



Mixed Properties:

Epoxy System		LR120
Pot life (min)	at 25°C on 0.5g	60
Viscosity (mPa.s)	at 25°C	<500
Specific gravity	at 25°C	1.1
Gelation (hr)	at 25°C on 2mm Thickness	3
Demolding time (hr)	at 25°C on 2mm Thickness	8-10

PROCESSING CONDITIONS

This Epoxy System cure completely at room temperature, if required. At this point in the cure, the bag and infusion materials can be removed from the laminate and the part can be sanded or trimmed as required. Full cure will be achieved in 3 to 7 days at normal room temperature. A heat cure will shorten the curing time of System LR120. In situations where the laminate can be placed in an oven after a room temperature gel, curing times of 3 to 8 hours at 80°C or 10 to 12 hours at 100°C will provide 90% of full cured properties.

If necessary, warm and stir until uniform.

MECHANICAL AND THERMAL PROPERTIES at 25°C

Flexural strength	ISO 178	MPa	120
Flexural modulus	ISO 178	MPa	3500
Tensile strength	ISO 527	MPa	70
Tensile modulus	ISO 527	MPa	3300
Elongation at break	ISO 527	%	5
Hardness	ISO 868	Shore D10	86
Glass transition temperature	ISO 11359	°C	100
Deflection temperature	ISO 70	°C	90

(1): Average values obtained on standard specimens @ 24 hr at 25°C + 4 hr at 90°C.

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

*ensure good ventilation

*wear gloves, safety glasses and waterproof clothes.

STORAGE CONDITIONS

*Epoxy System LR120 is slightly hygroscopic and should be stored at room temperature in conditions such that moisture is excluded, in the original containers kept tightly closed. Under these conditions the shelf life should be a minimum of one years from date of certification.

Keep in @22-30°C & humidity<50%