



### EPIKOTE™ Resin MGS® LR 635

### EPIKURE™ Curing Agent MGS® LH633, -635, -635LV, -636, -637

## CHARACTERISTICS

<b>Approval</b>	DNVGL
<b>Application</b>	Rotor blades for wind turbines, boatbuilding as laminating and adhesive resins, sporting goods, molds, tools, and other devices
<b>Operational temperature</b>	-40 °C up to +70 °C after appropriate cure
<b>Processing</b>	At temperatures between 15 °C and 50 °C <b>With appropriate application, the LH633 curing agent can deliver cold cure performance at temperatures as low as 5°C</b>
<b>Features</b>	Pot life from approx. 10 min. up to more than 5 hours Curing agents can be mixed for intermediate reactivity
<b>Storage</b>	Shelf life of 24 months in originally sealed containers

## APPLICATION

Laminating resin EPIKOTE™ MGS® LR 635 is an epoxy-based laminating resin system with a wide range of applications. It contains neither solvents nor fillers and is used for processing of glass, carbon, and aramid fibers.

The available curing agents cover a wide reactivity range from very fast to very slow. Additionally, mixing of curing agents (e.g. LH633 and LH637) is possible to adjust reactivity to individual needs. After precuring at room temperature, the manufactured components are workable and demoldable, only for the very slow curing agent LH637 the manufactured component eventually will be a bit brittle. The final properties, however, will only be reached after postcure at temperatures of more than 40°C.

Due to the chemical characteristics of this system we do not expect any problems concerning compatibility (e. g. blistering, tearing or changes in color), when it is processed with gelcoats. However, comprehensive tests are indispensable.

For epoxy resins crystallization is immanently possible. In an early stage, crystallization is visible as a clouding, and can progress to a stage, where the resin becomes a wax- like solid. Crystallization can be reversed by slow heating of the product to approx. 40 - 60 °C. without restriction to quality after removal, in fact a high purity of material will increase a tendency for crystallization. Although LR 635 is very unlikely to crystallize at low temperatures, storage conditions of 15-30 °C are recommended.

After dispensing material, the containers must again be closed carefully, to avoid contamination or absorption of water. All amine hardeners show a chemical reaction when exposed to air, known as „blushing“. This reaction is visible as white carbamide crystals, which could make the materials unusable.

Curing agents are colored to facilitate an easier identification of a homogenous mixture. The color is only a visual aid and is therefore not exactly specified. Therefore, variations from batch to batch are possible. Furthermore, the color is not stable and can change over time. This can be especially observed for high reactive curing agents like LH633 or LH635 and in addition for all curing agents due to UV radiation. Accordingly, the color can change over time depending on reactivity of curing agent and



storage conditions (like exposure to sunlight), but this has no effect on the overall performance and does not constitute a quality complaint.

The materials have a shelf life of minimum 2 years, when stored in their originally sealed containers.

Due to selected raw materials, we expect minimal problems concerning skin irritation and allergies during processing. The relevant industrial safety regulations for the handling of epoxy resins and hardeners are to be observed.

## TYPICAL PROPERTIES

Property *)	Unit	Resin LR635	Curing agent	
			LH633	LH635
Density <sup>1)</sup>	g/cm <sup>3</sup>	1.15	1.03	1.06
Viscosity <sup>1)</sup>	mPa·s	3.200	170	185
Pot life <sup>2)</sup>	min		9	15
T <sub>G,ultimate</sub> <sup>3)</sup>	°C		87	87

Property *)	Unit	Curing agent			
		LH635LV	LH636	LH6367	LH637
Density <sup>1)</sup>	g/cm <sup>3</sup>	1.01	1.03	0.96	0.94
Viscosity <sup>1)</sup>	mPa·s	100	80	12	10
Pot life <sup>2)</sup>	min	12	25	130	310
T <sub>G,ultimate</sub> <sup>3)</sup>	°C	88	90	88	86

\*) These are typical values and should not be construed as specifications. Specifications are referenced on Certificate of Analysis

### Measuring conditions:

- 1) measured at 25°C
- 2) 100g mixture of LR 635 and curing agent in water bath at 30°C
- 3) DSC 20K/min, midpoint

