



DESCRIPTION

ProInfusion RT is designed for production of composite structures by infusion or other methods and offers three different hardener choices for variable pot life / working times for consideration of part size and gel time set-up speeds.

APPLICATIONS

- High performance composite tools or parts for marine, and several other industries
- Suitable for infusion processing along with wet-layup, vacuum bagging and RTM processes

PROPERTIES

- High Clarity
- Very Low mixed viscosity
- Variable pot life hardener options (same ratio's)
- R.T. cure and post-cured options
- Excellent ultimate properties
- Hardener blending an option

PHYSICAL PROPERTIES					
Property	Units	ProInfusion Resin	Fast Hardener	Medium hardener	Slow Hardener
Mix ratio – by weight			100/27	100/27	100/27
Mix ratio – by volume			100/32	100/32	100/32
Aspect		Liquid	Liquid	Liquid	Liquid
Color	Visual	Clear	Lt. Amber	Lt. Amber	Lt. Amber
Mixed Viscosity (25°C)	Cps	890	266	250	250
Specific Gravity (25°C)	lbs./gal (g/cc)	9.47 (1.14)	7.89 (.95)	7.82 (.94)	7.85 (.94)
Gel Time (150 g) at 77°F (25°C)	minutes		27.4	96.3	160.5

PROCESSING CONDITIONS

After mixing according to the indicated ratio, carry out impregnation of the reinforcements. To ensure an optimal use and a good impregnation, please use packaging stored at a temperature above 15 ° C.

CURE CONDITIONS

In order to avoid any risk of distortion or tooling shrinkage a precise curing cycle must be observed. Demolding takes place only after a 24 hour R.T. minimum or 16 hour pre-curing at 40°C-60°C. material can be used with R.T. cure only or with some (Post-cure) carried out.



Neat Cured Properties Tested at 74°F (23°C)

	Test Method	Unit(s)	Fast Hardener	Medium Hardener	Slow Hardener
Glass Transition Temperature (Tg) *Cure #1 **Cure #2	ASTM E1545	°F (°C)	133 (56) 183 (84)	124 (51) 178 (81)	144 (62) 171 (77)
Hardness *Cure #1 **Cure #2	ASTM D-2240	Shore D	87 88	86 86	88 84
Flexural Strength *Cure #1 **Cure #2	ASTM D790	psi (MPa)	10,162 (70) 17,278 (119)	7,495 (52) 15,419 (106)	7,815 (54) 15,951 (110)
Flexural Modulus *Cure #1 **Cure #2	ASTM D790	psi (MPa)	487,197 (3,362) 444,808 (3,069)	440,170 (3,037) 419,367 (2,894)	436,836 (3,014) 432,003 (2,981)
Tensile Strength *Cure #1 **Cure #2	ASTM D638	psi (MPa)	5,714 (39) 8,653 (60)	3,665 (25) 7,480 (52)	5,081 (35) 10,263 (71)
Tensile Modulus *Cure #1 **Cure #2	ASTM D638	psi (MPa)	266,653 (1,840) 237,572 (1,639)	281,713 (1,944) 254,861 (1,759)	268,352 (1,852) 241,990 (1,670)
Tensile Elongation *Cure #1 **Cure #2	ASTM-D638	%	2.4 4.5	1.4 3.6	2.1 6.5

* Cure #1 - 7 day/R.T.

** Cure #2 - 8 hr/140°F (60°C) + 8/hr/180°F (82°C)

Composite Cured Properties Tested at 74°F (23°C)

	Test Method	Unit(s)	Fast Hardener	Medium Hardener	Slow Hardener
Flexural Strength *Cure #1 **Cure #2	ASTM D790	psi (MPa)	28,778 (199) 30,591 (211)	36,650 (253) 31,586 (218)	35,191 (243) 43,617 (301)
Flexural Modulus *Cure #1 **Cure #2	ASTM D790	psi (MPa)	2.28M (15,732) 2.03M (14,007)	2.24M (15,456) 2.24M (15,456)	2.54M (17,526) 2.59M (17,871)
Tensile Strength *Cure #1 **Cure #2	ASTM D638	psi (MPa)	36,083 (249) 36,662 (253)	36,801 (254) 36,950 (255)	40,147 (277) 43,119 (298)
Tensile Modulus *Cure #1 **Cure #2	ASTM D638	psi (MPa)	920,629 (6,353) 965,815 (6,664)	985,417 (6,799) 902,167 (6,225)	1.19M (8,211) 1.13M (7,797)
Tensile Elongation *Cure #1 **Cure #2	ASTM D638	%	6.6 6.1	5.9 6.1	5.9 6.1

Infused laminate – 8 layer, 10 oz. glass, 0-90° rotation / Resin wt. content 28% for fast 30% for medium 25% for slow

*Cure #1 - 7 day/R.T.

**Cure #2 - 8 hr/140°F (60°C) + 8/hr/180°F (82°C)



STORAGE CONDITIONS

This product has a shelf life 12 months as indicated by the expiration date on the container when stored in original unopened containers between 59 – 77°F (15 – 25°C). Any opened can must be tightly closed.

HANDLING PRECAUTIONS

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

- Ensure good ventilation
- Wear gloves, and safety glasses

For additional information, please consult the Safety Data Sheet (SDS).

DISCLAIMER

The information contained in this technical data sheet results from research and tests conducted in our laboratories under precise conditions. Seller cannot anticipate all conditions under which seller's products, or the products of other manufacturers in combination with seller's products, may be used. It is the responsibility of the user to determine the suitability of the SikaAxson's products, under their own conditions, before commencing with the proposed application. In no event shall SikaAxson US be liable for any direct, indirect, punitive, incidental, special, and/or consequential damages, to property or life, whatsoever arising out of or connected with the use or misuse of our products.

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