

General description

NM Resin 094 together with NM Hardener 093 C is a low viscosity epoxy resin for manufacturing of sandmoulds and laminates.

The resin can be accelerated with up to 10% of NM Accelerator 254 (See below). The reactivity versus concentration of accelerator is shown in the table

At increased amounts of accelerator, potlife and exothermic are affected.
When having large moulds, the accelerator should not be added.

Typical properties

Resin:

NM Gjutharts 094

Hardener:

NM Härdare 093 C

Accelerator:

NM Accelerator 254

Mixing ratio:

Resin-Hardener 100-37 by weight

Resin-Hardener 100-44 by volume

Density

Resin: 1159 kg/m³

Hardener: 965 kg/m³

Accelerator: 1146 kg/m³

Viscosity at 25°C:

Resin: 3500 mPa·s

Hardener: 22 mPa·s

Accelerator: 65 mPa·s

Mixture: 500 mPa·s

Potlife 100g 20°C: see table

Tensile strength, 0% 254: 52 MPa

Tensile strength, 6% 254: 55 MPa

Normal packing: 13.0 + 4.8
= 17.8 kg

Cleaning solvent: Acetone

% Accelerator 254	Potlife (Minutes)
0	100
0.5	65
1.0	50
1.5	40
2.0	35
2.5	31
3.0	28
4.0	26
5.0	20
6.0	17
7.0	16
8.0	15
9.0	14
10.0	13

Potlife for NM Resin 094 / NM Hardener 093 C with different amounts of NM Accelerator 254. The values are for 100 gms of NM Resin 094 / NM Hardener 093 C with a initial temperature of 20°C. The percent adding is calculated as ex. 100 gms + 1 gm.

NILS MALMGREN AB

P.O.Box 2039
S-442 02 YTTERBY

Phone: +46 303-936 10
Fax: +46 303-928 55

E-mail: info@nilsmalmgren.se
Web: www.nilsmalmgren.se