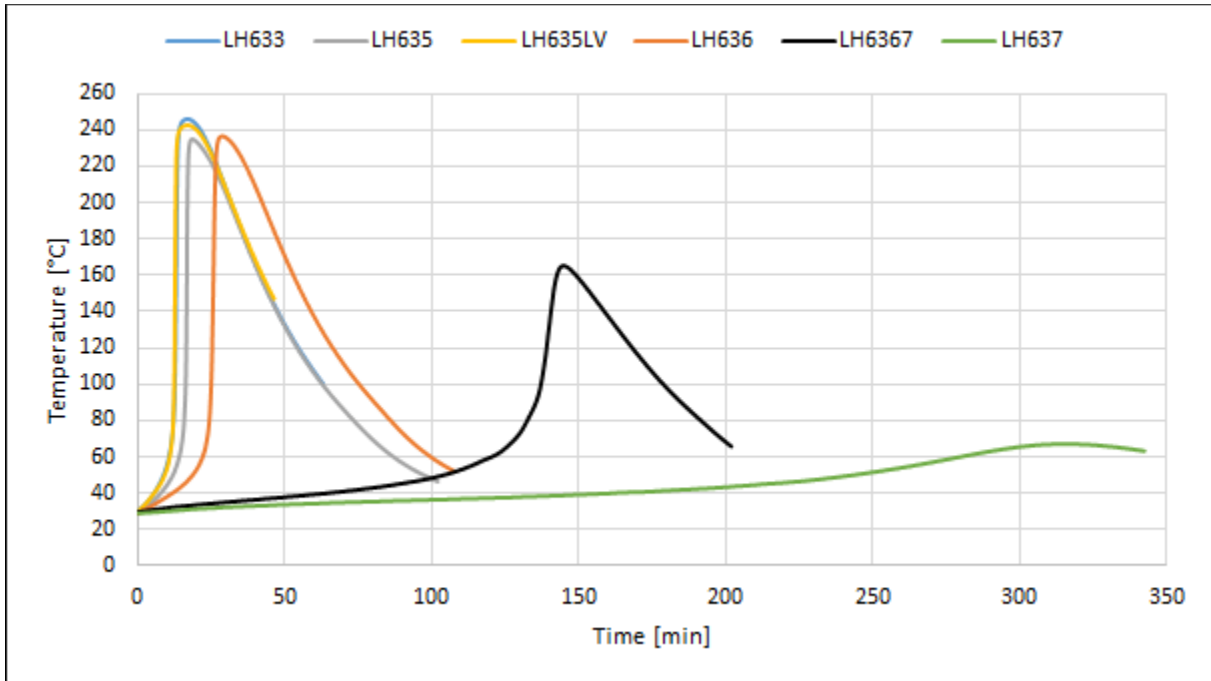
## MIXING RATIO

	Parts curing agent per 100 parts resin LR635					
	LH633	LH635	LH635LV	LH636	LH6367	LH637
Parts by weight	30 ± 2					
Parts by volume	34 ± 2	33 ± 2	34 ± 2	34 ± 2	36 ± 2	37 ± 2

The mixing ratio stated must be observed very carefully. Adding more or less curing agent will not result in a faster or slower reaction, but in incomplete curing which can't be corrected in any way. Resin and curing agent must be mixed very thoroughly. Pay special attention to the walls and bottom of the mixing container.



