

Cast Resin Systems



General

Our company is manufacturing cast resins on basis polyurethane (PUR) for various applications since several decades. It goes without saying, that we always did this up to date with the latest technology.

For several years we are a member of the german „norm comittee“, which develops the VDE-regulations for cast resins used in cable joints.

Therefore we feel obliged to already realize the demanded technical improvements in our product development when new norms are in the planning stage.

The same high requirements are set on the choice and production of our packaging for cast resin systems. All available packaging variations are used with respect to ecological considerations and to ensure the highest safety to the user.

Cast resins

The range of the manufactured cast resins in our company is a result of special requests and requirements from our customers. They have all been tested in practice.

When the customer has no special requirements, we supply our well-trying standard systems from our cast resin selection.

Furthermore we have developed cast resin systems for special solutions in cooperation with our customers and are producing them as special systems exclusively for these customers.

The polyurethane (PUR) cast resins for the use in cable joints and electrical components are of course corresponding to the VDE norm 0291 part 2.

That means, that the requirements referring to stability against hydrolysis and hydrophobia are also fulfilled.

Our systems are free from solvents and heavy metals, resistant against chemical influences and mechanically stable. During the hardening process they develop low heat and are showing a very good adhesion to different surfaces (cable sheath of PVC, PE, XLPE, metal or joints in rock, concrete, asphalt).

Application

We develop and produce polyurethane (PUR) cast resins for low-voltage (LV) and medium-voltage (MV) applications as well as for casting of electric components.

Furthermore we are manufacturing sealing compounds for the filling of joints (e.g. inductive loops) in roads and warehouses.

Packing

Recyclable tins in all sizes.

Double-chamber bags with a volume up to 5 litres in different designs.

Cast Resin PU 300 · 1 kV



Technical Data		
processing temperature	+ 10°C ro + 35°C	
mixing ratio	100 : 35	(by weight)
processing time	app. 15 min.	(23°C)
final hardness after:	app. 2 - 3 days	(accd. to temperature)
density	1,23 g/cm ³	(20°C; reaction product)
hardness Shore D	app. 50	(23°C)
resistance to temperature	-25°C to +120°C	(after hardening)

Material description

The cast resin PU 300 is a two-component, natural coloured, unfilled polyurethane cast resin system. This excellent pourable system meets the type GNW according to VDE 0291 part 2 from 11/79. After final hardening the compound will be soft-elastic.

Application

Insulation of electrical components, especially to seal 1 kV straight and branch joints.

Processing

The two components (resin and hardener) are one unit, exactly fine-tuned to each other. There is no further need to weight out the components. The packing will be either in two separate tins or in double-chamber bags. Before you add the hardener, the resin-component should be mixed up.

In case you choose the packing in tins, the hardener must be filled completely into the resin and both components must be mixed with constant stirring. If you use the double-chamber bags, you must remove the separator, so that both components run together.

After that both compontens can be easily mixed by kneading the bag.

The time of mixing will be about 3 minutes. You can recognize a homogenous mixture by the uniform colour of the compound. During mixing it is important, that only few air bubbles are mixed into the compound.

The processing time is dependent on the ambient temperature. At lower temperatures you have longer and at higher temperatures you have shorter processing times.

The speed of hardening also depends on the ambient temperature and to the poured quantity. The final hardness will be reached after 2 to 3 days.

Storage

The original closed tins/bags have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 24 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Cast Resin PU 304 · 1 kV



Technical Data		
Processing temperature	+ 10°C to + 35°C	
Mixing ratio	100 : 28	(by weight)
Processing time	app. 15 min.	(23°C)
Final hardness after	app. 2 - 3 days	(accd. to temperature)
Density	1,34 g/cm ³	(20°C; reaction product)
Hardness Shore D	app. 60	(23°C)
Resistance to temperature	-25°C to +120°C	(after hardening)

Material description

The cast resin PU 304 is a two-component, filled polyurethane cast resin system. After final hardening the compound will be soft-elastic and insensitive to temperature.

