer of IPN adhesive between the parts and attaching the parts to each other by curing the first polymer system of the IPN adhesive using
25 radiation energy. The method further comprises thermally curing a second flexible polymer system of the IPN adhesive after the first polymer system has been cured. Curing the first adhesive system is performed substantially at room temperature using a beam of radiation, such as an electron beam, and the second adhesive system is thermally cured at a temperature above room temperature. The first

polymer system is cured to at least a stage which renders the part sufficiently rigid to allow the part to be handled during subsequent processing steps. The first polymer system may comprise an acrylated epoxy that forms a substantially continuous structure when cured that attaches and holds the parts together until the second
5 polymer system is cured. The second polymer system may be selected from the group consisting of a substantially flexible epoxy and a substantially flexible vinyl ester.

According to another disclosed embodiment, a method is provided of fabricating a composite structure. The method comprises laying up first and second
10 composite laminates each having a fiber reinforced IPN matrix including a first polymer adhesive system, and a flexible second polymer adhesive system. The method further comprises curing the first polymer adhesive system and assembling the first and second laminates together with a layer of the second polymer adhesive system therebetween. The method further comprises curing the second polymer
15 adhesive system. The first polymer adhesive system is cured substantially at room temperature by a beam of radiation. The second polymer adhesive system is cured by co-curing the assembled laminates and the layer of adhesive during a thermal cure cycle after the first polymer adhesive system has been cured.

According to still another embodiment, an IPN adhesive comprises an
20 acrylated polymer system curable by radiation, and a flexible epoxy system cured after the acrylated polymer system is cured. The acrylated polymer system may comprise an acrylated epoxy, and the radiation may be selected from the group consisting of an electron beam, ultraviolet light and x-ray radiation. The flexible polymer system may be one selected from a group consisting of a flexible epoxy and
25 a flexible vinyl ester.

In accordance with another embodiment, a reinforced composite structure is provided. The composite structure comprises a reinforcement, and a matrix in which the reinforcement is embedded. The matrix includes an IPN forming a gradient interface around the reinforcement resulting in improved shear force transfer from

the matrix to the reinforcement. The reinforcement may include fibers selected from the group consisting of carbon, fiberglass and an aramid. The IPN is a bi-continuous structure including an acrylated polymer and a flexible epoxy.

5 Although the embodiments of this disclosure have been described with respect to certain exemplary embodiments, it is to be understood that the specific embodiments are for purposes of illustration and not limitation, as other variations will occur to those of skill in the art.

**THE EMBODIMENTS OF THE INVENTION IN WHICH AN EXCLUSIVE
PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:**

1. A composition consisting essentially of:

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a first polymer system having a first modulus of about **180** ksi to about **335** ksi consisting essentially of a thermosetting acrylate; and

a second polymer system consisting essentially of:

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a thermosetting epoxy system comprising a first epoxy; and

an epoxy curing agent.

- 15 2. The composition of Claim 1, wherein the thermosetting acrylate is bisphenol A diacrylate.

3. The composition of Claims 1 or 2, wherein the second polymer system has a second modulus, wherein the second modulus has a value of about **60**
20 percent or less of the first modulus.

4. The composition of Claims 1 – 3, wherein the first epoxy is diglycidyl ether of bisphenol A and wherein the thermosetting epoxy system further comprises polypropylene glycol diglycidyl ether.

25

5. The composition of Claim 4, wherein the thermosetting epoxy system comprises about **50** weight percent of diglycidyl ether of bisphenol A and about **50** weight percent polypropylene glycol diglycidyl ether.

- 5 6. The composition of Claim 4, wherein the thermosetting epoxy system comprises about **60** weight percent of diglycidyl ether of bisphenol A and about **40** weight percent of polypropylene glycol diglycidyl ether.

- 10 7. The composition of Claim 4, wherein the thermosetting epoxy system comprises about **70** weight percent of diglycidyl ether of bisphenol A and about **30** weight percent of polypropylene glycol diglycidyl ether.

8. The composition of Claims 1 – 3, wherein the first epoxy is bis((**3,4**-epoxy cyclohexyl)methyl)adipate.

- 15 9. The composition of Claims 1 – 3, wherein the epoxy curing agent is **2**-ethyl-**4**-methyl imidazole, and wherein a ratio of the epoxy curing agent to the thermosetting epoxy system is about **1:10** by weight.

- 20 10. The composition of Claims 1 – 3, wherein the epoxy curing agent is **2**-ethyl-**4**-methyl imidazole, and wherein a ratio of the epoxy curing agent to the thermosetting epoxy system is about **9** mol percent to about **31** mol percent.

- 25 11. The composition of Claims 1 – 3, wherein the epoxy curing agent is methylhexahydrophthalic anhydride, and wherein a ratio of the epoxy curing agent to the thermosetting epoxy system is about **45** weight percent to about

70 weight percent of the epoxy curing agent per hundred weight percent thermosetting epoxy system.

12. A composition consisting essentially of:

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a first polymer system having a first modulus of about **180** ksi to about **335** ksi consisting essentially of:

a thermosetting acrylate;

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a trifunctional acrylate; and

a second polymer system consisting essentially of:

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a thermosetting epoxy system comprising a first epoxy; and

an epoxy curing agent.

13. The composition of Claim **12**, wherein the second polymer system has a second modulus, wherein the second modulus has a value of about **60** percent or less of the first modulus.

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14. The composition of Claim **12** or **13**, wherein the thermosetting acrylate is bisphenol A diacrylate and wherein the trifunctional acrylate is trimethylolpropane triacrylate.

25

- 15.** The composition of Claim **14**, wherein a ratio of the thermosetting acrylate to the trifunctional acrylate is about **4:1** by weight.
- 5 **16.** The composition of Claim **14**, wherein a ratio of the thermosetting acrylate to the trifunctional acrylate is about **3:2** by weight.
- 17.** The composition of Claims **12 – 14**, wherein the first epoxy is diglycidyl ether of bisphenol A and wherein the thermosetting epoxy system further comprises polypropylene glycol diglycidyl ether.
- 10
- 18.** The composition of Claim **17**, wherein the thermosetting epoxy system comprises about **50** weight percent of diglycidyl ether of bisphenol A and about **50** weight percent polypropylene glycol diglycidyl ether.
- 15
- 19.** The composition of Claim **17**, wherein the thermosetting epoxy system comprises about **70** weight percent of diglycidyl ether of bisphenol A and about **30** weight percent of polypropylene glycol diglycidyl ether.
- 20 **20.** The composition of Claims **12 – 14**, wherein the epoxy curing agent is **2-Ethyl-4-Methyl Imidazole**.

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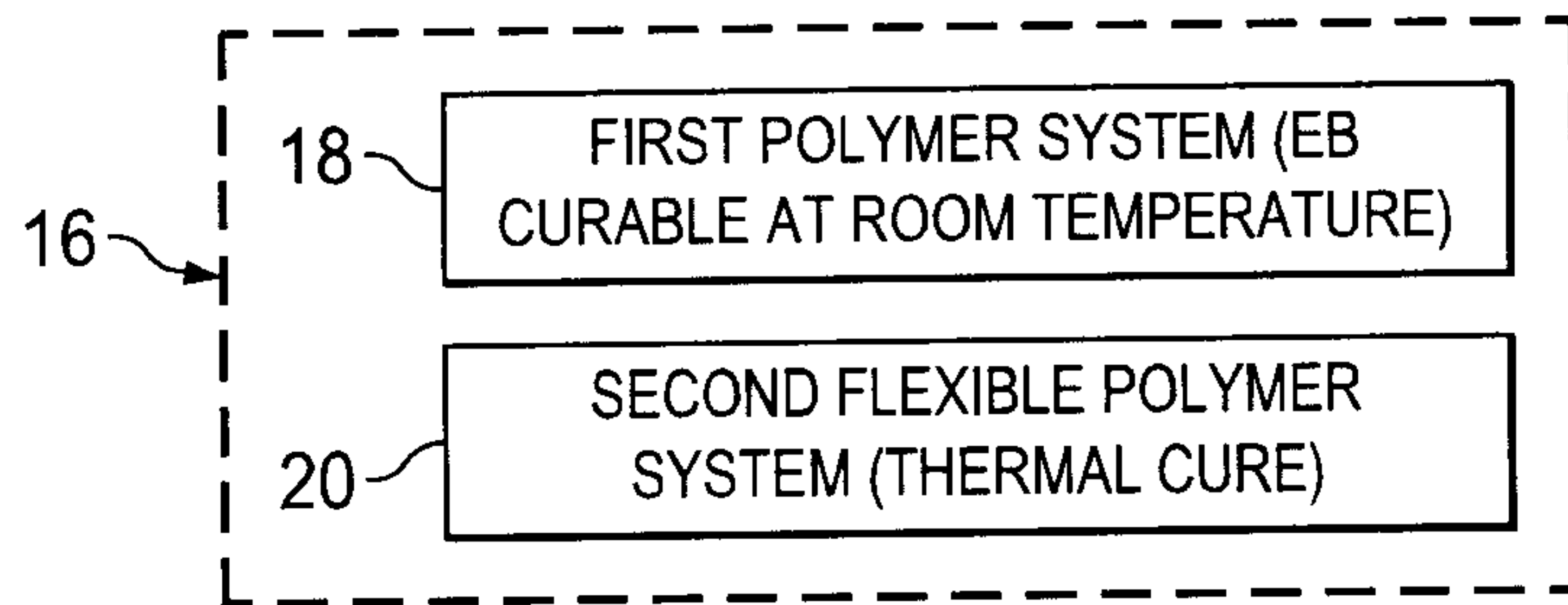


