



# Technical Data Sheet

## NM Laminering 625

Utg: 2011-04-21

Ers: 2011-05-09

Rev: 2011-05-18

### General Description

**NM Laminering 625** is an optimized epoxy system with high Tg, good wetting, very high strength and very low vapor pressure.

**NM Laminering 625** can be used for injection, but is optimized for hand lay-up.

**NM Laminering 625** has a very low vapor pressure and therefore, the system is almost odorless. Vacuum gives no gas.

Curing can be done at room or at elevated temperature. Post curing should proceed earliest after one day at room temperature.

### Processing Instructions

The mixture of components is very important, poor mixing may result in soft spots.

Mix thoroughly in a container, transfer the mixture into a clean container and mix further. Dosage should always be made on a scale with sufficient accuracy or a well calibrated dosage system.

Application is best done with a roller, but can also be done with a brush.

### Surface Preparation

Film forming release agent is recommended, for example Marbocote 220. Wax-based release agents are normally not recommended and test should be performed before use of these types.

### Curing

**NM Laminering 625** should first cure at room-temperature (20 – 23°C / 68 – 73°F) for 12 - 24 hours before post-curing.

A typical curing cycle could be one day at 23°C / 73°F and then a post-cure at 50°C / 122°F for 16 hours, or alternatively four hours at 100°C / 212°F.

It is important that the temperature is ramped up slowly to the final curing temperature. Normal increases are between 0.1 - 0.3°C per minute. It is often a combination of thickness and laminate structure, which determines the speed. The optimum cure cycle must be determined for each case.

**NM Laminering 625** can be stored for a longer period at room-temperature and be post-cured later.

**NM Laminering 625** can be used in combination with our hardener:

**NM Härdare 650 B**, approx. 180 min. pot-life.

**NM Härdare 650 F**, approx. 90 min. pot-life.

**NM Härdare 650 M**, approx. 120 min. pot-life.

### Completion Work

By hand lay-up, it is important that before further treatment as laminating, filling, etc. occurs, it is done when the surface is still tacky.

A dry surface must be sanded to ensure adhesion to the next layer.

## NILS MALMGREN AB

P.O Box 2039  
S-442 02 YTTERBY, SWEDEN

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

*Quality certified since 1990*

E-mail: info@nilsmalmgren.se  
Home site: www.nilsmalmgren.se

## Typical Properties

**Resin** NM Laminering 625  
**Hardener** NM Härdare 650 M

### Mixing ratio

Resin – Hardener 100 – 35 by weight  
 100 – 42.5 by volume

*Density:* 1099 kg/m<sup>3</sup>

*Density, Resin:* 1160 kg/m<sup>3</sup>

*Viscosity, Resin:* 1.5 – 1.7 Pa·s

*Appearance, Resin:* Clear liquid

*Colour (Gardner ISO 4630):* ≤2

*Density, Hardener:* 955 kg/m<sup>3</sup>

*Viscosity, Hardener:* 40 – 50 mPa·s

*Appearance, Hardener:* Clear liquid

*Colour (Gardner ISO 4630):* ≤3

<b>Mixed viscosity:</b>	<b>at °C / °F</b>	<b>mPa·s</b>
ISO 12058-1	18 / 64	1300 – 1400
	25 / 77	600 – 700
	40 / 104	200 – 250
	60 / 140	50 – 70

<b>Viscosity build up</b>	<b>from °C / °F</b>	<b>mPa·s</b>	<b>minutes</b>
ISO 12058-1	18 / 64	to 1500	15 – 20*
	18 / 64	to 3000	85 – 90*
	25 / 77	to 1500	60 – 70
	25 / 77	to 3000	100 – 110
	40 / 104	to 1500	45 – 55
	40 / 104	to 3000	60 – 70
	60 / 140	to 1500	20 – 25
	60 / 140	to 3000	25 – 30

\*The viscosity of the system causes short times at low temperatures.

<b>Pot-life</b>	<b>from °C / °F</b>	<b>minutes</b>
(Tecam, 100 ml, 65% RH)	18 / 64	160 – 180
	25 / 77	110 – 130
	40 / 104	40 – 45

<b>Gel time</b>	<b>at °C / °F</b>	<b>minutes</b>
(Hot plate)	25 / 77	140 – 180
	40 / 104	75 – 95
	60 / 140	25 – 40
	80 / 176	10 – 15
	100 / 212	4 – 6
	120 / 248	2 – 3

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**Gel time at 23°C / 74°F**

(Thin layers:  
0.4-0.7 mm)

Start:  
End:

