

Basis	general purpose resin
Resin	AH 140
Hardener	LI 60
Colour	yellow transparent

Applications

- Vacuuminfusion of carbon- and glass fibre parts
- Hand lay-up of carbon- and glass fibre parts

Properties

- cures tack free
- high heat resistance

Processing data

Product		Mixture AH 140 / LI 60	Resin AH 140	Hardener LI 60
Colour		yellow transparent	transparent	yellow transparent
Mixing ratio	p. b. w.		100	35
Viscosity at 25°C	mPas	600 ± 75	1000 ± 200	75 ± 10
Density at 20°C	g / cm ³	1,12 ± 0,02	1,17 ± 0,02	0,97 ± 0,03
Pot life 200 g / 20°C	min.	50 - 60	-	-
Curing time at RT	hrs.	20 - 24	-	-
Post curing	Time in h/ Temperature in °C	4 h 60 °C + 6 h 80°C + 4 h 120°C	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	120 ± 10
Flexural strength at breakage	EN ISO 178	%	7,4 ± 0,3
Flexural modulus	EN ISO 178	MPa	3000 ± 250
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	30 ± 5
Compressive strength	EN ISO 604	MPa	85 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	105 ± 3
Glass transition temperature TG	methode DSC	°C	ca. 95
Shore hardness	DIN 53505	Shore D	85 ± 2

Sales units (packages)

Units	Resin AH 140	5,000 kg / 10,000 kg / 25,000 kg / 50,000 kg / 220,000 kg
	hardener LI 60	1,750 kg / 3,500 kg / 25,000 kg / 50,000 kg

Processing instructions

The temperature of the material during the handling should be between 18 and 25°C. Resin and hardener should be mixed intensively at room temperature, avoiding the formation of air bubbles.

The ideal post-curing heating rate is of about 10°C/hour. We recommend the use of fixtures for complex geometries. The ideal cooling rate should be of 20°C/hour.

With a post-curing of 4 h at 60°C + 6 h at 80°C you reach a heat resistance HDT after DIN EN ISO 75 B of 95°C.

At room temperature (20°C), laminates can be demoulded and cut after about 2 days; by post-curing at 40-50°C after about 8 hours.

In General

Opened containers should be rapidly consumed, the hardener LI 60 tends to change in colour becoming brownish in contact with oxygen.

Storing

At appropriate storage 18-25°C.

Occuring crystallization of the resin component due to disadvantageous storage conditions can be made return by warming up the material at approx. 60° C.

Opened containers should be closed immediately after use and be protected against moisture. This material should be used up as soon as possible.

Shelf life is indicated on the labels

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

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