FIG. 1

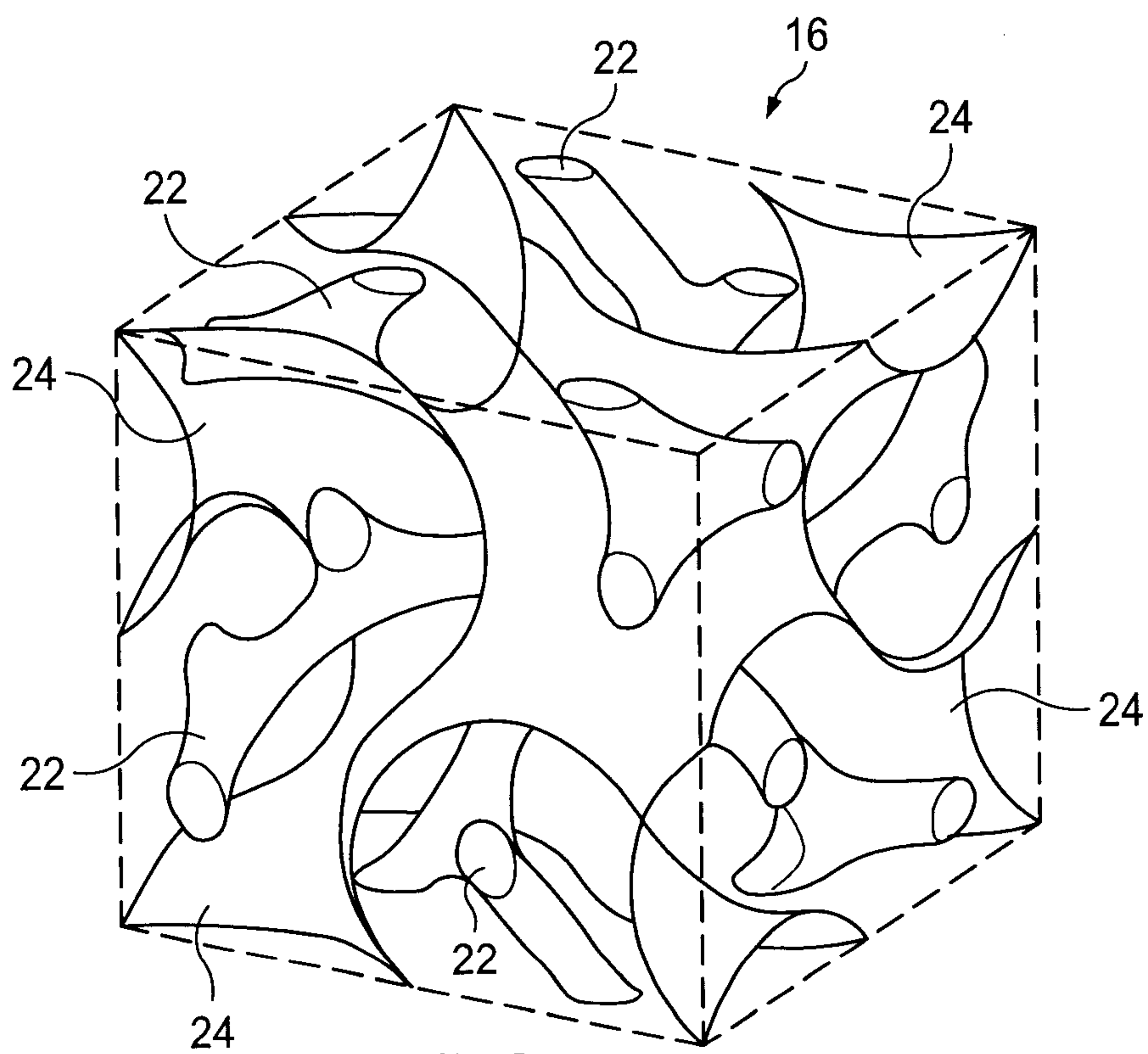


FIG. 2

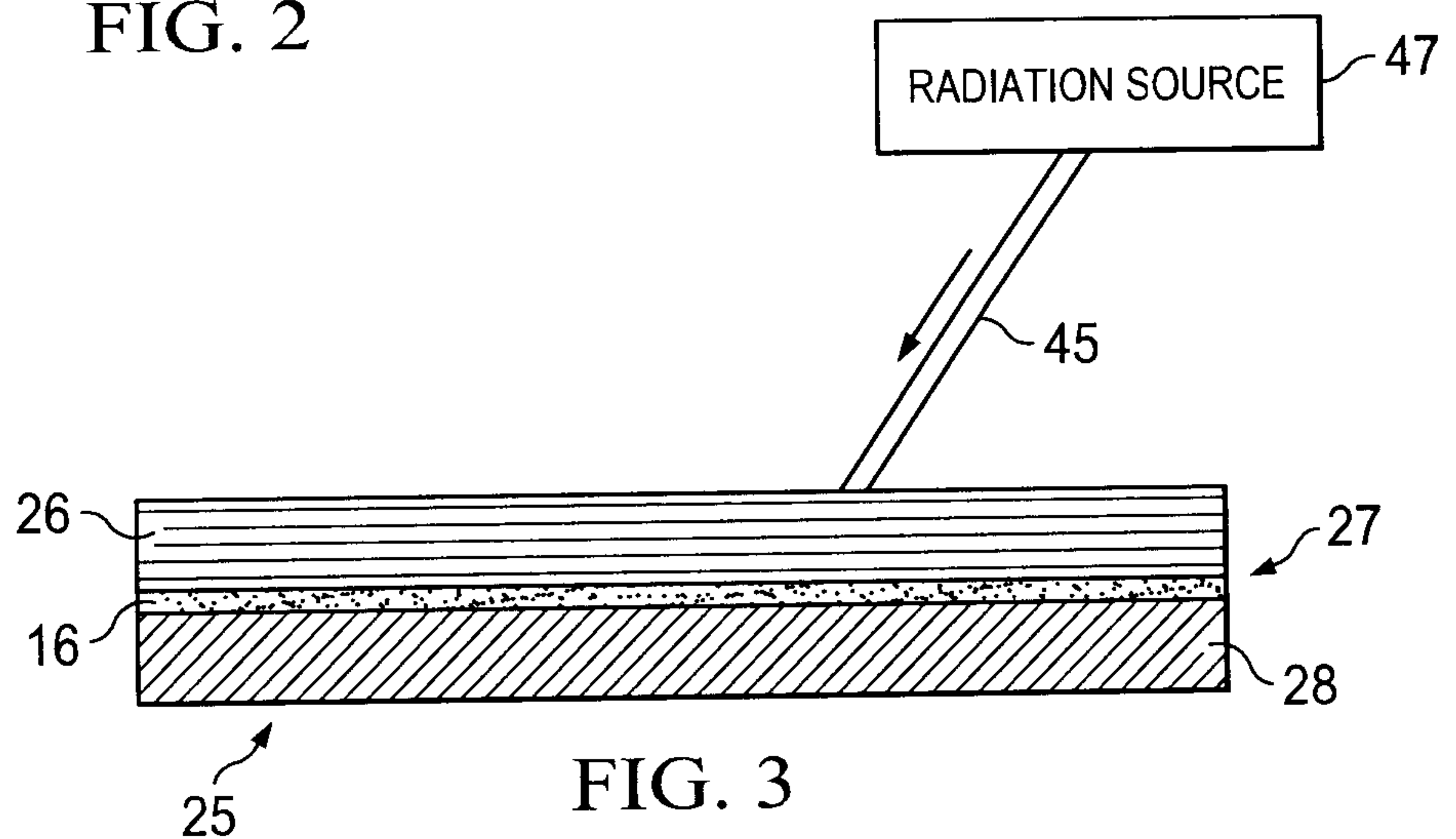


FIG. 3

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