



Technical Data Sheet

NM Laminering 380

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Ers: 2020-11-02

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General Description

NM Laminering 380 is intended for use in injection, where there are requirements for high heat resistance and low viscosity.

Application

The mixture of components is very important. A poor mixing results in soft spots in the cured system. Mix thoroughly in a vessel, transfer the mixture into a clean vessel and mix further. Dosage should always be done on a scale with sufficient accuracy.

Release agents

We recommend film forming release agents such as Marbocote 220.

Wax-based release agents are generally not recommended. For this, trials must be done first.

Curing

Laminates with **NM Laminering 380** should gel at room temperature, which takes about 6 hours and then be heat-cured at at least + 70°C.

Curing at + 70°C is complete after approx. 16 hours.

It is important that the temperature is ramped up slowly to the final curing temperature. Normal elevations are between 0.1 - 0.3 ° C per minute. Often it is a combination of the thickness of the laminate and the construction that determines the speed. The optimal curing cycle must be determined for each individual case.

Post work

It is important to further treatment as laminating, filling, etc. occurs when the surface is still like a tacky tape. A dry surface has to be sanded to ensure adhesion to the next layer.

Typical Properties

Resin NM Laminering 380
Hardener NM Härdare 2962

Mixing ratio

Resin – Hardener 100 – 25 by weight

Density, 20°C: 1100 kg/m³
Viscosity, 25°C: 0.4 Pa·s
Pot life 100g 20°C: 160 minutes

Flexural strength: 115 MPa
E-modulus [Flexural]: 3.7 GPa

T_G, 4h 40°C+11h, 80°C: 108°C

Colour: Transparent

Normal packing: On request

Cleaning solvent: Acetone

Flexural strength and E-modulus measured according to ISO 178
T_G measured according with DSC 20K/min

Disclaimer

This product's technical specifications are developed by experience in field and laboratory by us. Fully cured will take place at seven days at +23°C and 50 % RF.

We reserve the right to change products as well as data. Current data sheets are available at our website and with us. We cannot assume responsibility for use in areas that we do not know. The user shall always evaluate products for their intended use and we guarantee only the material properties. For every product we offer reference objects separately.