

Description

The lamination systems intended to be used for laminating of materials from glass, carbon, or Kevlar fibres. Letoxit PR 220 resin is produced on the basis of modified epoxy resin of dian type. Products from this resin are according to FAR 23 and DIN 4102/B1. The resin is suitable for applications where is lower flammability of final product required.

The resin is considered to be physiologically well compatible. Hardeners are of amin type and do not contain nonylphenol. Due to the resin's low viscosity and thereby also lower interfacial tension it shows good wetting ability of lamination textiles and materials when combined in mixture with the Letoxit EM 315, EM 316, EM 317 hardening agents.

Application

Lamination compounds are intended to be used for production of components stressed in extreme conditions, e.g. aircraft and sail plane components, components for construction of models, gliders, construction of sporting boats, transport vehicle bodies, forms etc. Lamination compounds are suitable for all types of manufacturing, such as manual laminating, winding as well as when using pressure or vacuum.

The optimum processing temperature of mixture lies in temperature range between 20 – 25°C. A higher processing temperature is also possible, but it shortens the pot-life of the compounds. Each hardener has got the same mixing ratio, therefore the hardeners can be combined by any way. This possibility enables to find optimal laminating system for various processing method. There is possible to take laminated part out of a mould after initiative curing for following working. Non-tacky, high-gloss surfaces are obtained even with unfavorable curing conditions such as lower temperatures or high relative humidity.

The mixture ratio must be followed as precisely as possible. Higher or lower dosage of the hardener does not result in acceleration or deceleration of the reaction, but leads to imperfect hardening and thereby also deterioration of mechanical properties. The mixture must be carried out properly. Mix it so long until the compound has no uniform transparent color and until there are no unstirred hardener „clouds“. Pay special attention to walls and bottom of the vessel.

Laminating systems can be combined together with suitable gel coats, various lacquers and paints (for example based on PUR).

Resin specification

	Norm	Resin Letoxit® PR 223
Density at 25°C (g/cm ³)	PN-5M-11	1,5-1,6
Viscosity at 25°C (mPa.s)	PN-5M-01	800-1000
Epoxy equivalent	PN-5M-20	0,59
Colour/Gardner		max. 6

Hardener specification

	Norm	Hardener Letoxit® EM 315	Hardener Letoxit® EM 316	Hardener Letoxit® EM 317
Density at 25°C	PN-5M-11	0,94-0,97	0,94-0,97	0,93-0,96



APPLICATION METHOD

Letoxit® PR 223

Letoxit® EM 315, 316, 317

Version: 11/2011

(g/cm ³)				
Viscosity at 25°C (mPa.s)	PN-5M-01	50-100	60-120	100-140
Hydrogen equivalent	-	64	64	64
Amine value (mg KOH/g)	PN-5M-06	480-600	480-530	400-500
Colour	-	transparent blue	transparent blue	transparent blue

Processing details

	Letoxit® PR 223 + Letoxit® EM 315, 316, or 317
Processing temperature	20 – 30 °C
Storage at 15 – 25 °C	minimally 6 months in their carefully sealed original containers
Curing	24 hours at temperature 20-25 °C
Post curing	15 hours at 50-60°C....up to..... 15 minutes at 150°C

Mixture ratio

	Resin Letoxit® PR 223 : hardener Letoxit® EM 315, 316, 317
Parts by weight	100 : 30 ± 1
Parts by volume	100 : 50 ± 1

Mechanical properties of unreinforced resin

Curing: 24 h 25°C 2 h 70°C 6 h 120°C	Norm	Resin Letoxit PR 223 + hardener Letoxit EM 315, EM 316, EM 317
Flexural strength (MPa)	CSN EN ISO 178	120-130
Modulus of elasticity (GPa)	CSN EN ISO 178	3,0-3,4
Impact strength (kJ/m ²)	CSN EN ISO 179	25-35

Packing

Resins and hardeners as well are supplied in PE containers in volume 5, 10 or 20 kg and also in 200 kg drums.