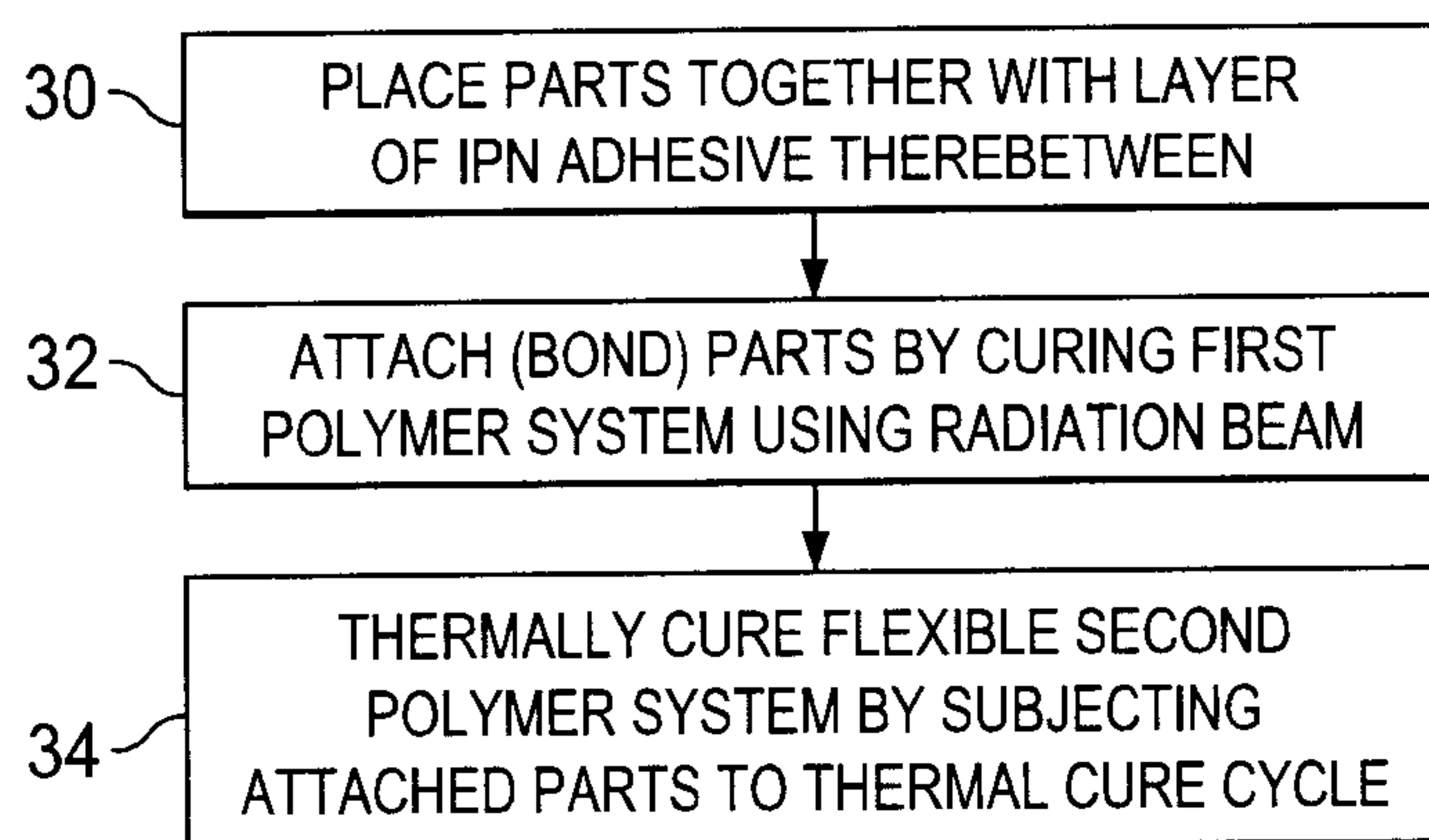
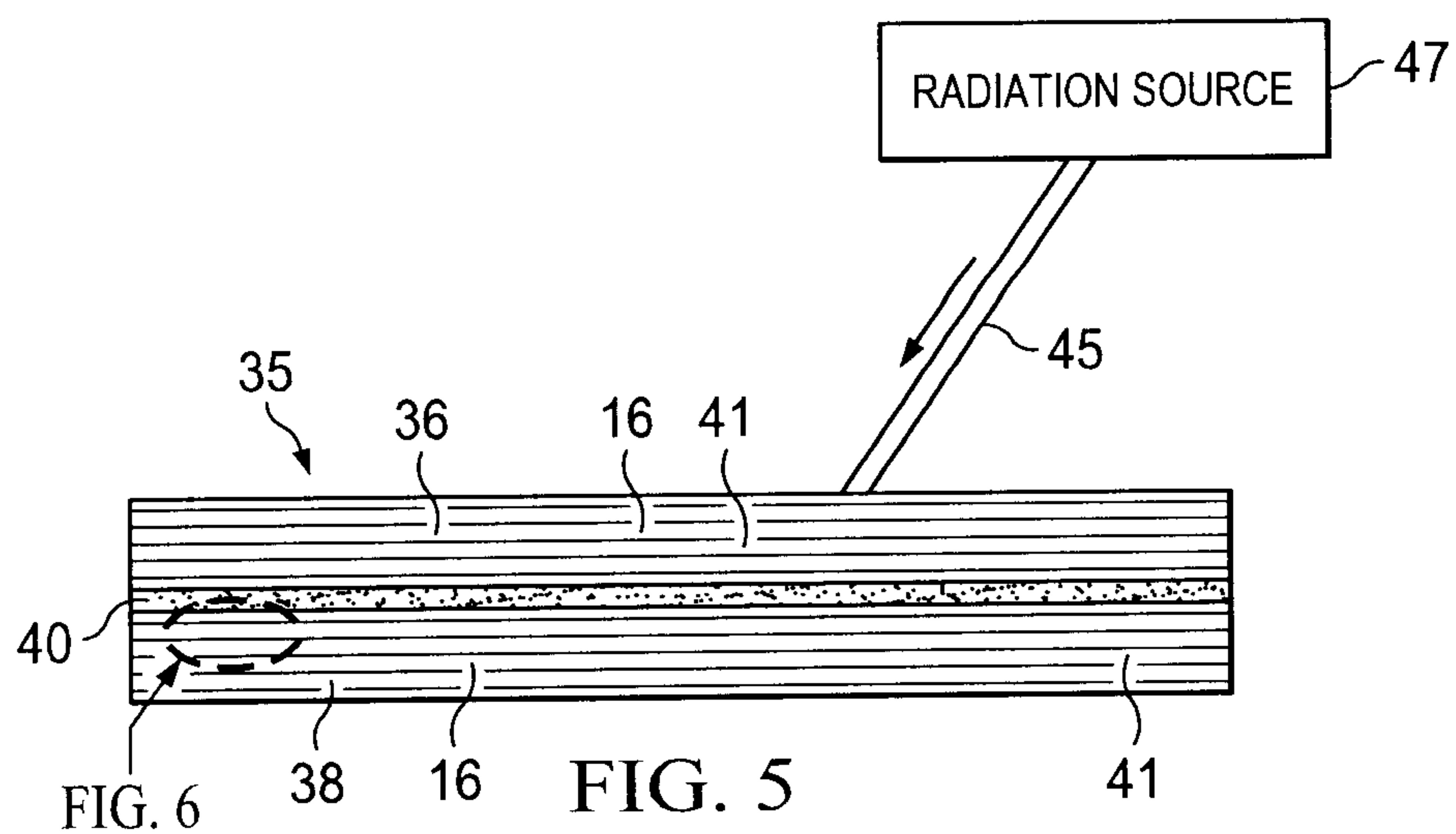


FIG. 4



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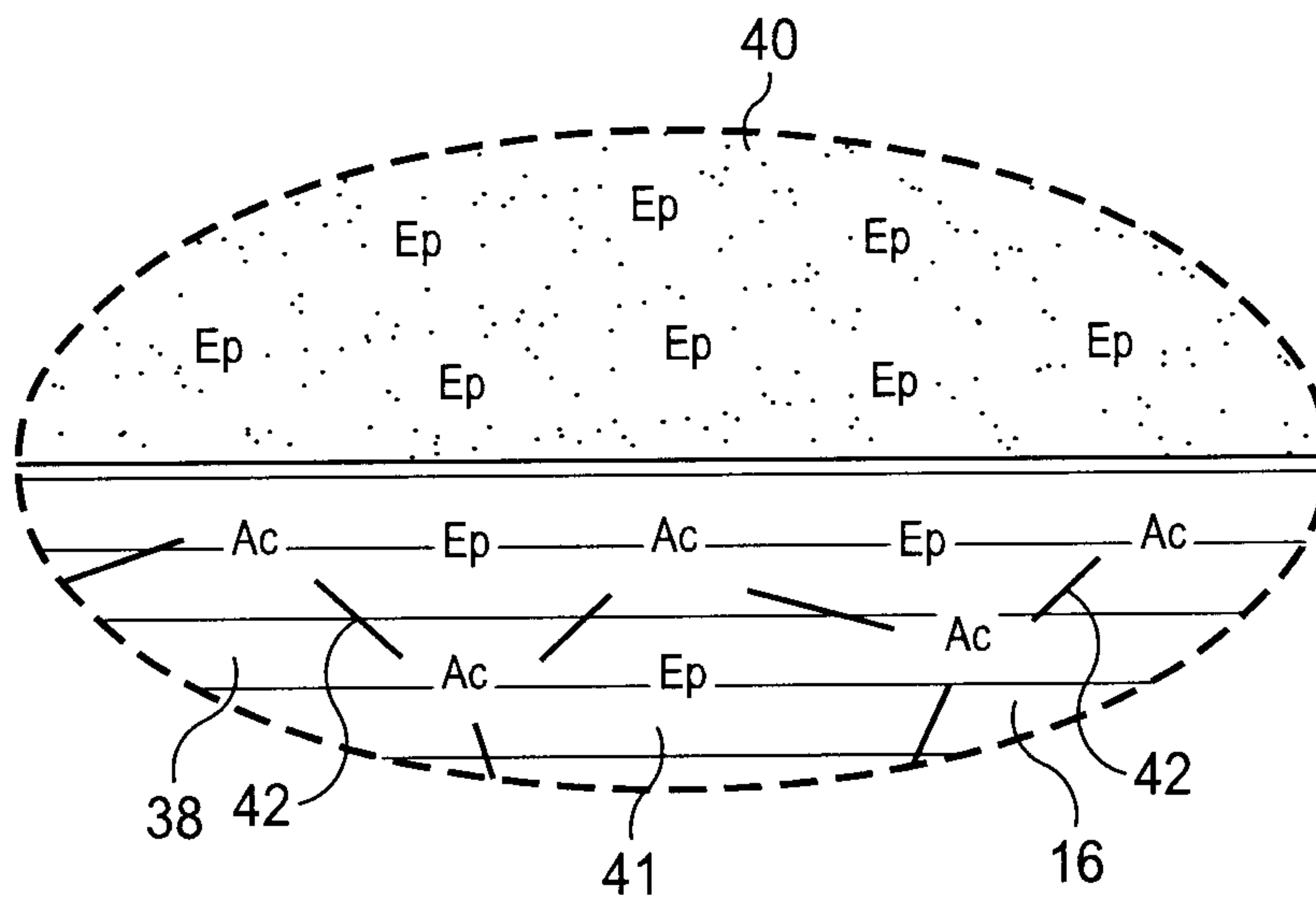


