



TECHNICAL DATA SHEET

Application: High performance composite parts of small and medium size. Manufacturing of structural parts for boats, model aircrafts, racing vehicles, sport components.

Processing: Manual lamination at atmospheric pressure for glass, carbon or kevlar fiber tissue. Room temperature curing. The hardeners can be blended in all proportions to adjust the reactivity of the system to the specific needs. Compared to traditional systems, this one also presents a high capability to post-cure with a moderate heat transfer.
 PetramHR: High reactivity. For small components or as accelerator for other hardeners.
 PetramMR: Medium reactivity. Standard hardener.

Description: High modulus un-filled epoxy system. The curing agent should be selected according to the application. The curing at room temperature plus the post-curing at moderate temperatures (50-60°C) allows high performance. Further stabilization at higher temperatures improves the thermal resistance of the components.

SYSTEM SPECIFICATIONS

Resin					
Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	1.200	1.800
PETRAM HR					
Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	30	80
Gelation time	25°C	IO-10-52a (UNI 8701)	min	15	25
PETRAM MR					
Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	30	60
Gelation time	25°C	IO-10-52a (UNI 8701)	min	50	60

TYPICAL SYSTEM CHARACTERISTICS

Resin					
Resin Colour				Pale/yellow	
Density resin	25°C	IO-10-51 (ASTM D 1475)	g/ml	1,13	1,17
Hardeners			Petram HR		Petram MR
Hardener Colour			Pale/yellow		Pale/yellow
Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	30 80	
Density	25°C	IO-10-51 (ASTM D 1475)	g/ml	1,02 1,06	0,94 0,98
Processing Data					
Mixing ratio by weight		for 100 g resin	g	100:30	100:30
Mixing ratio by volume		for 100 ml resin	ml	100:33	100:36
Pot life	25°C (50mm;200ml)	IO-10-53 (*)	min	12 17	35 45
Exothermic peak	25°C (50mm;200ml)	IO-10-53 (*)	°C	225 250	210 235
Initial mixture viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	400 600	400 600
Gelation time	25°C (1mm)	IO-10-88	h	2 3	5 7
Demoulding time	25°C (15ml;6mm)	(*)	h	4 6	6 8

TYPICAL CURED SYSTEM PROPERTIES

Properties determined on specimens cured: 24 h TA + 15 h 60°C

			Petram HR		Petram MR	
Colour			Pale yellow		Pale yellow	
Machinability			Excellent		Excellent	
Density 25°C	IO-10-54 (ASTM D 792)	g/ml	1,08	1,12	1,08	1,12
Hardness 25°C	IO-10-58 (ASTM D 2240)	Shore D/15	85	89	85	89
Glass transition (Tg)	IO-10-69 (ASTM D 3418)	°C	70	76	85	90
Maximum Tg	IO-10-69 (ASTM D 3418)	°C	77	83	105	110
Water absorption (24h RT)	IO-10-70 (ASTM D 570)	%	0,10	0,20	0,15	0,25
Water absorption (2h 100°C)	IO-10-70 (ASTM D 570)	%	0,60	0,70	0,55	0,65
Max recommended operating temperature	(***)	°C	75		95	
Flexural strength	IO-10-66 (ASTM D 790)	MN/m ²	120	130	120	130
Maximum strain	IO-10-66 (ASTM D 790)	%	4,5	6,5	5,0	7,0
Strain at break	IO-10-66 (ASTM D 790)	%	7,0	9,0	6,0	8,0
Flexural elastic modulus	IO-10-66 (ASTM D 790)	MN/m ²	3.600	4.000	3.400	3.800
Tensile strength	IO-10-63 (ASTM D 638)	MN/m ²	67	75	65	75
Elongation at break	IO-10-63 (ASTM D 638)	%	6,0	8,0	6,0	8,0
Compressive strength	IO-10-72 (ASTM D 695)	MN/m ²	88	98	95	105

nd = not determined na = not applicable RT = TA = laboratory room temperature (23±2°C)

Conversion units: 1 mPas = 1 cPs 1MN/m² = 10 kg/cm² = 1 MPa

(*) for larger quantities pot life is shorter and exothermic peak increases

(**) the brackets mean optionality

(***) The maximum operating temperature is given on the basis of laboratory information available being it function of the curing conditions used and of the type of coupled materials. For further possible information see post-curing paragraph.

Instructions:

Verify and when necessary, homogenize the components before use. Add the appropriate quantity of hardener to the resin, mix carefully. Avoid air trapping. For the surface preparation (mould or model) refer to the release agents data sheet.