Application

Insulation of electrical components; especially to seal 1 kV straight and branch joints.

PU 304 contains heat conducting fillers and is used in thermal difficult applications.

Processing

The two components (resin and hardener) are one unit, exactly fine-tuned to each other. There is no further need to weight out the components. The packing will be either in two separate tins or in double-chamber bags. Before you add the hardener, the resin-component should be mixed up.

In case you choose the packing in tins, the hardener must be filled completely into the resin and both components must be mixed with constant stirring. If you use the double-chamber bags, you must remove the separator, so that both components run together.

After that both components can be easily mixed by kneading the bag.

The time of mixing will be about 3 minutes. You can recognize a homogenous mixture by the uniform colour of the compound. During mixing it is important, that only few air bubbles are mixed into the compound.

The processing time is dependent on the ambient temperature. At lower temperatures you have longer and at higher temperatures you have shorter processing times.

The speed of hardening also depends on the ambient temperature and to the poured quantity. The final hardness will be reached after 2 to 3 days.

Storage

The original closed tins/bags have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 24 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Cast Resin PU 500/2 · 1 kV



Technical Data		
Processing temperature	+ 10°C to + 35°C	
Mixing ratio	100 : 40	(by weight)
Processing time	app. 15 min.	(23°C)
Final hardness after	app. 2 - 3 days	(accd. to temperature)
Density	1,23 g/cm ³	(20°C; reaction product)
Hardness Shore D	app. 60	(23°C)
Resistance to temperature	-25°C to +120°C	(after hardening)

Material description

The cast resin PU 500/2 is a two-component, natural coloured, unfilled polyurethane cast resin system. It has a very good pourability and meets the requirements of type RLS-W according to the draft of VDE 0291 part 2 dated June 1997. After final hardening the compound will be soft-elastic.

Application

Insulation of electrical components, especially to seal 1 kV straight and branch joints.

Processing

The two components (resin and hardener) are one unit, exactly fine-tuned to each other. There is no further need to weight out the components. The packing will be either in two separate tins or in double-chamber bags. Before you add the hardener, the resin-component should be mixed up.

In case you choose the packing in tins, the hardener must be filled completely into the resin and both components must be mixed with constant stirring. If you use the double-chamber bags, you must remove the separator, so that both components run together.

After that both components can be easily mixed by kneading the bag.

The time of mixing will be about 3 minutes. You can recognize a homogenous mixture by the uniform colour of the compound. During mixing it is important, that only few air bubbles are mixed into the compound.

The processing time is dependent on the ambient temperature. At lower temperatures you have longer and at higher temperatures you have shorter processing times.

The speed of hardening also depends on the ambient temperature and to the poured quantity. The final hardness will be reached after 2 to 3 days.

Storage

The original closed tins/bags have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 24 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Cast Resin PU 910 · 10 kV



Technical Data		
Processing temperature	+ 10°C to + 35°C	
Mixing ratio	100 : 36	(by weight)
Processing time	app. 30 min.	(23°C)
Viscosity	app. 1300 mPa.s	(reaction substance; beginning temp. 23°C, after 5 min.)
Final hardness after	app. 5 days	(accd. to temperature)
Density	1,14 g/cm ³	(20°C; reaction product)
Hardness Shore D	app. 50	(23°C)

Material description

The cast resin PU 910 is a two-component, natural coloured, unfilled polyurethane cast resin system. The very good pourable system will be soft-elastic after final hardening.

Application

Insulation of electrical components, especially to seal 10 kV straight and transition joints.

Processing

The two components (resin and hardener) are one unit, exactly fine-tuned to each other. There is no further need to weight out the components. The packing will be either in two separate tins or in double-chamber bags. Before you add the hardener, the resin-component should be mixed up.

In case you choose the packing in tins, the hardener must be filled completely into the resin and both components must be mixed with constant stirring. If you use the double-chamber bags, you must remove the separator, so that both components run together.

After that both components can be easily mixed by kneading the bag.