FIG. 6

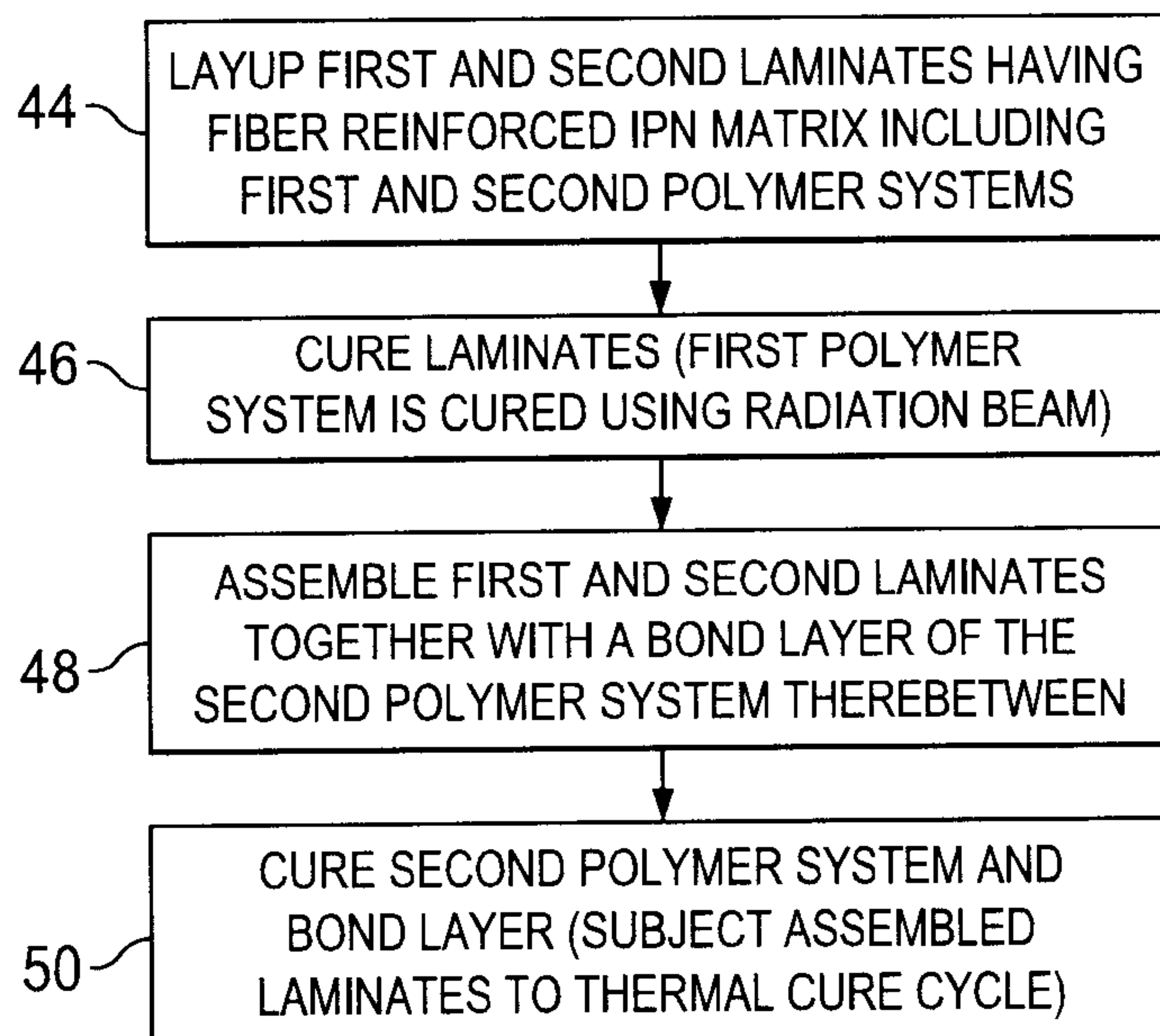
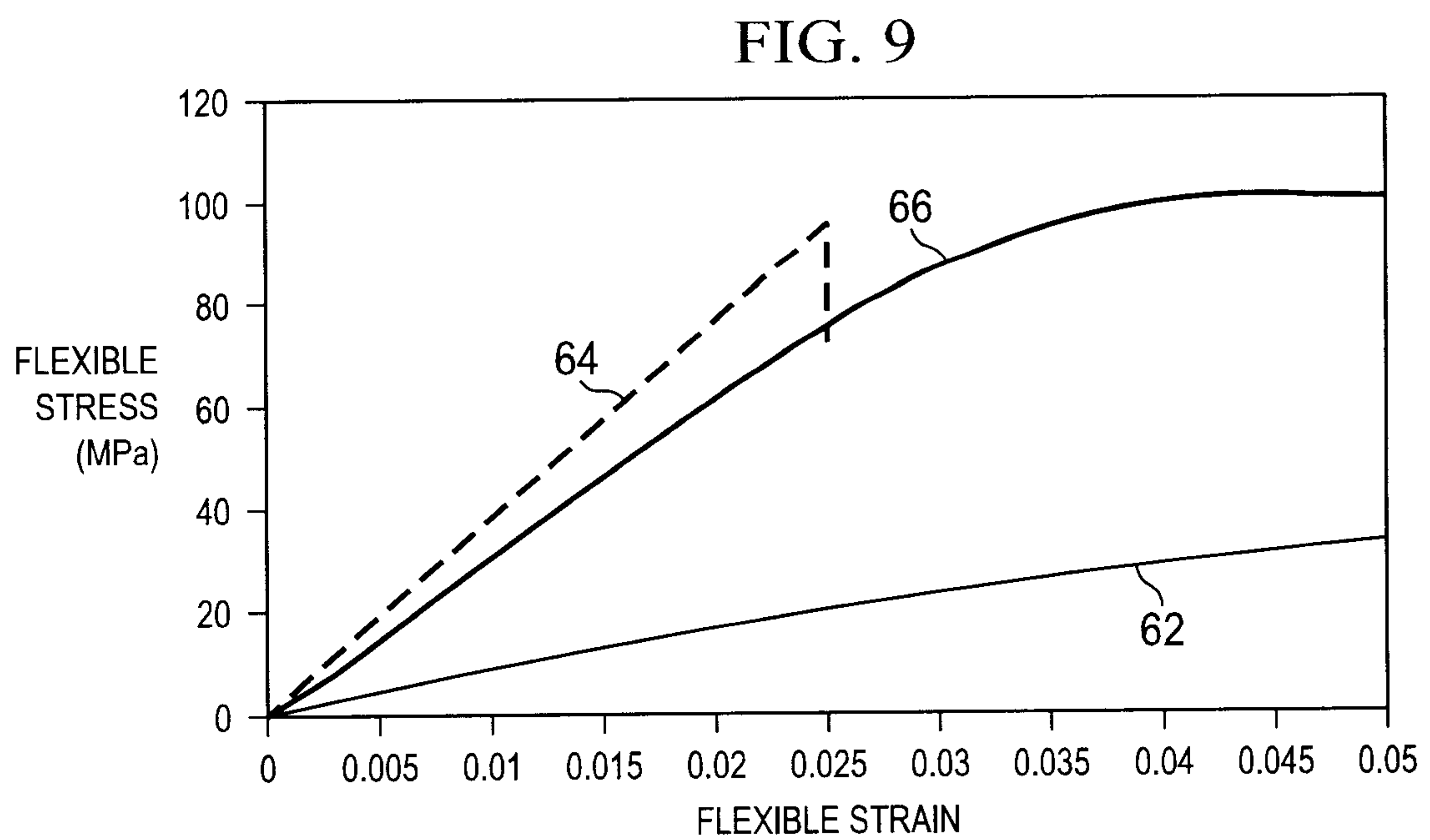