**hours**

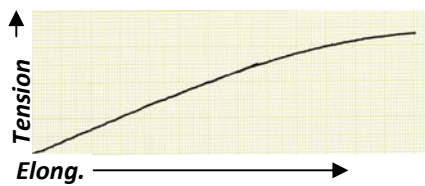
3 - 4  
5 - 6

<b>Glass transition temperature</b> (DSC, 20 K/min)	<b>Curing</b>	<b>T<sub>G</sub> onset, °C</b>	<b>T<sub>G</sub>, °C</b>	<b>T<sub>G</sub>, °F</b>
	2 days 25°C	49 – 51	51 – 54	124 – 129
	8 days 25°C	58 – 60	60 – 64	140 – 147
	7 days 23°C	56 – 58	58 – 60	136 – 140
	1 month 23°C	58 – 60	60 – 64	140 – 147
	2 months 23°C	59 – 61	61 – 65	142 – 149
	3 months 23°C	60 – 63	62 – 66	144 – 151
	4 months 23°C			
	24 h 23°C + 10 h 40°C	61 – 65	63 – 67	145 – 153
	24 h 23°C + 20 h 40°C	64 – 68	66 – 70	151 – 158
	24 h 23°C + 10 h 50°C	72 – 76	75 – 79	167 – 174
	24 h 23°C + 15 h 50°C	74 – 77	76 – 80	169 – 176
	24 h 23°C + 10 h 60°C	83 – 87	85 – 89	185 – 192
	24 h 23°C + 15 h 60°C	84 – 86	85 – 88	185 – 190
	24 h 23°C + 2 h 80°C	87 – 91	92 – 96	198 – 205
	24 h 23°C + 8 h 80°C	96 – 100	100 – 104	212 – 219
	24 h 23°C + 1 h 90°C	84 – 88	90 – 94	194 – 201
	24 h 23°C + 4 h 90°C	96 – 100	102 – 106	216 – 129
	24 h 23°C + 1 h 100°C	91 – 95	100 – 104	212 – 219
	24 h 23°C + 4 h 100°C	98 – 102	104 – 108	219 – 226

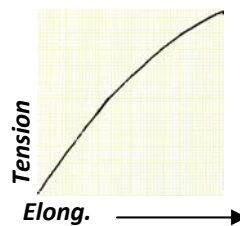
<b>Tensile strength</b> (ISO 527)		<b>Curing:</b>	<b>7 days 23°C</b>	<b>15 h 50°C</b>	<b>8 h 80°C</b>
	Tensile strength	MPa	53 – 54	75 – 78	76 – 79
	Elongation at break	%	2.0 – 2.2	3.7 – 4.2	6.5 – 7.5
	E-modulus	GPa	2.8 – 2.9	2.3 – 2.5	2.2 – 2.4

<b>Flexural strength</b> (ISO 178)		<b>Curing:</b>	<b>7 days 23°C</b>	<b>15 h 50°C</b>	<b>8 h 80°C</b>
	Flexural strength	MPa	72 – 88	133 – 135	124 – 137
	Elongation at break	%	1.8 – 2.2	4.5 – 4.7	4.7 – 5.0
	E-modulus <sub>Flexural</sub>	GPa	4.3	3.0 – 3.1	2.7 – 2.9

**Tension/Elongation at flex.**



**Tension/Elongation at tension**



<b>Water absorption</b> (ISO 62)	<b>Submerged</b>	<b>Curing:</b>	<b>7 days 23°C</b>	<b>8 h 80°C</b>
	4 days 23°C		+0,40 – 0,45 %	+0,30 – 0,35 %
	10 days 23°C		+0,63 – 0,68 %	+0,50 – 0,55 %
	30 minutes 100°C		+0,55 – 0,60 %	+0,40 – 0,46 %
	60 minutes 100°C		+0,68 – 0,75 %	+0,60 – 0,66 %

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**Properties of cured laminate**

*Test pieces made of 16 layers of 300 grams E-glass fabric 0/90°. Fibre volume: 45-46%. Cured for 10 at 80°C.*

**Flexural strength**

(ISO 178)

			<b>Unconditioned</b>
Flexural strength	MPa		580 – 620
Elongation at break	%		3.8 – 5.0
E-modulus <sub>Flexural</sub>	GPa		21 – 25

**After 30 days in water at +23°C**

Flexural strength	MPa		542 – 550
Elongation at break	%		4.2 – 4.4
E-modulus <sub>Flexural</sub>	GPa		22 – 23

**Tensile strength**

(ISO 527)

			<b>Unconditioned</b>
Tensile strength	MPa		360 – 390
Elongation at break	%		1.7 – 2.0
E-modulus <sub>Tensile</sub>	GPa		33 – 39

*Normal packing:*            27.0 kg  
                                       6.75 kg  
                                       1.350 kg

*Cleaning solvent:*            Acetone

**Disclaimer**

This product’s technical specifications are developed by experience in field and laboratory by us.

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.