



## Epoxy system hand lamination-room temp. curing

All-round handlamination systems

Improved thixotropy, increased adhesion to metal, composites and other substrates.

All curing agents within the range can be intermixed in order to obtain customer specific pot-life.

B-Cure 50 curing agents cures well at low temperatures and are therefore very suitable when no post curing is possible.

In high humidity conditions can blushing occur – use peel-ply if so.

<b>A-Pox 3000H</b>	<b>B-Cure 50 fast</b>	<b>B-Cure 50 medium</b>	<b>B-Cure 50 slow</b>
Mixing ratio by weight	100:50	100:50	100:50
Viscosity of mixture: (at 23 C)	1000-1800 mPas	1000-1800 mPas	1000-1800 mPas
Time to gelation min (23°C-350g.)	20-25min	40-50 min	65-75 min
Min. cure temp °C	8	8	8
Thin film set-time RT	4h	6h	10h
Elong to break %	3-4%	4-5 %	4-5 %
Adhesion	+++	+++	+++
Tg – DSC *)	~60°C	~60°C	~60°C

\*) after 6h curing at 45gr.C



## Epoxy system hand lamination – post curing (medium Tg)

The system is an easy applicable lamination system which exhibits excellent mechanical properties. The system includes 3 different hardeners, which can be intermixed for customer specific pot-life. Curing will take place at temperatures down to +15 C and will provide good mechanical properties after 24 – 48 hours of curing at normal ambient temperature. It is recommended that the system is post cured at +40 dg.C for a min of 8h, which in return will ensure excellent mechanical and chemical resistance properties.

<b>A-Pox 3000H</b>	<b>B-Cure 32 fast</b>	<b>B-Cure 32 medium</b>	<b>B-Cure 32 slow</b>
Mixing ratio by weight	100:32	100:32	100:32
Mixing ratio by volume	100:36	100:36	100:36
Viscosity of mixture: (at 23 C)	1000-1800 mPas	1000-1800 mPas	1000-1800 mPas
Time to 50 C min (350g/23 C)	50-70	120-140	200-230
Thin film set-time Minimum .	Ca. 4 H	Ca. 6 H	Ca. 8 H
Min. cure temp	15 dgC	15 dgC	15 dgC
Tg – DSC (*) oC	Ca. 90	Ca. 90	Ca. 90

(\*): DSC at 2'nd run after 30 C - 180 C with 10 C pr. min.



## Epoxy system vacuum infusion - post curing (medium Tg)

The system is based upon a high quality BPA/F blend, modified for reduced viscosity and increased wetting properties. Curing agents are developed for the infusion process. Based upon long experience with vacuum- and RTM process, and designed to give best possible combination of strength and good processability.

As always it is an advantage using heated moulds and preheated epoxy for infusion, thus reducing viscosity - typically to 30°C. It is recommended to post cure at min 50 dgC for a min of 10 H, which in return will ensure excellent mechanical and chemical resistance properties.

Post curing at elevated temperatures for a min of 24 H is essential when applying the slow hardeners.

<b>A-Pox 900</b>	<b>B-Cure 32 Fast</b>	<b>B-Cure 32 Medium</b>	<b>B-Cure 32 Slow</b>
Mixing ratio by weight	100:32	100:32	100:32
Mixing ratio by volume	38:100	38:100	38:100
Viscosity of mixture: (at 23 C)	250-350 mPas	250-350 mPas	250-350 mPas
Time to 50 C min (23 C 200 g).	50-70	100-125	200-230
Time to peak min (23 C 200 g)	60-80	120-140	220-240
Thin film set-time Minimum .	Ca. 6 H	Ca. 8 H	Ca. 12 H
Min. cure temp	15 dgC	15 dgC	15 dgC

<b>Curing agent</b>	<b>INF 32 FAST</b>	<b>INF 32 MEDIUM</b>	<b>INF 32 SLOW</b>
Tg – DSC (*) oC	Ca. 90	Ca. 90	Ca. 90

(\*): DSC at 2<sup>nd</sup> run after 30 C - 180 C with 10 C pr. min.



## Epoxy system UV-Resistant surfaces

Where a long lasting, clear and strong UV surface is desirable, this is a perfect match. This system has even high Tg and high chemical resistance. Low priced.

	UV resistant system for coatings, surface lamination etc.
A-Pox 400	B-Cure 24
Mix-ratio by weight	100:29
Viscosity mixed	100-200 mPas
Gel-time 23°C-200g.	600-800 min.
Min. Cure temp °C	20°C
E-modulus	28 - 3000
Elongation to break %	4-5%
Max Tg	70-85°C
Chemical resistance (1-5)	5

Notice. System must be cured at +40 degr.C at 4-5h before demoulding and postcured at +40 degr.C 6-8h.



## Epoxy system Medium temp.tooling

System for tooling. Typical tools for windturbine blades, hulls, automotive etc. Very good wetting properties.

	Tooling
A-Pox 900	B-Cure 24
Mix-ratio by weight	100:27
Viscosity mixed	275-400 mPas
Gel-time 23°C-200g.	120-140 min.
Min. Cure temp °C	20°C
E-modulus	29 - 3100
Elongation to break %	4-5%
Tensile Strength	65-75 Mpa

Notice. System must be cured at +40 degr.C at 4-5h before demoulding

Postcured at 12h/100 degr.C : Tg midpoint 122-126 degr.C

Postcured at 12h/120 degr.C : Tg midpoint 126-130 degr.C