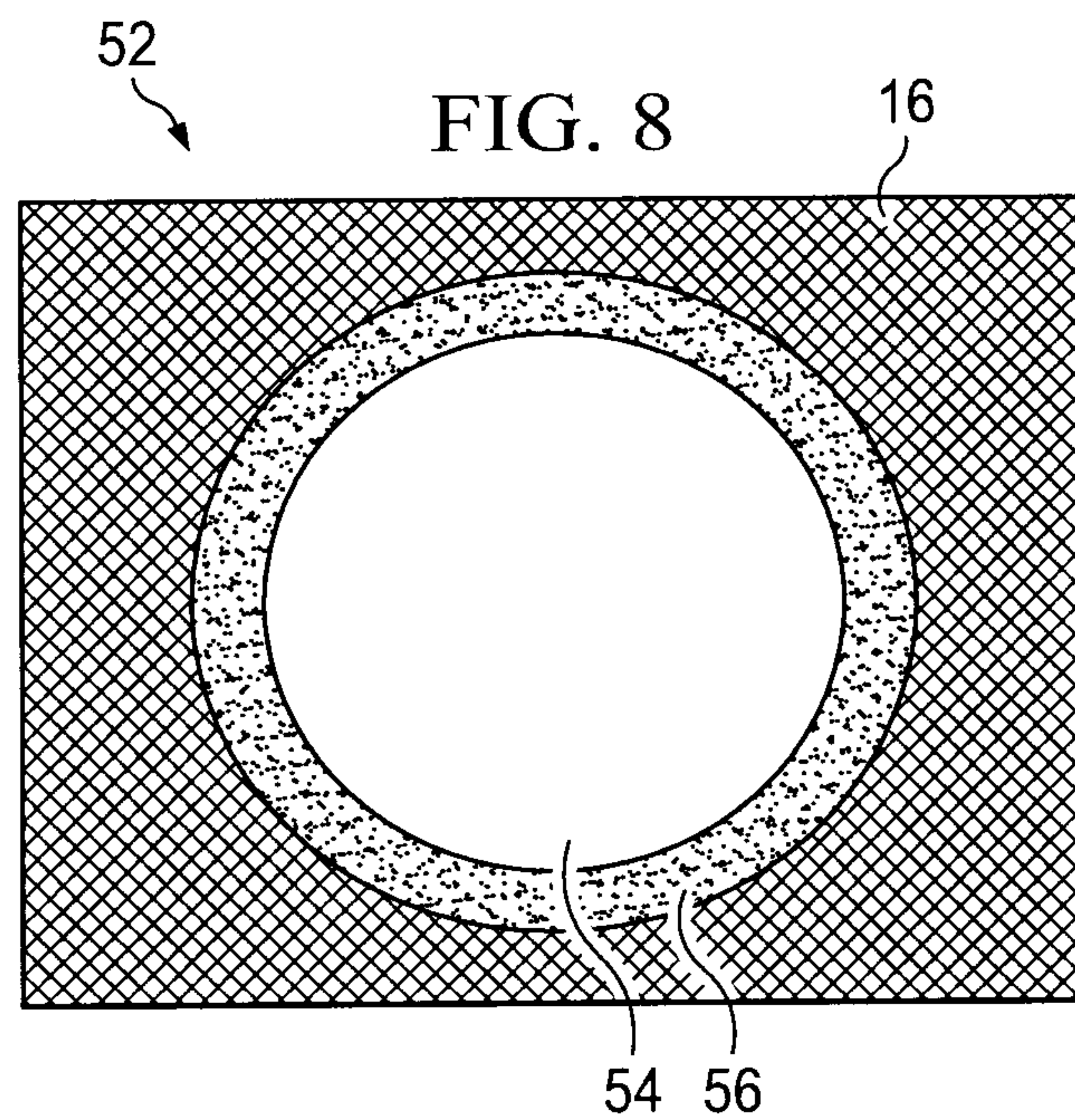
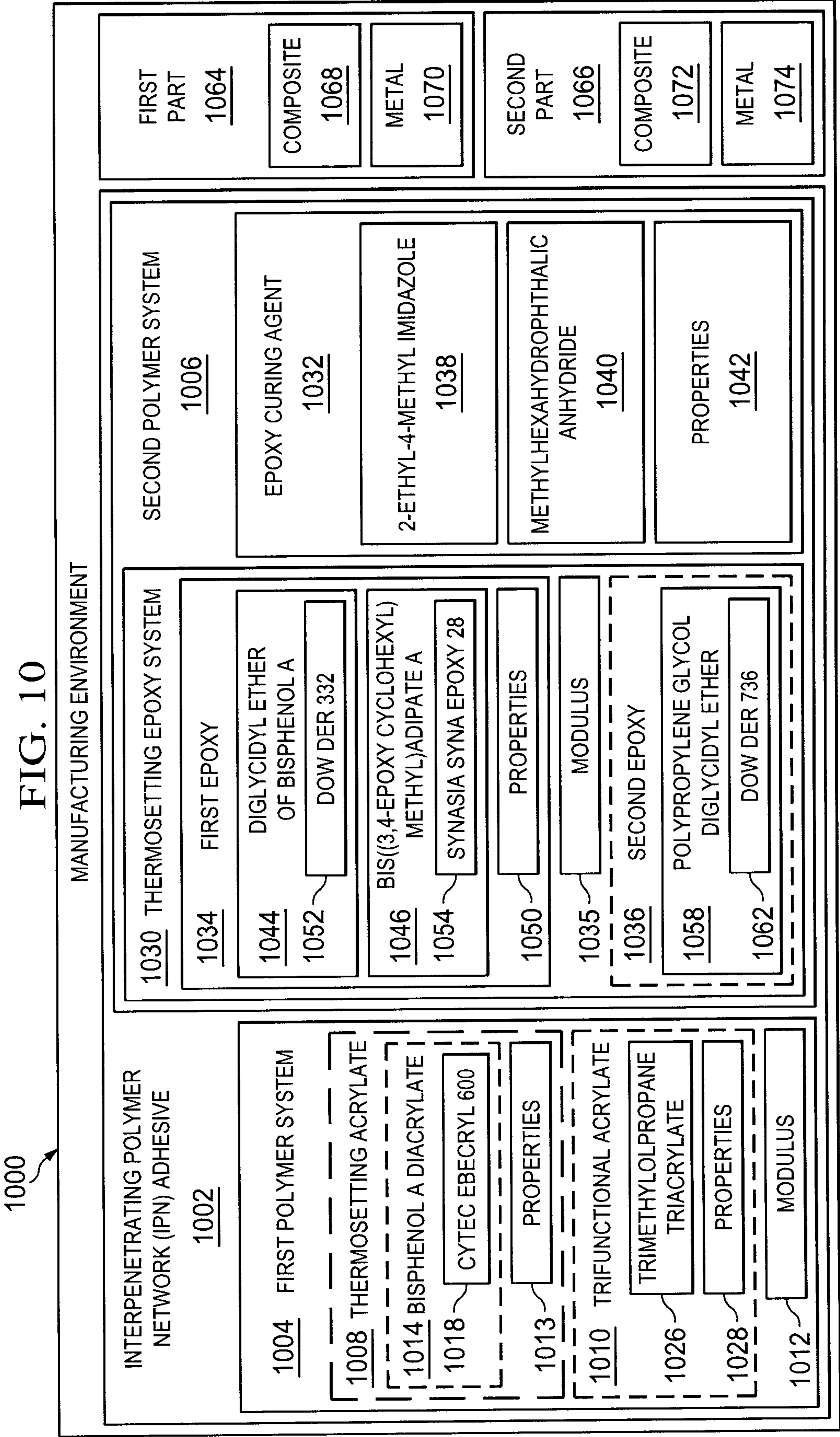


