



TECHNICAL DATA SHEET

SK2TM164-1

Two-component epoxy gel coat

► DESCRIPTION

SK2TM164-1 is a two-component epoxy gel coat for production of prepreg tools. This dimensionally accurate carbonfibre filled mould surface resin provides better surface slip and has a very low thermal expansion and a very high heat resistance.

This product is used in various manufacturing processes of parts made of composite materials.

► TECHNICAL DATA

Material type: Epoxy

PHYSICAL PROPERTIES			
Composition	Mixing	Resin Part A	Hardener Part B
Colour	grey	grey	brown transparent
Mixing ratio	-	100 p. b. w.	31 p. b. w.
Viscosity at 25°C (mPa.s)	thixotrop	thixotrop	375 mPas
Density at 20°C	1,22 g/cm ³	1,35 g/cm ³	0,97 g/cm ³
Pot life 200g / 20°C	220-260 min	-	-
Curing time at RT	24-48 hrs	-	-
Post curing	16 / 60 h/°C 8 / 130 h/°C 4 / 160 h/°C	-	-
TECHNICAL SPECIFICATIONS			
Flexural strength	EN ISO 178	MPa	90
Flexural modulus	EN ISO 178	MPa	4630
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	7,3
Compressive strength	EN ISO 604	MPa	105
Heat resistance (HDT)	DIN 53458	°C	164
Shore hardness	DIN ISO 7619-1	Shore D	87
Coefficient of linear expansion	DIN 53752	10-6 K-1	ca. 50



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► SIZE

Packing	Pack
Kit	4,5 kg

► PROCESSING INSTRUCTIONS

The temperature of material and processing should be between 18 and 25° C.

After each use the containers have to be closed again. Porous mould surfaces should be sealed before by SK2TR450-1. For an optimum mould release we recommend a suitable release agent (e.g. SK2TR450-4) which can be easily applied with a brush. The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

Stirring rods etc. with residual resin can be easily cleaned with SK2TR000-1 cleaning agent.

► STORAGE

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Shelf life is indicated on the labels.

► SAFETY MEASURE

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices.

► WASTE DISPOSAL

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Product Safety Data Sheet.



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► **GUARANTEE**

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.