

APPLICATIONS

EPOLAM 2035 resin / 2025 hardener allows the production of composite moulds and structures by infusion methods.

PROPERTIES

- High thermal resistance
- Good chemical resistance
- High thickness laminates

PHYSICAL PROPERTIES				
		RESIN EPOLAM 2035	HARDENER EPOLAM 2025	MIXING
Mixing ratio by weight		100	27	
Aspect		liquid	liquid	liquid
Colour		light amber	blue	blue
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT	1,300	18	400
Density at 25°C	ISO 1675 : 1985	1.15	0.92	-
Density at 23°C of the cured product	ISO 2781 : 1996	-	-	1.12
Pot life (500 g) at 25°C (min)	Gel Timer TECAM			105

MECHANICAL AND THERMAL PROPERTIES AT 23°C (1) (2)			
Glass transition temperature (tg)	ISO 11359 : 2002	°C	130
Flexural modulus	ISO 178 :2001	MPa	2,800
Flexural strength	ISO 178 :2001	MPa	108
Tensile modulus	ISO 527 :1993	MPa	3,100
Tensile strength	ISO 527 :1993	MPa	72
Elongation at break	ISO 527 :1993	%	4
Hardness	ISO 868 :2003	Shore D15	83
Coefficient of thermal expansion (CTE) (+30°C to +110°C)	ISO 11359 : 1999	10 ⁻⁶ K ⁻¹	62

(1) Average values obtained on standard specimens / Hardening 16 hrs at 120 °C

(2) These values have been determined on the pure resin (without reinforcement)

PRECAUTIONS

Normal health and safety precautions should be observed when handling these products :

- ensure good ventilation
- wear gloves and safety glasses

For further information, please consult the product safety data sheet.

PROCESSING

After mixing according to the indicated ratio impregnate the reinforcement according to the infusion process. Hardening takes place 16 hours at room temperature.

Place a thermo-couple between the laminate and the pattern at 50 mm of the border. Bring the whole set laminate + pattern at 45°C. Hold the temperature for at least 2 hours. Bring the laminate down to room temperature at 20°C/hr prior to demoulding.

Postcure to the following schedule with a temperature gradient of 30°C/hr:

- 2 hours at 60°C
- 2 hours at 80°C
- 2 hours at 100°C
- 3 hours at 120°C
- let cool at maximum rate of 30°C/hr

For any further information concerning the Resin Infusion Method and peripheral products provided by Axson, please contact our Technical Support Department.

REMARKS

Laminates thickness must not be over 12 mm.

STORAGE

Use within **24 months** of the manufacturing date. Expiry date indicated on the packaging.

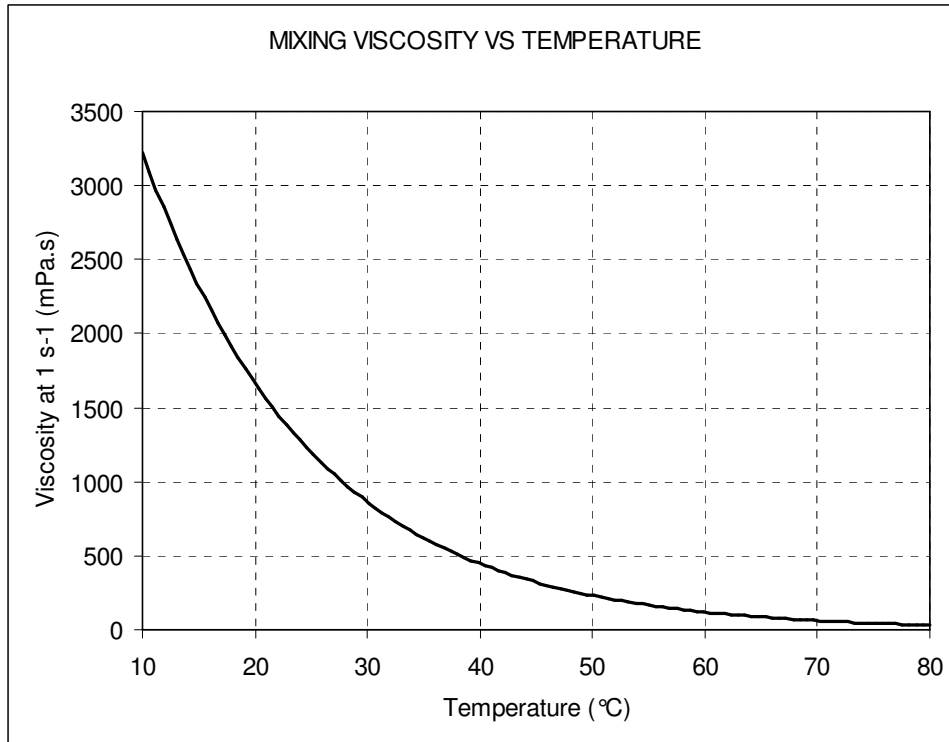
PACKAGING

EPOLAM 2035 RESIN	EPOLAM 2025 HARDENER
1 x 5.2 kg	1 x 1.4 kg
1 x 20.8 kg	1 x 5.6 kg

GUARANTEE

The information of our technical data sheet are based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON refuse any guarantee about the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

ANNEX 1



Test machine : Rheometer CVO 100 Bohlin Instruments
Cone-plate system
Gap 150 µm
Shear rate : 1s⁻¹