FIG. 7

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FIG. 11

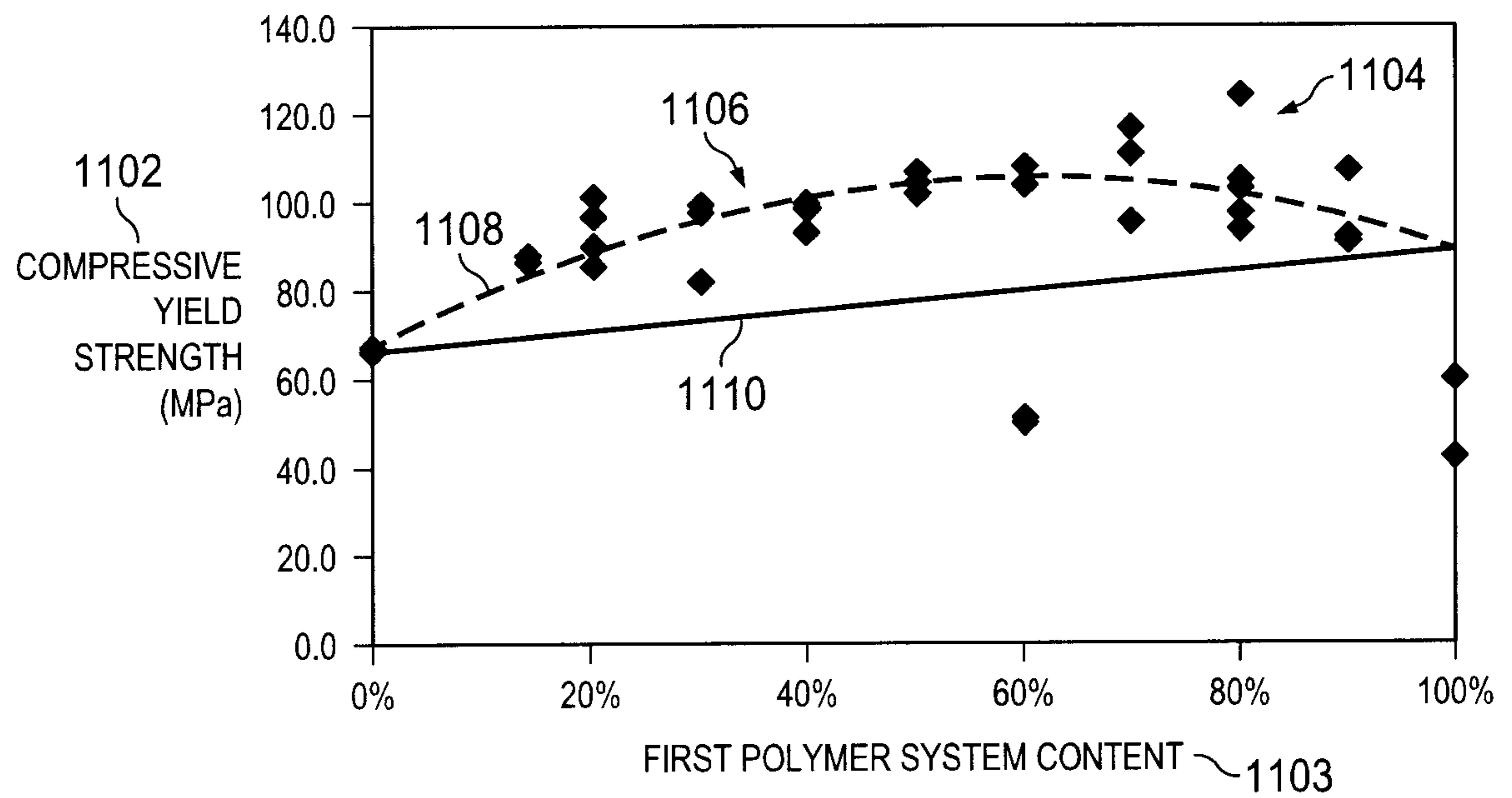
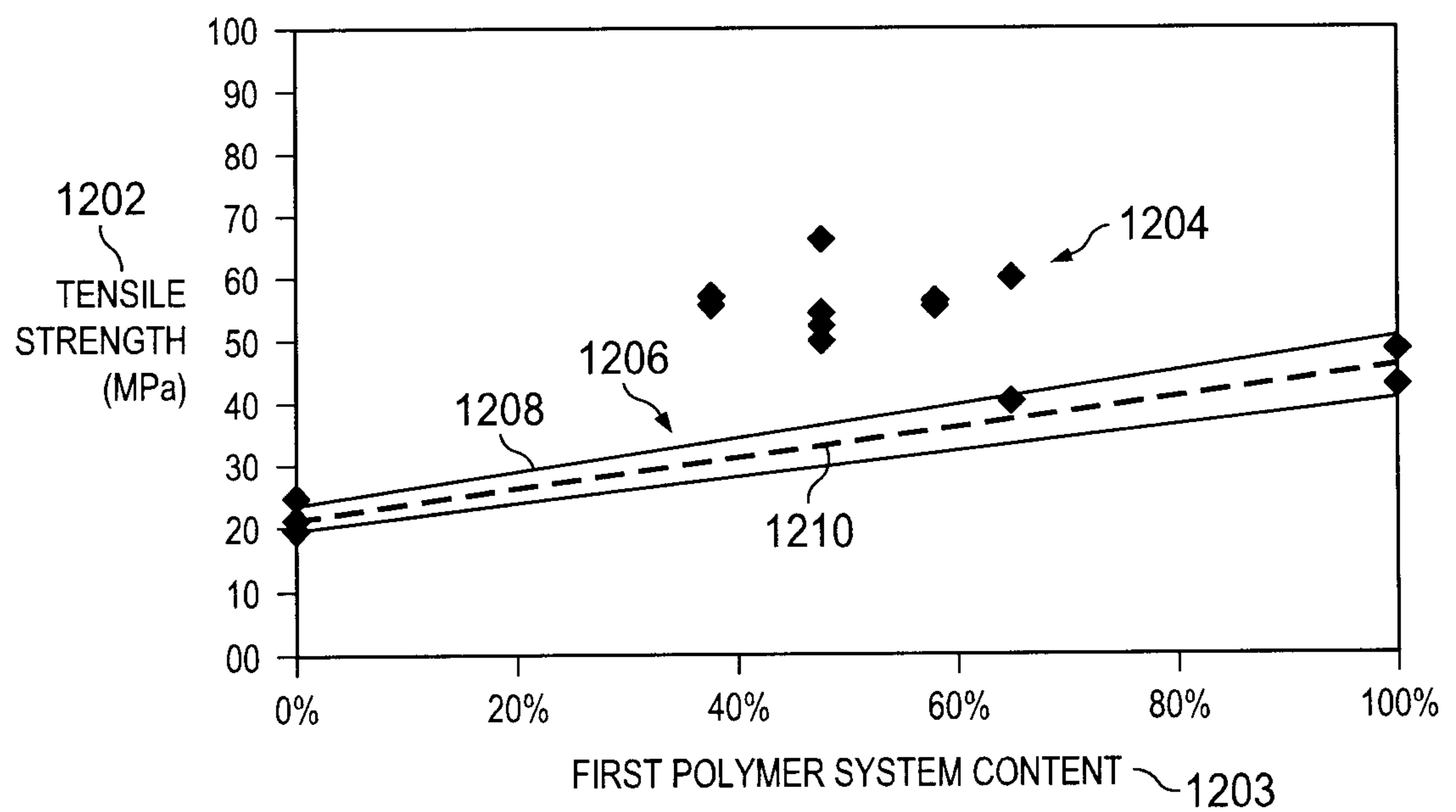
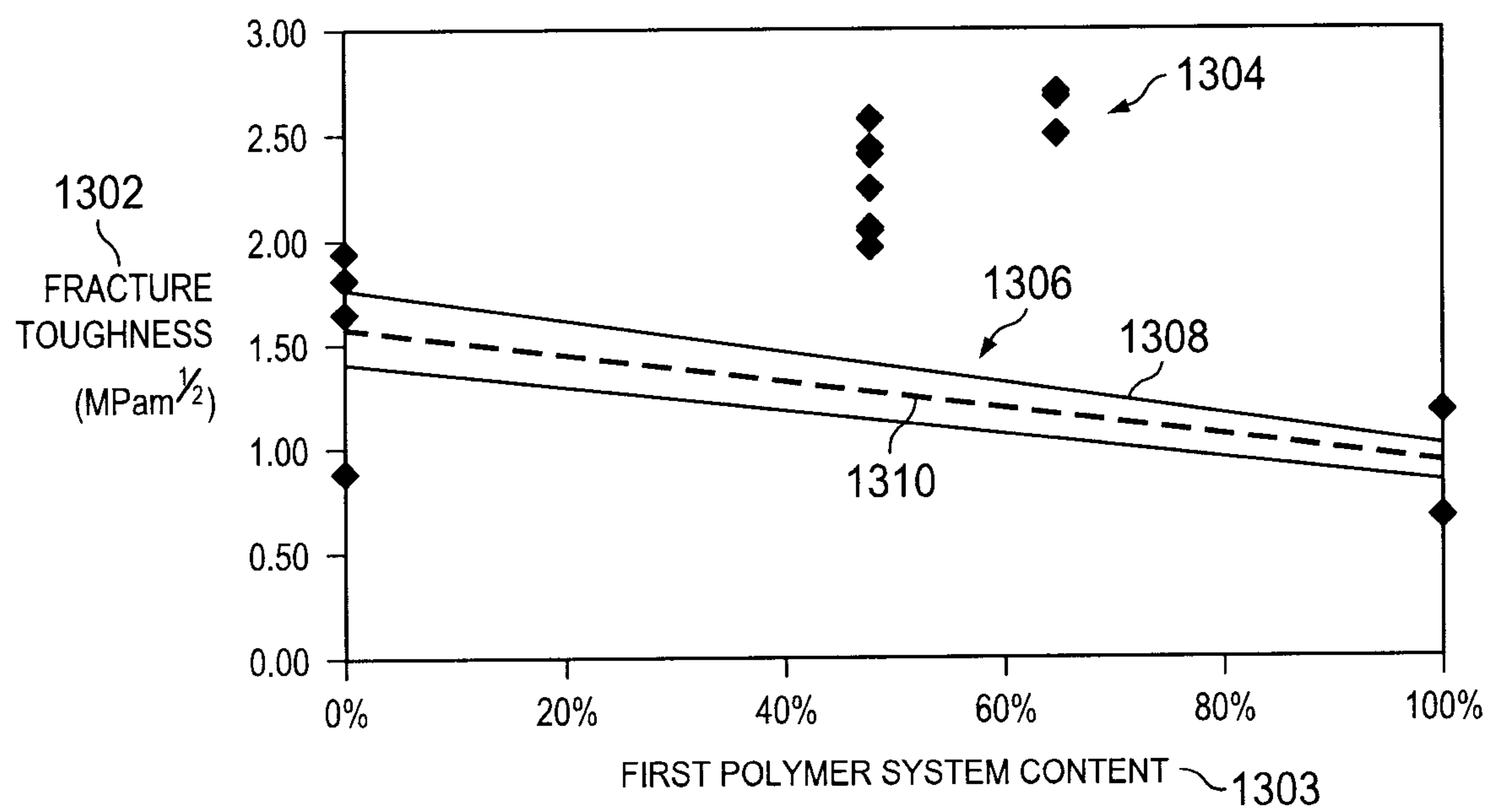