The time of mixing will be about 3 minutes. You can recognize a homogenous mixture by the uniform colour of the compound. During mixing it is important, that only few air bubbles are mixed into the compound.

The processing time is dependent on the ambient temperature. At lower temperatures you have longer and at higher temperatures you have shorter processing times.

The speed of hardening also depends on the ambient temperature and to the poured quantity. The final hardness will be reached after 2 to 3 days.

Storage

The original closed tins/bags have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 24 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Joint Sealing Compound PU 4009 grey



Technical Data		
Processing temperature	+ 10°C to +35°C	
Mixing ratio	100 : 9	(by weight)
Processing time / pot life	app. 20 min.	(23°C)
Viscosity	app. 8000 mPa.s	reacting substance; start temp. 23°C, after 5 min.
Final hardness after	app. 3 - 5 days	(depending on temperature)
Density	1,53 g/cm ³	(20°C; reaction product)
Hardness Shore A	60 - 70	(20°C)
Resistance of temperature	-25°C to +100°C	(after hardening)

Material description

The joint compound PU 4009 grey is a two-component, filled polyurethane cast resin. After final hardening, the compound will be elastic and is insensitive to frost and heat.

Application

For sealing of joints in roads and stores, especially to seal induction loops. The compound shows good adhesion to concrete, eternit, asphalt and different synthetics. As the hardened compound will keep elastic, you can remove the compound out of the joint by using a knife or a similar sharp tool.

Processing

In order to have the best adhesion of the joint compound to the flanks, the joints which have to be sealed must be dry and free of dust and oil. The use of a primer is not necessary. The sealing of the joints may only be carried out when the weather is dry. If necessary, the joints have to be covered.

The two components (resin and hardener) which are one unit, are exactly fine-tuned to each other. There is no further need to weight out the components.

Before you add the hardener, the resin should be mixed up. The hardener must be filled completely into the resin and both components must be mixed with constant stirring.

The time of mixing will be about 3 minutes. You can recognize a homogenous mixture by the uniform colour of the compound. During mixing it is important that only few air bubbles are mixed into the compound.

The processing time is related to the ambient temperature. At lower temperatures you have longer, respectively at higher temperatures shorter processing times. You can fasten or slow down the time, by storing the components in a warm (e.g. in the car) respectively cool place (e.g. in the shadow) before processing.

The reaction heat of the compound while hardening is negligible. After 1 to 2 hours you can walk on the joint. The speed of hardening depends on the ambient temperature and to the joint cross-section. The final hardness will be reached after 3 to 5 days.

Storage

The original closed tins have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 12 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Joint Sealing Compound PU 4009 black



Technical Data		
Processing temperature	+ 10°C to + 35°C	
Mixing ratio	100 : 12	(by weight)
Processing time	app. 20 min.	(23°C)
Viscosity	app. 4200 mPa.s	reacting compound after 5 Min. at start temperature 23 °C
Final hardness after	app. 3 - 5 days	(accd. to ambient temperature)
Density	1,34 g/cm ³	(20°C; reaction product)
Hardness Shore D	60 - 70	(23°C)
Resistance to temperature	-25°C to +100°C	(after hardening)

Material description

The joint compound PU 4009 black is a two-component, filled polyurethane cast resin with added bitumen. After final hardening, the compound will be elastic and is insensitive to frost and heat.

Application

For sealing of joints in roads and stores, especially for the sealing of induction loops. The compound shows good adhesion to concrete, eternit, asphalt and different synthetics. As the hardened compound will keep elastic, you can remove the compound out of the joint by using a knife or a similar sharp tool.

Processing

In order to have the best adhesion of the joint compound to the flanks, the joints which have to be sealed must be dry and free of dust and oil. The use of a primer is not necessary. The sealing of the joints may only be carried out when the weather is dry. If necessary, the joints have to be covered.

The two components (resin and hardener) which are one unit, are exactly fine-tuned to each other. There is no further need to weight out the components.

Before you add the hardener, the resin should be mixed up. The hardener must be filled completely into the resin and both components must be mixed with constant stirring.

