

SR 8500 / KTA 7227

One component epoxy system

Previous use :

- Filament winding
- Pultusion (doesn't contain internal release agent)
- Non thixotropic adhesive
- Hand laminate

Data

Products	Type	Aspect Color	Viscosity Cps @ 25°C	Density @ 20°C
SR 8500	Epoxy resin	Viscous liquid Yellow	4300	1.176
KTA 7227	Hardener	Powder White	na	0.25 to 0.32
8500 / KTA 7227	Blend	Liquid white		

Pot-life :

Store @ 18-23°C, the blend 8500 / 7227 don't react at ambient temperature.

Process:

Blend: 8500 / KTA 7227, let defoaming one night.

Mixing ratio :

SR 8500 / KTA 7227 : 100 g / 14 g
No critical ratio.



Reactivity data :

Mixing ratio by weight	100 / 14	100 / 15	100 / 16	100 / 17	100 / 18
Gel time @ 120°C*	5'	5'	4'	4'	4'
Glass transition 1 hour @ 120 °C by DSC					
Tg1	130	131	130	129	127
Tg1 max.	124	124	121	121	118
Gel time @ 120°C**	12'		11'		
Gel time @ 130°C**	6' 30"		6' 15"		
Gel time @ 140°C**	3' 50"		3' 45"		
Gel time @ 150°C**	2'05"		2'		

* : Initial temperature : 20 °C Speed rate temperature : 5°C / mn

** : Blend 8500 / KTA 7227 : put immediatly @ temperature

Safety data sheet resume :

Products	Symbol	Risk phrases
SR 8500		Xi: Irritating N: Dangerous for the environnement R 36/38 R 51/53 R 43
KTA 7227		Xn : Nocif N :Dangerous for the environnement R 22 R 40 R 48 / 22 R 50 / 53