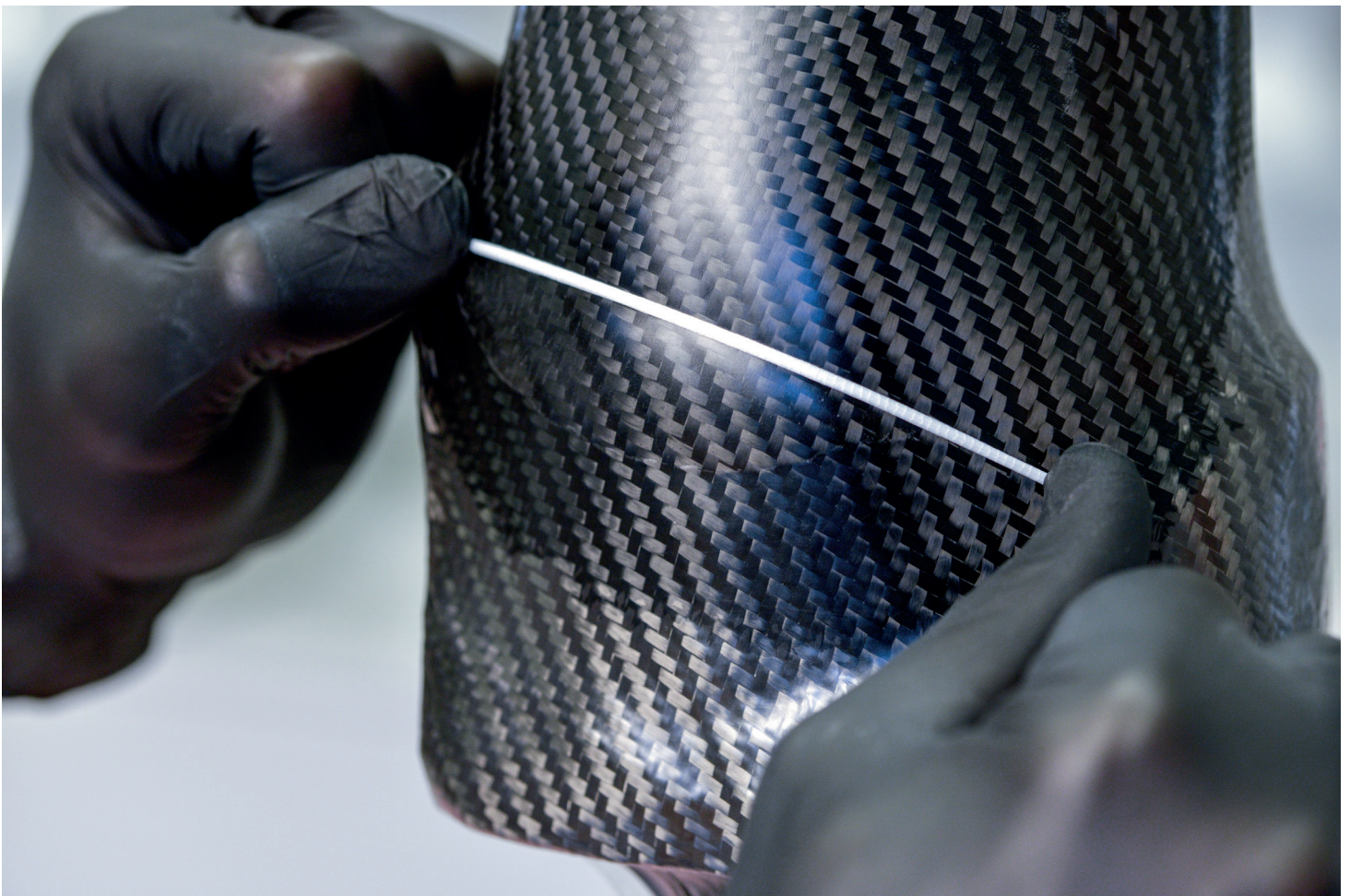


Tips for an optimal result – Processing EpoxiPure (112P80/112P81)



EpoxiPure enables the technician to work comfortably thanks to the careful selection and composition of the ingredients. Our practical processing tips will help you to achieve optimum results.

General

A thin vacuum stocking (95P2) should always be placed between the reinforcement layers and the PVA film to guarantee the direct transport of the resin in the first to the last layers. Due to the perfect matching of the resin to the reinforcing material (C-fibre), there is no need to apply "suction layers" such as Perlon tricot. The EpoxiPure casting resin does not become hot during the curing process, so that insulations on structural parts to be laminated remain in place. Furthermore, no fine gas bubbles form on the construction surface due to the cold curing process. The permanent elasticity and stability is strongly dependent on the shape of the construction as well as the ratio of the fibre to the resin. Generally, resin pockets in the casting should be avoided and excess resin should be removed.

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Mixing

EpoxiPure casting resin is a Duroplast and hardens by polyaddition. This means that the required amount of resin must always be in the correct ratio with the hardener to achieve optimum cross-linking. To do this, use a calibrated digital scale (readability 1 g) and stick to the mixing ratio of 100 g resin : 40 g hardener. Mix the two components in a clean mixing cup using a wooden spatula for at least 3 minutes.

Overlaminat

In order to create a secure bond (adhesion) between the first and second laminate, it is necessary to roughen the surface well with sandpaper (K120) and pre-treat it free of grease (only blow off with compressed air). After overlaminating with EpoxiPure, the plaster seal must be removed before hardening in the oven (annealing).

Time factor

After mixing resin and hardener, a processing time of approx. 45 minutes remains. This value is influenced by the ambient temperature and the quantity of resin used.

Tip:

The rapid, large-area distribution of the EpoxiPure casting resin during the lamination process can extend the so-called pot life. Ensure a room and storage temperature of 18 - 23 °C.

Curing

- Standard: 10 hours at 23 °C room temperature + vacuum -> demouldable -> pre-tempering for optimal sanding 1 hour at 60 °C -> final tempering for stress-free final hardening 1 hour at 100 °C.
- Rapid hardening: After casting under negative pressure 2.5 hours at 60 °C for optimum grinding -> Final tempering for stress-free final hardness
Final tempering for stress-free final hardening 1 hour at 100 °C

Description	Content	Item no.
EpoxiPure casting resin	1,0 kg	112P80/1
EpoxiPure casting resin	5,0 kg	112P80/5
EpoxiPure hardener	400 g	112P81/04
EpoxiPure hardener	2,0 kg	112P81/2

During rapid curing with heat, the resin becomes temporarily more fluid, therefore set the vacuum to max. 0.4 bar. When using a Socket Attachment Block (12A5/-3/-7), a water content in the wood must be taken into account (6 - 10 %). Uncontrolled shrinkage may occur during heat curing of the stock. We therefore recommend the use of metal ingots (16A3 or 16A5).