The time of mixing will be about 3 minutes. You can recognize a homogenous mixture by the uniform colour of the compound. During mixing it is important that only few air bubbles are mixed into the compound.

The processing time is related to the ambient temperature. At lower temperatures you have longer, respectively at higher temperatures shorter processing times. You can fasten or slow down the time, by storing the components in a warm (e.g. in the car) respectively cool place (e.g. in the shadow) before processing.

The reaction heat of the compound while hardening is negligible. After 1 to 2 hours you can walk on the joint. The speed of hardening depends on the ambient temperature and to the joint cross-section. The final hardness will be reached after 3 to 5 days.

Storage

The original closed tins have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 12 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Compound OK 80 · 1 kV



Technical Data		
Processing temperature	+ 5°C to + 40°C	
Density	1,75 - 1,80 g/cm ³	(20°C)
Breakdown voltage	> 25 kV	(VDE 0370 / 20°C)
Viscosity	80 - 100 Pa*s	(20°C, after Brookfield)

Material description

The compound OK 80 is a one-component, non-hardening cold casting compound based on higher hydrocarbons.

The material is non-hazardous so no labeling is required in accordance with the EEC directives. It contains neither isocyanates nor other toxic or hazardous components. Due to the marking-free components a problem-free disposal is given.

Application

OK 80 is used as sealing compound for branch and straight joint boxes in the range up to 1 kV.

The compound can be used on different materials (e.g. PVC, XLPE, metals). It has very good insulation properties and is also watertight.

Processing

Before pouring OK 80 has to be made homogenous by kneading (bag) or by stirring (bucket). It is important that only few air bubbles are mixed into the compound. OK 80 can be used at temperatures below 0°C, but the best processing temperature is between 20-25°C. Therefore it is recommended to store the material in a heated room before use.

The joint box must be made out of the solid material and has to be sealed carefully during mounting. During pouring of OK 80 into the mould, hit the joint box slightly on the outside to support degassing.

After pouring the viscosity of OK 80 increases noticeably and the flowability becomes negligible. Therefore the escape of the material through the cables is nearly impossible.

Packing is available in plastic buckets or in bags.

Storage

The original closed buckets/bags have to be stored in a dry and frost-free place.

When stored at a temperature between 10 - 30°C the shelf life is almost unlimited.

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheet.

Compound OK 99 · 1 kV



Technical Data		
Processing Temperature	+ 10°C to + 35°C	
Mixing ratio	100 : 50	(by weight)
Processing time / pot life	app. 25 min.	(23°C)
Final hardness after	app. 5 days	(depending on temperature)
Density	1,16 g/cm ³	(20°C; reaction product)
Hardness Shore A	app. 25	(23°C ; 7d)
Viscosity	app. 6.500 mPa.s	reacting compound after 5 Min. at start temperature 23°C

Properties

OK 99 is a two-component sealing compound with very good adhesive properties on metal and cable insulating materials.

OK 99 is an elastic hardening compound which follows the cable movements in the underground and has good longitudinal water tightness.

During the hardening process the compound does not heat up. OK 99 is easy and safe while handling. Joints can be opened without destruction and the compound can be removed.

The material is non-hazardous, so no labeling is required in accordance with the EEC directives. It contains neither isocyanates or other toxic or hazardous components. Due to the marking-free components a problem-free disposal is given.

Application

The two components (resin and hardener) are one unit, exactly fine-tuned to each other. There is no further need to weight out the components. The packing will be either in two separate tins or in double-chamber bags. Before you add the hardener, the resin-component should be mixed up.

In case you choose the packing in tins, the hardener must be filled completely into the resin and both components must be mixed with constant stirring.

If you use the double-chamber bags, you must remove the separator, so that both components run together.

After that both components can be easily mixed by kneading the bag.

The time of mixing will be about 3 minutes. You can recognize a homogenous mixture by the uniform colour of the compound. During mixing it is important, that only few air bubbles are mixed into the compound.

