



2010 M 25

FOAMING EPOXY SYSTEM

RESOLTECH 2010M25 is an epoxy foaming system formulated to fill voids and create a structural core. This enables manufacturers to produce complex shaped parts such as paddles, blades, rudders, fins.

RESOLTECH 2010M25 produces a durable, homogeneous foam with low exothermy.

RESOLTECH 2010M25 does not contain any CFC or banned chemical.

MIXING RATIO

The mixing ratio is constant whatever the hardener selected.

By weight: 100 + 36.

Hardener(s) available: 2014M.

WARNING: The mixing ratio must be accurately followed. It is not possible to change the ratio, it would result in lower mechanical properties. The mixture should be thoroughly stirred to ensure full homogeneity.

It is important to note that epoxy systems tend to heat up much faster in a pot than as a thin film. It is therefore necessary to only mix the necessary amount usable within the given pot life. Keeping the mixture in flat open containers reduces the risks of exothermic reaction.

APPLICATION

The standard procedure of working with epoxy systems applies to the RESOLTECH 2010M25. The system can be applied by casting or injection.

In case of laminating over a cured surface without peel ply, it is required to deglaze, clean and degrease the support prior to laminating.

For more information, please refer to the applications technical bulletins (TechNotes), available on request.

CURING

Workshop conditions: 18 to 25°C, 70% humidity maximum.

| | |
|-------------------------------|---|
| Working time | 17H for a 3cm thick film 15H for a 7cm thick film 10H for a 11cm thick film |
| Start of the foaming reaction | 5mn until 40 mn |
| Curing time | 4 to 10 hours (depending on the foaming volume) |
| Post cure (tg>50°C) | 48H @ ambient + 6H @ 40°C |
| Post cure (tg>70°C) | 48H @ ambient + 12H @ 60°C |
| Post cure (tg=95°C) | 48H @ ambient + 6H @ 40°C + 16H @ 60°C |

WARNING!

A post cure at elevated temperature following the time schedules featured above is mandatory.

The foaming reaction starts 4 to 5 minutes after mixing.

MECHANICAL PROPERTIES

| | |
|---------------------|-----------------------|
| Compression modulus | 210 N/mm ² |
| Flexural strength | 5 N/mm ² |
| Flexural modulus | 275 N/mm ² |
| Elongation at break | 1.9% |
| Max Tg: | 95°C |

PHYSICAL PROPERTIES

| | |
|--------------------------|--------------------|
| Resin aspect: | Thick white liquid |
| Hardener aspect: | Clear liquid |
| Mixture aspect: | Thick white liquid |
| Density of mixture | 1 |
| Density of foamed system | 0.25 |

Above values given at 22°C.

PACKING & STORAGE

Resoltech 2010M25 is available as follow:
1.36kg, 6.8kg, 38.08kg, 272kg.

Shelf life is one year in sealed containers as provided. Keep containers sealed and away from heat and cold.

HEALTH AND SAFETY

It is advised to follow basic rules such as avoiding skin contact, wear masks when producing dust. Please read our standard health and safety sheet for more information.
In case of eye contamination, wash with water and seek medical advice.

More information is available on **www.resoltech.com**.

The data provided in this document is the result of tests and is believed to be accurate. We do not accept any responsibility over the mishandling of these products and our liability is limited strictly to the value of the products we manufacture and supply.

RESOLTECH SARL
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