Technical
Datasheet

LH 27 / resin + hardener

Basis	**2 - Component - Epoxy Resin**
Resin	**LH 27 resin**
Hardener	**LH 27 hardener**
Colour	transparent

Applications

- Boatbuilding
- Mould constructions
- Vacuum infusion
- Injection process

Properties

- high temperature resistance
- low viscosity
- excellent wet-out characteristics
- heat curing

Processing data

Product		**Mixture LH 27 / resin + hardener**	**Resin LH 27 resin**	**Hardener LH 27 hardener**
Colour		transparent	transparent	transparent
Mixing ratio	**p. b. w.**		**100**	**32**
Viscosity at 25°C	mPas	500 ± 50	2200 ± 400	80 ± 10
Density at 20°C	g / cm^3	1,10 ± 0,02	1,17 ± 0,02	0,96 ± 0,02
Pot life 100 g / 20°C	min.	210 - 270	-	-
Pot life 500 g / 23°C	min.	-	-	-
Curing time at RT	hrs.	-	-	-
Post curing	Time in h/ Temperature in °C	2 / 75 4 / 160 (unbedingt einhalten)	-	-

Physical data

Properties	**Inspect. requirem.**	**Unit**	**Value**
Flexural strength	EN ISO 178	MPa	135 ± 5
Flexural modulus	EN ISO 178	MPa	2950 ± 250
Flexural strength at breakage	EN ISO 178	%	8 ± 1
Tensile strength	EN ISO 527	MPa	70 ± 5
Compressive strength	EN ISO 604	MPa	80 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m^2	26 ± 5
Heat resistance (Martens)	DIN 53458	°C	117 ± 3
Glass transition temperature TG	TMA	°C	> 150
Shore hardness	DIN 53505	Shore D	87 ± 3

Sales units (packages)

Units	LH 27 resin	can 25 kg / barrel 50 kg / barrel 225 kg / container 1000 kg
	LH 27 hardener	can 8 kg / can 24 kg / barrel 180 kg

Processing instructions

The material- and processing temperature should be between 18°C – 25°C. The resin and hardener should be mixed intensively and bubble-free at room temperature.

For parts which don't require GL-approval, the pot life of the system can be accelerated by mixing the hardener BIV 800 with hardener W 15.
The mixing ratio resin-hardener remains 100 : 30. Pot life table for the mixture with different hardeners on demand.

Before demoulding the part on the mould has to be post cured for some hours at 50 - 60°C to avoid cold brittleness.

Storing

At appropriate storage (room temperature) in closed original container 9 months.
Occurring crystallization, due to disadvantageous storage conditions, can be made return by warming up the material at approx. 60 °C.
Already opened containers should be closed immediately after use and also protected agains moisture. Material should be used as soon as possible.

Safety measure

When processing this product the recommended protection measures of the government safety organization of the chemical industry should be followed. Safety advices should be followed.

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