The final hardness will be reached after approximately 5 days.

Storage

The original closed tins/bags have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 24 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Removable Sealing Compound PH-S-607



Technical Data		
Mixing ratio	9 : 1	(by weight)
Processing time / pot life	60 - 100 min.	(23°C, to 60.000 mPa.s)
Mixing viscosity	app. 4.000 mPa.s	(23°C, after Brookfield)
Density	1,17 g/cm ³	(23°C; reaction product)
Hardness Shore A	app. 30	(23°C)
Resistance to temperature	-45°C to +180°C	(after hardening)

Material description

The removable sealing compound PH-S-607 is a addition curing two-component silicone rubber that vulcanizes at room temperatures.

It has a excellent flowability with good self-deaeration. The compound has good dielectric properties. The compound can be removed by knife or similar tools.

Application

Encapsulation of electrical and electronic components.

Processing

Before the rubber base is taken from the drum or mixed with the catalyst, it must be stirred thoroughly, preferably using a mechanical stirrer, in order to redisperse any filler which may have settled.

For processing Silicon E the hardener must be filled in the rubber base and both components must be mixed with constant stirring.

The mixture should be poured in a thin stream from close as possible. The point of contact should not be varied once selected. The silicone rubber will thus fill all voids and expel air. The resultant vulcanisates are bubble-free.

PH-S-607 will cure at room temperature as well as at elevated temperature.

PH-S-607 does not adhere to other substrates. If the adhesion of the rubber to different metals or glass is required, the application of a primer is necessary. To achieve an optimal adhesion it is advisable to cure the compound at elevated temperatures (for example 1 hour at 150°C).

Certain chemicals can retard, or in unfavourable cases, prevent the vulcanisation. This includes sulfur-, tin-, nitrogen-compounds like amines, amides, azides, some antioxidatants in plastic and rubber, certain plasticine types, residues of solid condensation curing silicone rubbers, phenol resins, etc. The user is advised to test all raw materials as to their compatibility with PH-S-607.

Storage

The original closed tins have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 12 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Silicone E



Technical Data		
Mixing ratio	100 : 5	(by weight)
Processing time	app. 150 min.	(23°C, to 60.000 mPa.s)
Mischungsviskosität	app. 7000 mPa.s	(23°C, after Brookfield)
Density	1,23 g/cm ³	(23°C; reaction product)
Hardness Shore A	app. 45	(23°C)
Resistance to temperature	-45°C to +180°C	(after hardening)

Material description

Silicon E is a pourable, condensation-curing two- component silicone rubber vulcanising at room temperature. It has a excellent flowability with good self-deaeration and a medium Shore A hardness after curing. The cured rubber Silicon E has good dielectric properties.

Application

Encapsulation of electrical and electronic components. Also suitable for making flexible moulds or as flexible mould release agent.

Processing

Before the rubber base is taken from the drum or mixed with the catalyst, it must be stirred thoroughly, preferably using a mechanical stirrer, in order to redisperse any filler which may have settled.

For processing Silicon E the hardener must be filled in the rubber base and both components must be mixed with constant stirring.

The mixture should be poured in a thin stream from close as possible. The point of contact should not be varied once selected. The silicone rubber will thus fill all voids and expel air. The resultant vulcanisates are bubble-free.

Condensation-curing silicone rubbers requires catalytical amounts of humidity for proper cure. If the containers are not stored tightly closed, or are even left open, the water added during the production may evaporate, resulting in markedly prolonged pot lives as well as curing problems, such as adherence of rubber to the surface.

In this case, the water content of the air must be increased by appropriate measures, e.g. evaporators or atomisers, to at least 40% relative humidity. Water should not be added to the rubber base.

As encapsulating material Silicon E is a condensation-curing silicone rubber, it will achieve its full operability only after the volatile reaction products (low-molecular alcohols) formed during vulcanisation have been removed.

The potted components must not be exposed to temperatures exceeding 90°C until the alcohol formed during cure has fully escaped from the vulcanisate.

