



SR 8500 / SZ 8525

Fast and clear epoxy system for hot processes

Low viscosity epoxy system specially formulated for large scale production: ski and sports goods.

Very short cycle times hot process: 10 minutes at 100 °C or 20' at 90 °C.

Clear system after cure

Components properties

| | Units | SR 8500 | SZ 8525 |
|---------------------------|--------|---------------|---------------|
| Viscosity at 25 °C | mPa·s | 4200 ± 500 | 25 ± 5 |
| Density at 20 °C | Kg / l | 1.17 ± 0.01 | 0.94 ± 0.01 |
| Mixing viscosity at 25 °C | mPa·s | 960 ± 200 | |
| Refractive index at 25 °C | | 1.576 ± 0.002 | 1.488 ± 0.003 |

Shelf Life

In sealed containers at 20 – 25 °C

- SR 8500: Crystallization free, 24 months
- SZ 8525: Store in closes container, avoid long contact with air, 12 months

Mixing ratio:

| | By weight | By volume |
|---------|-----------|-----------|
| SR 8500 | 100 g | 100 ml |
| SZ 8525 | 25 g | 30 ml |

Reactivity (Hot Plate)

| Tooling temperature | Gel time (film) | Dust free (film) | Curing process (mn) | Glass transition (DSC)* Onset / Tg1 (°C) |
|---------------------|-----------------|------------------|---------------------|---|
| @ 80 °C | 8' | 12' | 30' | 85-90 |
| | | | 45' | 99 |
| | | | 60' | 102 |
| | | | 75' | 103 |
| | | | 90' | 104 |
| | | | 120' | 106 |
| @ 90 °C | 6' | 7' | 15' | 94 |
| | | | 20' | 102 |
| | | | 25' | 104 |
| | | | 30' | 106 |
| | | | 40' | 106 |
| @ 100 °C | 4' | 4' 50'' | 10' | 104 |
| | | | 20' | 113 |
| @ 110 °C | 2' 20'' | 3' | 6' | 96 |
| | | | 10' | 114 |

- : According standard Iso 11357-2 :1999



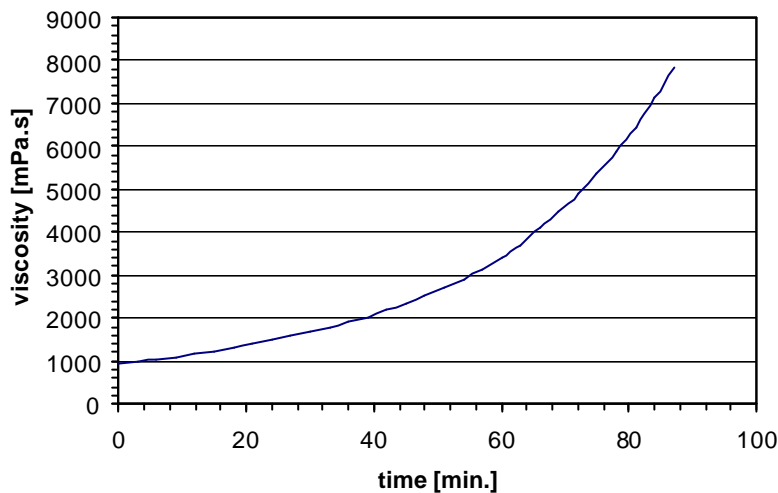
Typical curing cycle under hot press:

- @ 80 °C : 1 hour
- @ 90 °C : 20'
- @ 100 °C : 10'
- @ 110 °C : 8'

Pot-life:

100g-mixture @ 23 °C: ~ 85 minutes

SR 8500 / SZ 8525 blend at 23°C



Packaging

| Kits | SR 8500 | SZ 8525 |
|--------|------------|-----------|
| 980 kg | 4 x 200 kg | 180 kg |
| 250 kg | 200 kg | 2 x 25 kg |
| 15 kg | 12 | 3 |
| 1.25 | 1 | 0.25 |

Toxicity guide

| Products | Symbol | Risk phrases |
|----------|--------|--|
| SR 8500 | | Xi: Irritating N: Dangerous for the environment R 36/38 R 51/53 R 43 |
| SZ 8525x | | C: Corrosive R 21/22 R 34 R 43 |

(EEC Classification according Directive 67 / 548 / EEC)