

## Description

Epoxy foaming system SV 60 is composed of three components:

component A-epoxy resin

component B-hardener

component C-foaming additive

Epoxy foaming system is intended mainly for laminate manufacturing. It can be applied separately or combined with other foams used as sandwich core, such as expanded polystyrene, polyurethane foam, PVC foam or acrylic foam.

## Application

Epoxy foaming system can be applied for production of:

-sailboards, boats and sport equipment

-aircraft parts

-in automotive industry and parts for bus production

Foaming system can be applied either manually or by automatic device. Temperature resistance of cured foam is 80°C.

## Technical data

### A. Resin

Properties of uncured resin

Property	Norm (method)	Characteristic
Visual aspect		colorless to light yellowish liquid
Density at 20°C	ISO 1675/CSN 656 199	1,16 ± 0,01 g/cm <sup>3</sup>
Viscosity at 25°C	method cone-board	9-13 Pa.s
Epoxy equivalent		0,53-0,56

### B. Hardener

Properties of hardener

Property	Norm (method)	Charakteristic
Visual aspect		blue to greenish transparent liquid
Hydrogen equivalent		63

### C. Additive

Density at 20°C	ISO 1675/CSN 656 199	1,0 g/cm <sup>3</sup>
Viscosity at 25°C	method cone-board	25-35 Pa.s

## Processing

Mixing ratio by weight of resin and hardener: 100:35.

Before adding hardener it is necessary mix the foam additive into the resin. Because additive is not soluble in resin, the mixing has to be done very carefully. Quality of mixing has major role in final properties of cured foam. The storage period of mixed resin with additive is approximately 2 weeks.

Foaming quantity depends on big amount of factors and therefore the dosing of foaming additive is best to set experimentally for each product individually. Usually the range of dosing of additive on resin is from 100:1 to 100:3. Maximally it can be 100:5.



# TECHNICAL DATA SHEET

The foam with density below 200 kg/m<sup>3</sup> hasn't good mechanical properties and therefore usual density of foam should be in range 200-800 kg/m<sup>3</sup>.

Because the liquidity of mixed foaming compound (all of three components) isn't high, it is necessary to spread well the compound all over of surface of a part.

In case of application foaming mixture on polyester gelcoat it is necessary to do the adhesion test before. Unsuitable combination can cause separating of gelcoat, producing bubbles or cracks.

The pot-life of mixed compound (in 100 g) is 50-60 min. It depends on the amount of mixed compound and temperature too.

Curing:

- a) 24 hours at 20°C and postcuring 1 hour at 60°C
- b) 2 hours at 60°C

Approximate properties of cured foam:

Density (g/cm <sup>3</sup> )	0,20	0,30
Flexural strength (N/mm <sup>2</sup> )	3-3,5	6-6,5

## Packing

Components are supplied in 5, 10 and 20 kg cans and 200 kg barrels.

## Storage

1 year rok storing in dry place at temperature 20 - 25°C in original sealed containers.

## Safety during processing:

see Safety sheet

## Producer and Supplier:

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