Vulcanisates that are absolutely free from alcohol are obtained by storing them exposed to the air for a period of, depending on layer thickness, 48 - 72 hours at ambient temperature or by heating them in a well ventilated oven at 70°C maximum for approx. 6 hours/cm layer thickness.

Storage

The original closed tins have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 12 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

HFS-Liquid Foam (FCKW-free)



Technical Data		
Processing temperature	+10°C to +35°C	
Processing time	app. 20 sec.	(21°C)
Starting time	app. 20 sec.	(23°C)
Climbing time	app. 3 min.	(23°C)
Non-sticking time	app. 10 min.	(23°C)
Freefoamed specific gravity	46 kg/m ³	(23°C)
Dimensional stability	3 - 5 %	24 h, 120°C
Bending strength	2,5 - 3,5 kg/cm ³	
% closed cells	96 - 98	Remmington

Material description

HFS-Liquid Foam is a two-component, natural coloured, unfilled polyurethane foam. It has good adhesive properties on steel, aluminium, concrete, PVC and PE.

After final hardening, the foam is soft-elstic. The ready hardened foam is odourless, resistant to rotteness and mould and has good insulation properties.

Application

To foam out of telecommunication joints. Especially for complicated moulds or hard to reach hollow spaces.

When required the foam can be easily removed with a knife or a similar tool.

Processing

The two-components (resin and hardener) are exactly fine-tuned to each other. There is no further need to weight out the components.

The packing is in two separate bottles. The bottle of the resin has to be used as the mixing container.

The hardener must be filled completely into the resin. Close the mixing bottle and shake the compound for

20 seconds. As soon as the bottle inflates, the HFS-Liquid Foam has to be poured out IMMEDIATELY.

The processing time is dependent on the ambient temperature. At lower temperatures you have longer and at higher temperatures you have shorter processing times.

The speed of hardening also depends on the ambient temperature and to the poured quantity. The final hardness will be reached after 2 days.

Storage

The original closed tins/bags have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 18 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.

Cast Resin EPL 701 • electrically Conductive



Technical Data		
Processing temperature	+5°C to +35°C	
Processing time	21°C	app. 70 min.
Colour	light ocher	
Density	1,89 g/cm ³	(20°C)
Adhesion	app. 23°C	1,0 N / mm ²
	app. 70°C	0,3 N / mm ²
(After buffeting test)	app. 23°C	0,5 N / mm ²
Hardness Shore D	70 - 80	(23°C)
Volume volume at hardening	app. 1%	
Thermal expansion	54 x 10 ⁻⁶ K ⁻¹	
Thermal conductivity	1W / K x m	
Specific conductance	< 0,1 Ohm x cm	
Behaviour in case of fire (hardened)	Class B1	DIN 4102
Stability	against aging, sea water, ozone irradiation	

Material description

Electrically conductive sealing compound, two-component based on a non-crystallising, modified epoxy-resin. EPL 701 is vibration proof, resistant to seawater and ozone and is non-ageing.

Application

To create a electrically conductive connection.

This compound will create a permanent connection with nearly all surfaces and can be casted to workpieces of every form and size.

EPL 701 has been proven to be reliable in hard-to-reach places.

Processing

The surfaces have to be dry and clean. The use of a primer is not necessary. The two-components (resin and hardener) are exactly fine-tuned to each other. There is no further need to weight out the components.

The resin has to be mixed up (do not use a metal stirrer) and after that the hardener component has to be

completely poured into the resin tin. After that the compound has to be mixed for about 3 minutes. During mixing it is important, that only few air bubbles are mixed into the compound.

The processing time is dependent on the ambient temperature. At lower temperatures you have longer and at higher temperatures you have shorter processing times. The final hardness will be reached after 3 days.

Storage

The original closed tins have to be stored in a dry and frost-free place. Open units must be used at once.

The processing-guarantee is 6 months after production date (see labels on the containers).

Hazardous / Safety advice

Follow the advice printed on the containers and the relevant safety data sheets for resin and hardener.