

DESCRIPTION

Production of composite tooling and structures by the usual impregnation methods (infusion, wet-lay-up).

PROPERTIES

- Thermal resistance up to 200°C
- Low viscosity
- Good wetting of reinforcements
- Fast impregnation

PHYSICAL PROPERTIES				
Composition		EPOLAM 2090 RESIN	EPOLAM 2026 HARDENER	MIXED
Mix ratio by weight		100	53	
Mix ratio by volume at 25°C		100	65	
Aspect		liquid	liquid	liquid
Color		amber	colorless	amber
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT	1,600	100	650
Specific gravity at 25°C	ISO 1675 : 1985	1.16	0.95	-
Specific gravity of cured product at 23°C	ISO 2781 : 1996	-	-	1.14
Pot life at 25°C on 150 g (min)	Gel Timer TECAM	-	-	1,500

MECHANICAL PROPERTIES at 23°C ⁽¹⁾			
Flexural modulus	ISO 178 :2001	MPa	2,800
Flexural strength	ISO 178 :2001	MPa	50
Glass temperature transition (T _g)	ISO 11359 : 2002	°C	205

(1) : Average values obtained on standardized specimens.

Hardening 1 hour at 60°C, 1 hour at 80°C, 2 hours at 120°C and 4 hours at 180°C.

These values were obtained on the pure resin (without reinforcement).

PROCESSING CONDITIONS

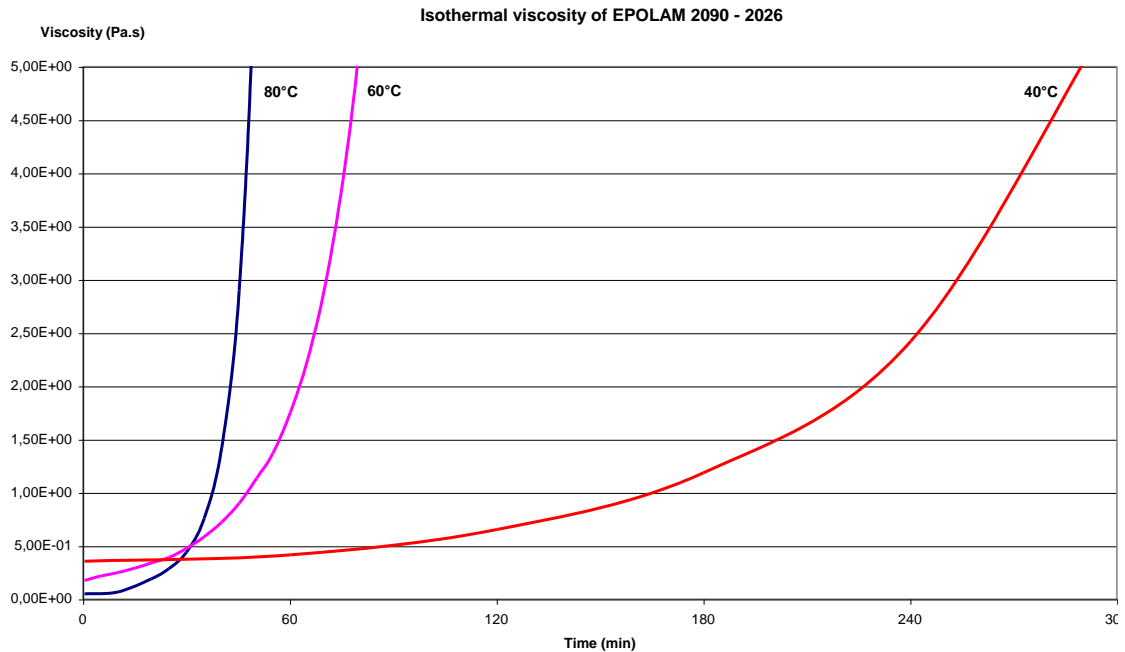
LAMINATING : After mixing according to the indicated ratio carry out impregnation of the reinforcements.
Then cure 24 hours at 40°C.

THERMAL TREATMENT

In order to avoid any risk of distortion or tooling shrinkage a precise curing cycle is to be observed.

Reminder : demoulding takes place only after a 24 hours pre-curing at 40°C. A conformer is recommended for complex shapes. Then the following thermal treatment can be carried out : 1 hour at 60°C, 1 hour at 80°C, 2 hours at 120°C and 4 hours at 180°C and observe an increase and a decrease in temperature of 20°C per hour between stages.

VISCOSITY PROFILE



HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products : ensure good ventilation, wear goggles, safety glasses and waterproof clothes.
For further information, please consult the product safety data sheet.

STORAGE CONDITIONS

Shelf life is 6 months for the share resin at a storage temperature between 8°C and 20°C, and 9 months for a storage temperature under 8°C. Shelf life for the share hardener is 24 months at a storage temperature between 15°C and 25°C. Both parts have to be stored safe from moisture and in their unopened container of origin. Opened containers must carefully be closed safe from moisture under inert and dry gas cover (dry air, nitrogen, etc).

Disclaimer

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