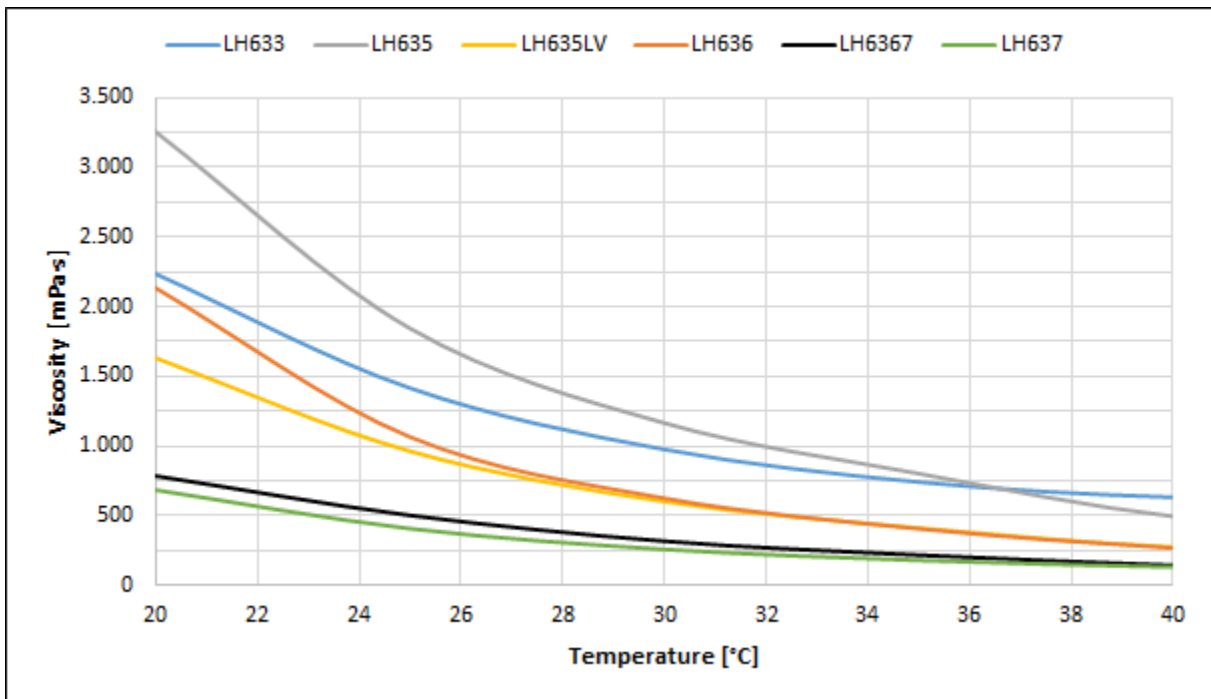
### TEMPERATURE DEVELOPMENT



#### Measuring conditions:

measured 100g in a paper cup with a lid isolated in a water bath at 30°C; starting at 30°C