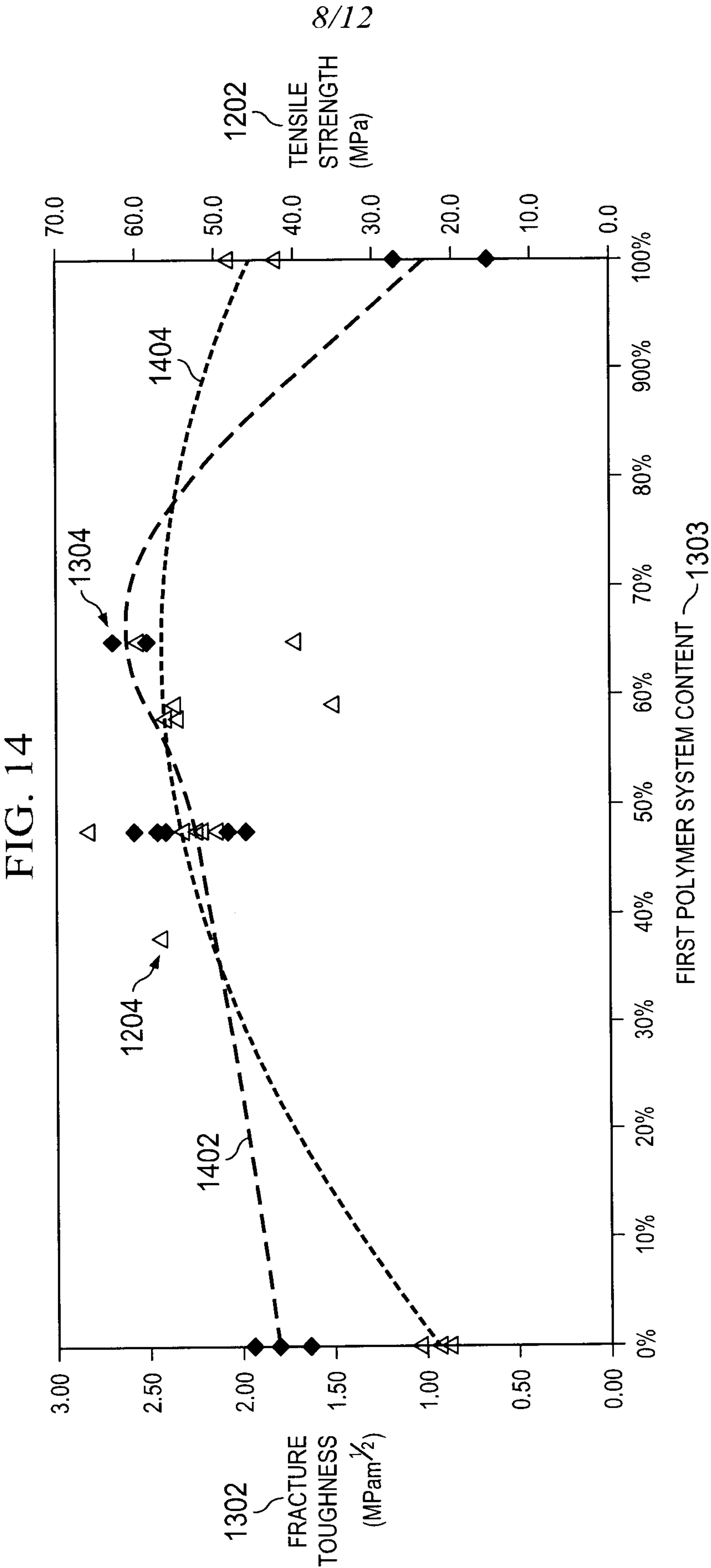
FIG. 12



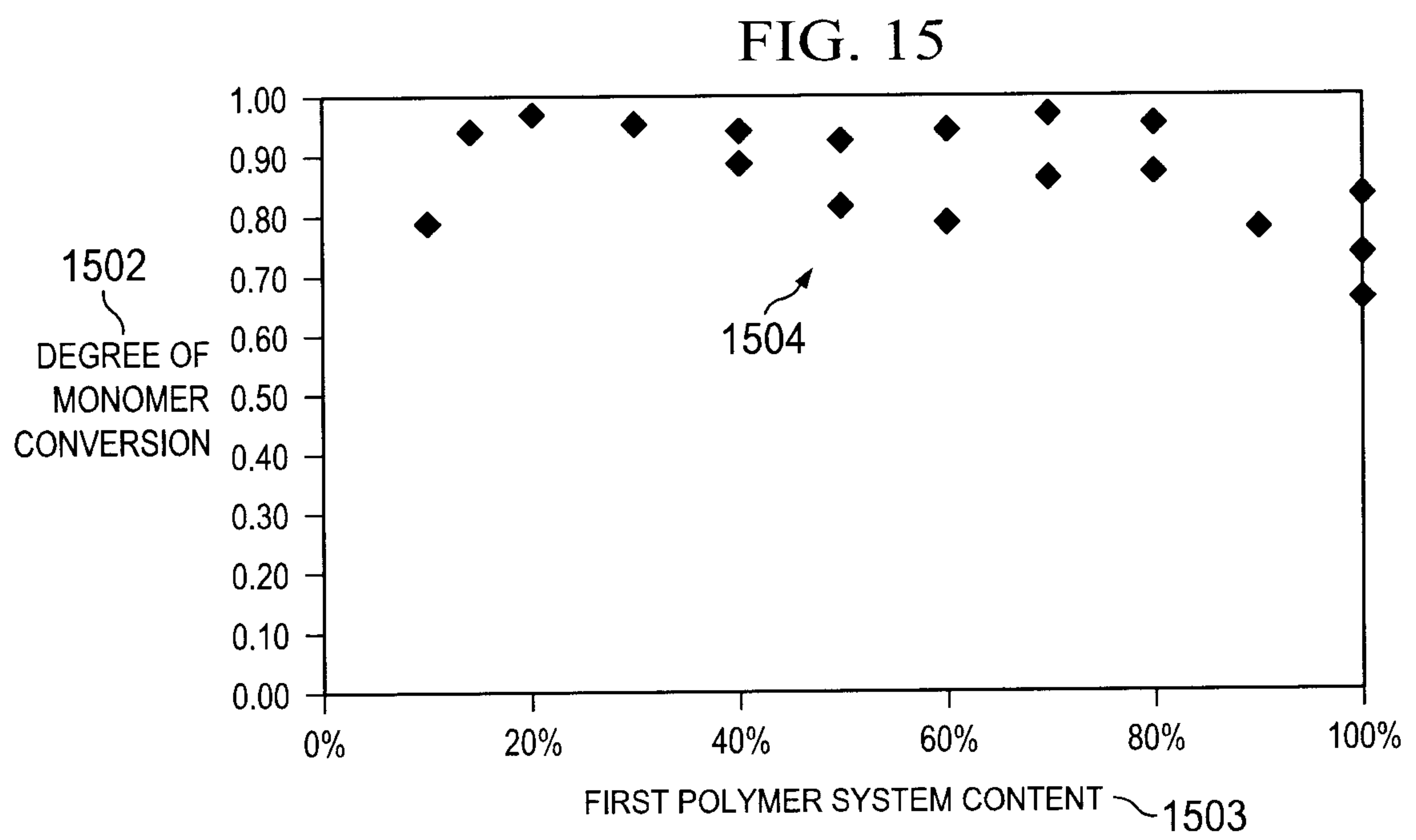
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FIG. 13





