

Adhesives and Tooling

Tooling Systems

Araldite® Kit K36

Araldite® Epoxy Laminating System

Epoxy based general purpose laminating system for processing and curing at room temperature.

Applications	General purpose laminates
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Processing Methods	Impregnating Manually or with automatic mixing and dosing equipment
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Properties	Low initial viscosity Low shrinkage on curing Good thermal stability at temperatures of 20°C to 70°C Good mechanical properties
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Resin	Viscosity	at 25°C	mPa.s	500-1000
	Specific gravity	at 25°C	g/cm ³	1.1 - 1.15
	Flash point		°C	155
	As supplied form		Clear pale yellow liquid	
	Hazardous decomposition products		Carbon monoxide, carbon dioxide and other toxic gases and vapours if burned	
	Disposal		Regular procedures approved by national and/or local authorities	

Hardener	Viscosity	at 25°C	mPa.s	70-100
	Specific gravity	at 25°C	g/cm ³	0.98-1.02
	Flash point		°C	>100
	As-supplied form		Clear, pale, yellow liquid	
	Hazardous decomposition products		Carbon monoxide, carbon dioxide and other toxic gases and vapours if burned	
	Disposal		Regular procedures approved by national and/or local authorities	

Mix Ratio			Parts by weight	by volume
	Araldite® Kit K36	Resin	100	2 parts
		Hardener	50	1 part

To ensure complete curing of the system, this ratio must be strictly adhered to.

Processing Data (guideline values)	Usable life (750g mix)	15°C	45-55 Minutes
		25°C	30-40 Minutes
		35°C	15-20 Minutes
	Minimum Curing Time @	15°C	25-36 Hours
		25°C	18-24 Hours
		35°C	8-12 Hours
	Full Cure	25°C	7 Days

Processing Data	Pot life of 750gm mix at	15°C	45-55 Minutes
		25°C	30-40 Minutes
		35°C	15-20 Minutes
	Cure Time at	15°C	25-36 Minutes
		25°C	18-24 Hours
		35°C	8-12 Hours

Coverage With a 155 gsm plain weave glass cloth, 300-500 g/m²

Storage Store the components in a dry place at 18-25°C, in tightly sealed original containers. Under these conditions, the shelf life will correspond to the expiry date stated on the label. After this date, the product may be processed only after re-analysis. Partly emptied containers should be tightly closed immediately after use. For information on waste disposal and hazardous products of decomposition in the event of a fire, refer to the Material Safety Data Sheets (MSDS) for these particular products.

Remarks To determine whether cross linking has been carried to completion and the final properties are optimal, it is necessary to carry out relevant measurements on the actual object or to measure the glass transition temperature. Different gelling and cure cycles in the customer's manufacturing process could lead to a different degree of cross linking and thus a different glass transition temperature.

Handling precautions This Araldite® and Hardener have been formulated with the objective of being as safe as possible, however, in common with most epoxy resins and hardeners, consistent skin contact with uncured materials may cause irritation of sensitive skins. For this reason contact with the uncured materials should be avoided at all times.

Caution
 Vantico Pty Limited products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should also be taken to prevent the uncured materials from coming into contact with skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in Vantico Pty Limited Publication No. 24264/3/e Hygienic precautions for handling plastic products of Vantico Pty Limited and in the Vantico Pty Limited Material Safety Data sheets for the individual products. These publications are available on request and should be referred to for fuller information.

First Aid

- If Material enter eyes, flood with water for at least 15 minutes, then consult a doctor.
- If skin rashes or allergic responses (such as wheezing, swelling) occur, consult a doctor.
- If swallowed, DO NOT induce vomiting. Drink copious amounts of water and contact a doctor or the Poisons Information Centre.

If more specific information on toxicity and safe handling is required, the following publications are available from Vantico on request.

Material Safety Data Sheet

“Epoxy Resins - Instructions for Use, Handling and Disposal”.

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Vantico Pty Limited

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