Curing / Post-curing:

Post curing is always advisable for RT curing systems in order to stabilize the component and to reach the best mechanical properties, although, this system is able to reach (already at room temperature) a thermal resistance higher than those of traditional systems. If post-cured at a moderate temperature (60°C) it is possible to obtain a good thermal resistance. Curing and post-curing should be carried out before using, the mould as a function of the required thermal resistance. Post cure the tool increasing gradually 10°C/hour.

Users should evaluate the best conditions of curing or post-curing depending on the component size and shape. For big size components decrease the thermal gradient and increase the post-curing time. In the case of thin layer applications and composites, post cure on the jig.

Storage:

Epoxy resins and their hardeners can be stored for two years in the original sealed containers stored in a cool, dry place. The hardeners are moisture sensitive therefore it is good practice to close the vessel immediately after each use.

Handling precautions:

Refer to the safety data sheet and comply with regulations relating to industrial health and waste disposal.

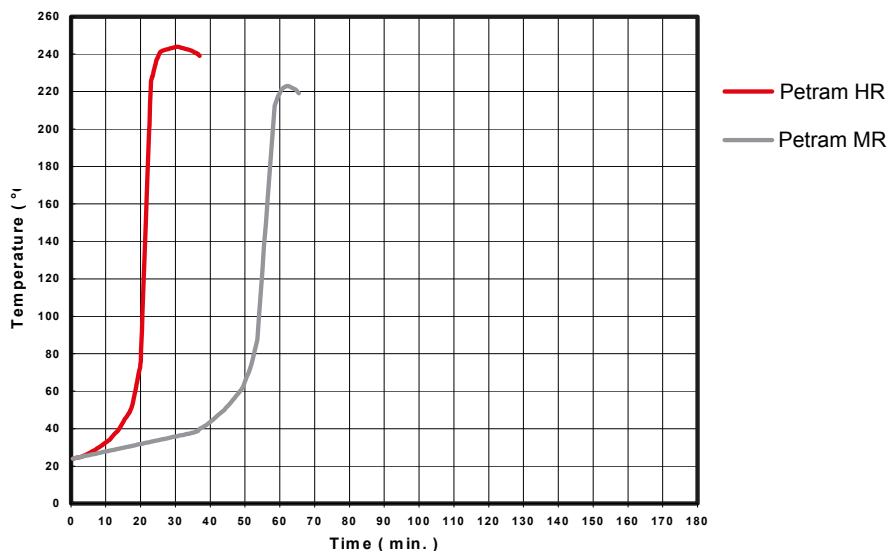
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The information given in this publication is based on the present state of our technical knowledge but buyers and users should make their own assessments of our products under their own application conditions.

Systems properties in wet state

Reactivity Profiles

(200ml system volume, resin / hardener mixing ratio 100:30 at 25° C in air)



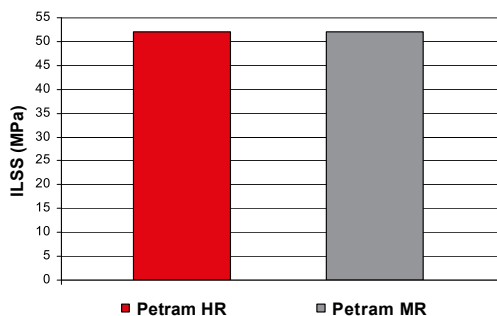
Suggestions for the proper use of the systems with vacuum bag process 2 mm thickness

	PETRAM HR				PETRAM MR			
	15°C	20°C	25°C	30°C	15°C	20°C	25°C	30°C
Maximum time before vacuum application(h)	3	2	1,5	1	7	4	3	2
Gelification time (h)	4-7	n.d.	2-3	n.d.	11-15	n.d.	5-7	n.d.
Minimum time for vacuum release (h)	8	5	3,5	2	16	9	7,5	6,5
Demoulding (h)	9	6	4,5	3	20	12	10	8

N.B. The reported values are derived from lab tests and from the application experience. They must be considered indicative because they are related to the specific size and shape of the components. Buyers and users should make their own assessments of our products under their own application conditions.

Interlaminar shear stress (ILSS) of laminates

(Multiaxial glass 300g/m² Realized with vacuum bag) - ASTM standard D 2344



The laminate has been obtained by hand lay-up of a glass tissue of 300g/m² (Type raso 8) impregnated with the different systems until a final thickness of 5 mm has been obtained.
The test specimens have been prepared according to ASTM D2344 and before testing they were stabilized at 50°C for 16 hours.