



# TECHNICAL DATA SHEET

## SK2TM180-1 Epoxy gel coat

### ► DESCRIPTION

SK2TM180-1 is a black two-components carbon filled epoxy gel coat designed for production of moulds for prepreg, RTM, SMC, thermoforming. SK2TM180-1 has a high thermal resistance and can be polished, the product is chemically resistant.

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

### ► TECHNICAL DATA

Material type: Epoxy

PHYSICAL PROPERTIES			
Composition	Part A	Part B	Mixing
Mix ratio by weight	100	31	-
Aspect	thick liquid	liquid	thick liquid
Colour	black	brown transparent	black
Viscosity at 25°C (mPa.s)	thixotropic	375±75	thixotropic
Density at 20°C	1,35±0,03	0,97±0,02	1,22±0,02
Potlife, 200 g at 20°C (min)	-	-	220 - 260
Curing time at RT (in hours)	-	-	24 - 48
Post curing time (in hours / temperature in °C)	-	-	16 / 60 8 / 130 4 / 160
MECHANICAL & THERMAL PROPERTIES (1)			
Hardness	DIN ISO 7619-1	Shore D	87±3
Flexural strength	EN ISO 178	MPa	90±4
Flexural modulus	EN ISO 178	MPa	4630±300
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	7,3±1,5



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Compressive strength	EN ISO 604	MPa	105±7
Heat resistance (HDT)	DIN EN ISO 75 B	°C	175±5
Glass transition temperature TG	TMA	°C	175
Coefficient of thermal expansion	internal test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	около 50

(1): Average values obtained on standardized specimens, on neat resin. Hardening: according to the curing cycle indicated on the next page.

### ► SIZE

Packing	Part A	Part B
Kit 4,5 kg	12 containers x 0.285 kg each	12 containers x 0.090 kg each

### ► PROCESSING

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

As soon as the surface resin has gelled but is still slightly tacky, you can proceed with your buildup. Porous mould surfaces should be sealed first. The mould should be coated 2-3 times and allowed to evaporate for approx. 20 min. after each application.

The mixing ratio of resin and hardener must be kept according to the instructions.

### ► STORAGE

Both parts should be protected from moist and be stored in the original unopened packing at the temperature 18 - 25°C. Opened containers should be closed immediately after use and should be used up as soon as possible.

### ► HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products: ensure good ventilation, wear gloves, safety glasses and clothes.



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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.