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FIG. 16

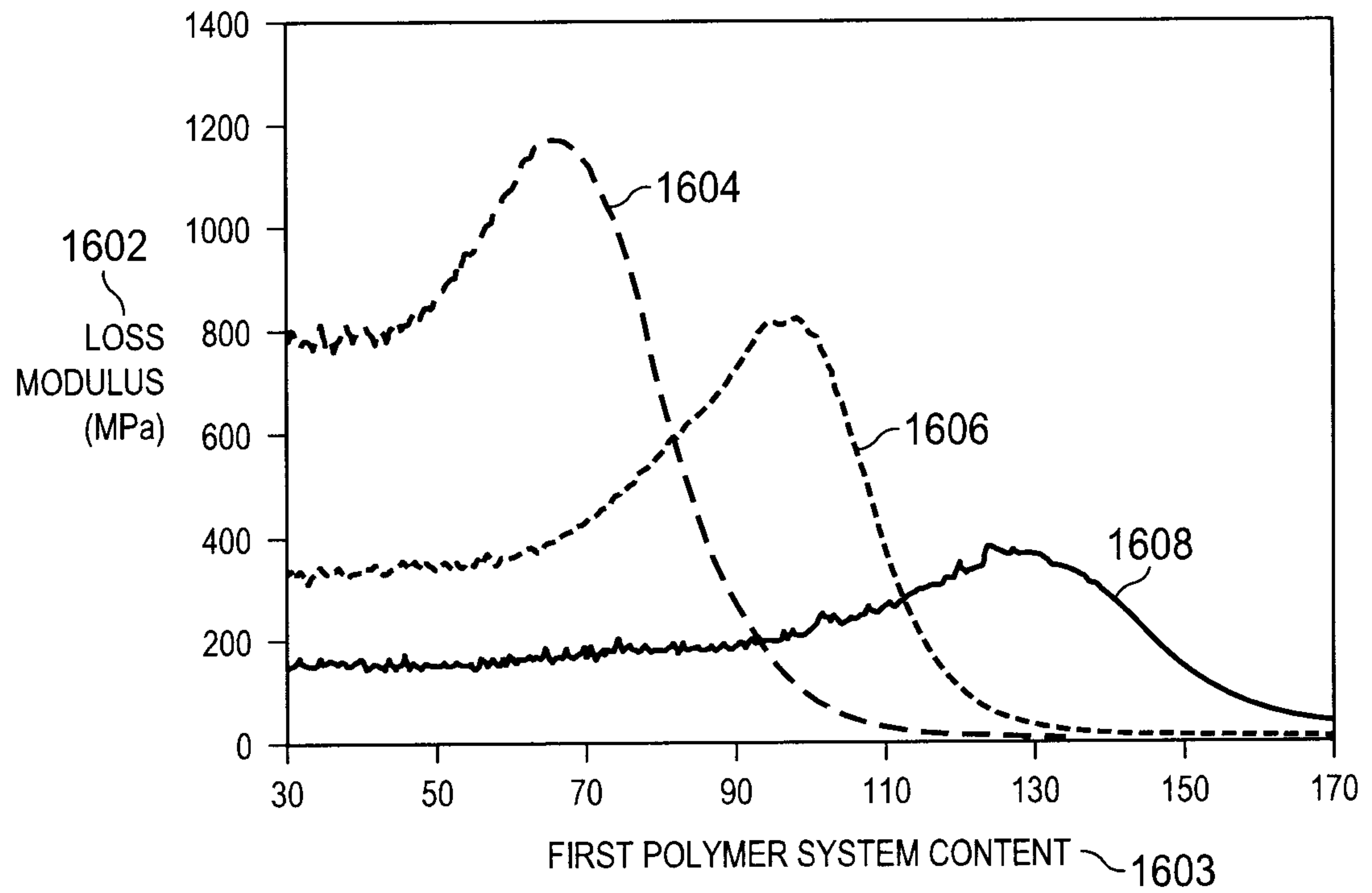


FIG. 17

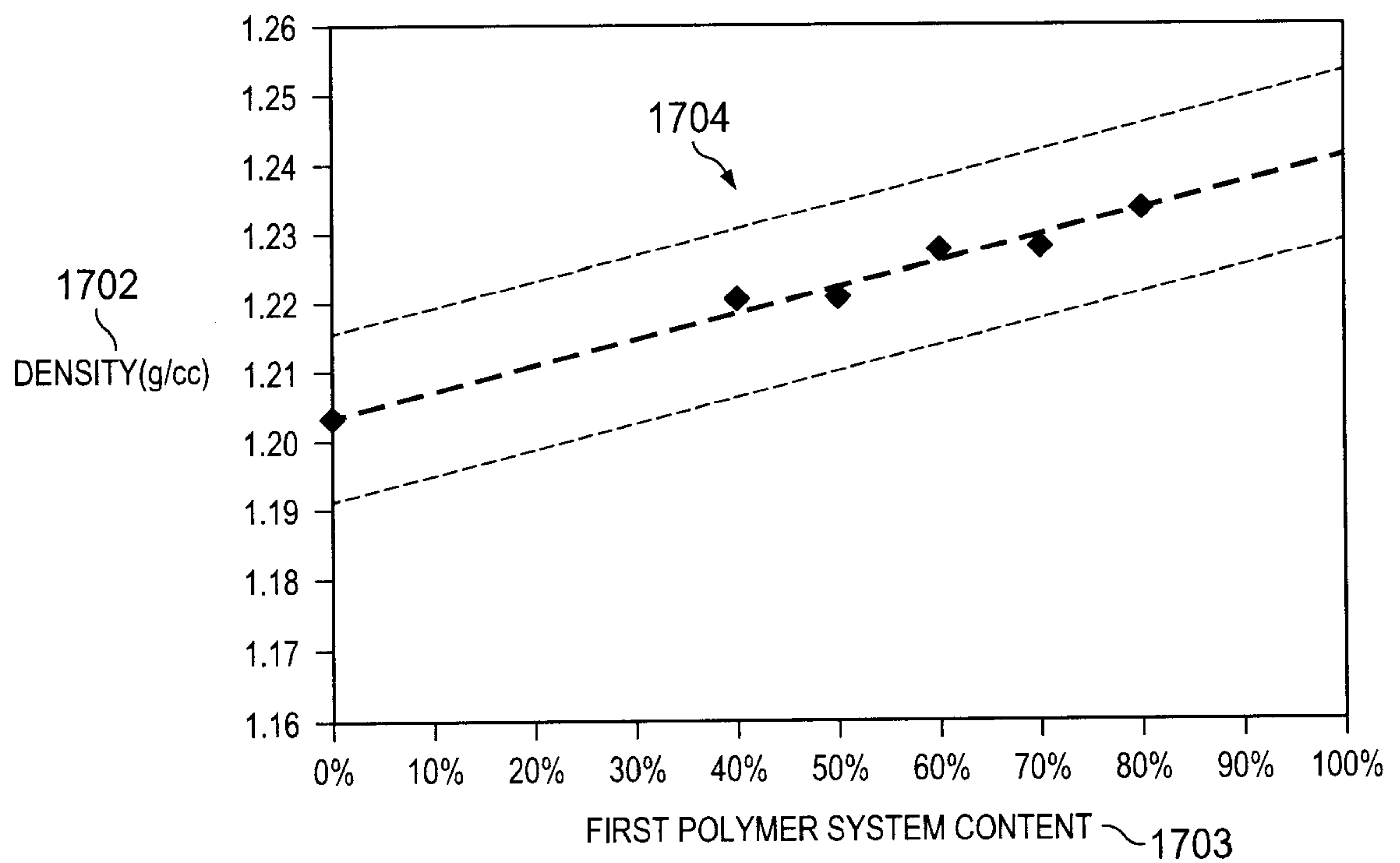
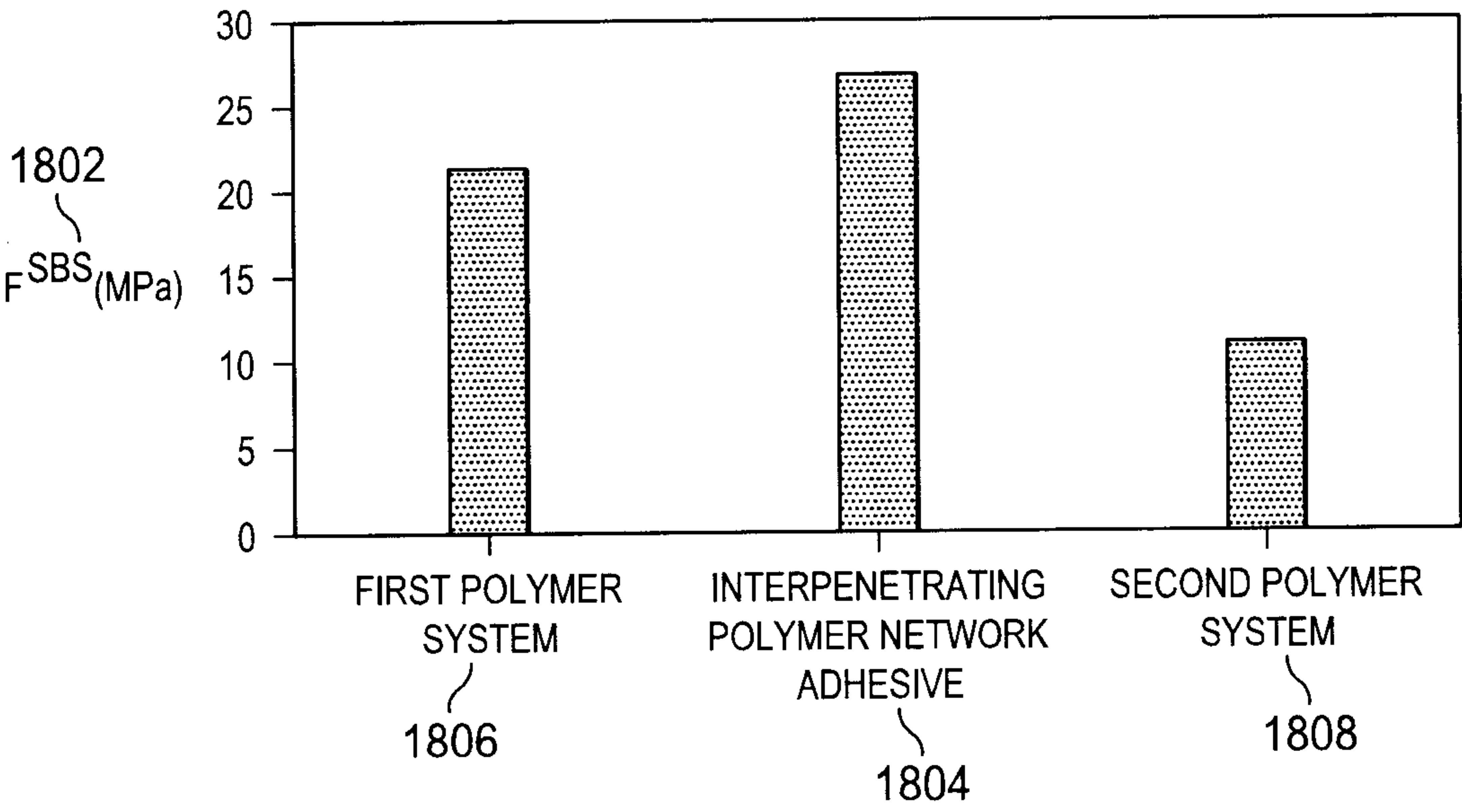


FIG. 18



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