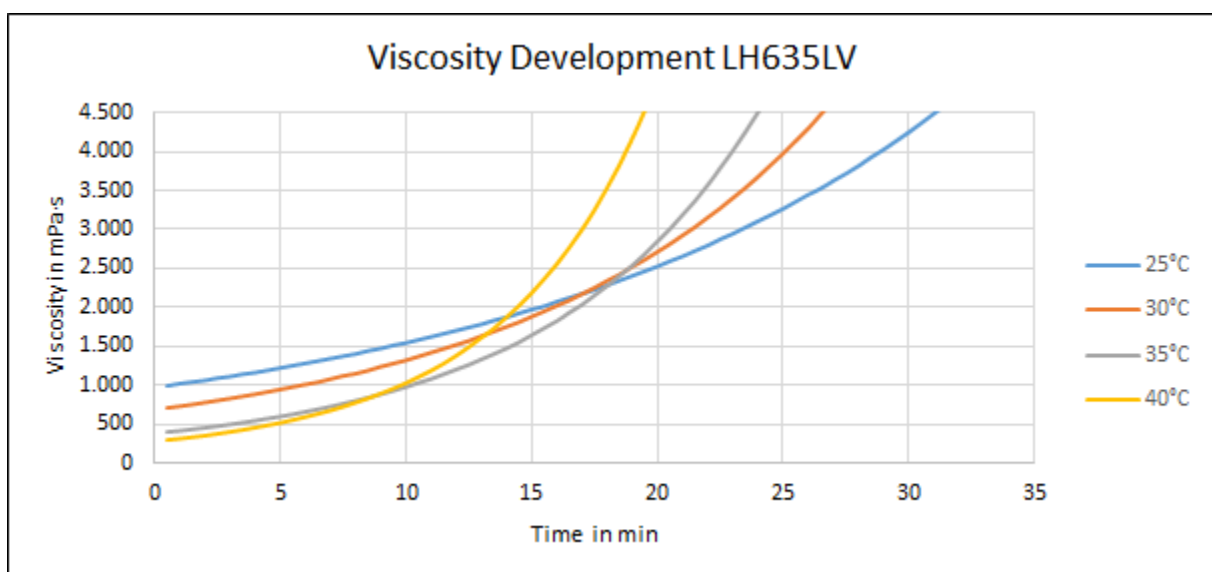
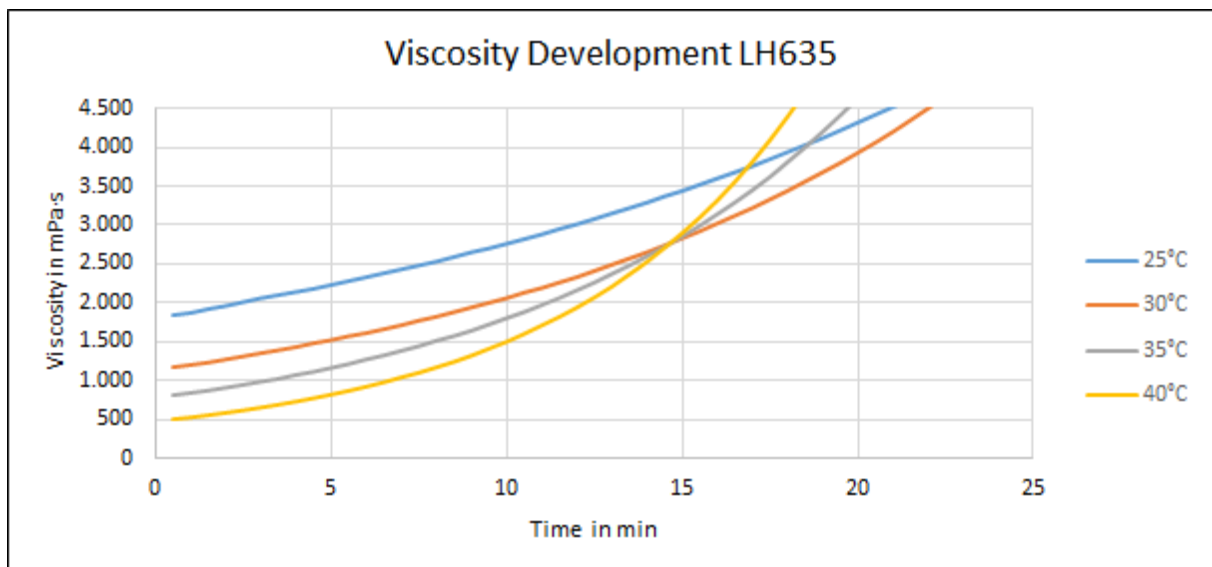
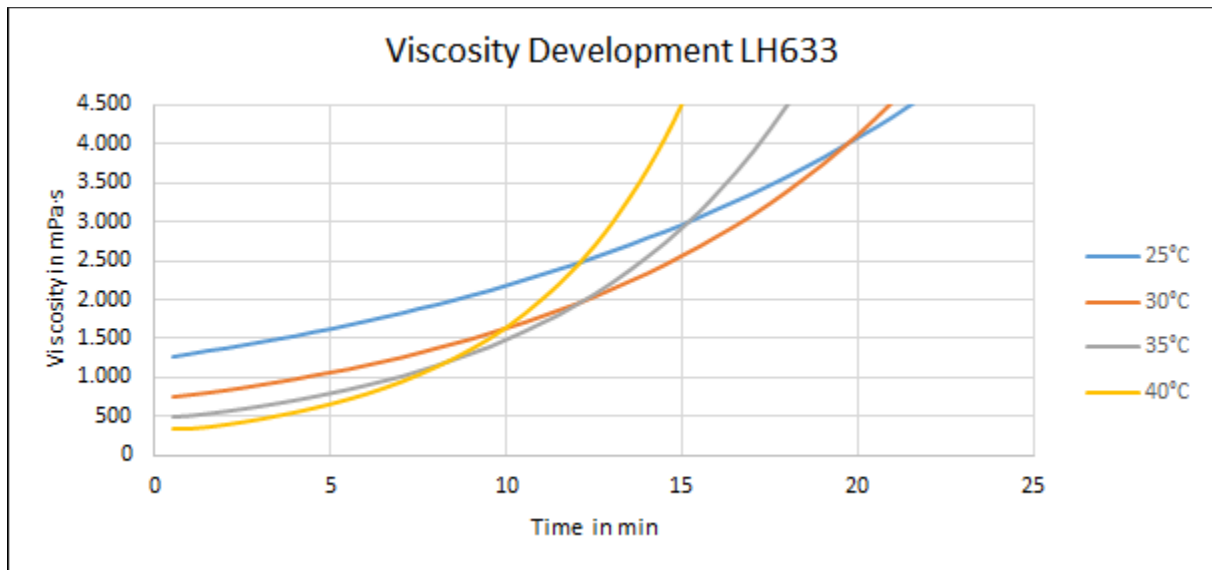
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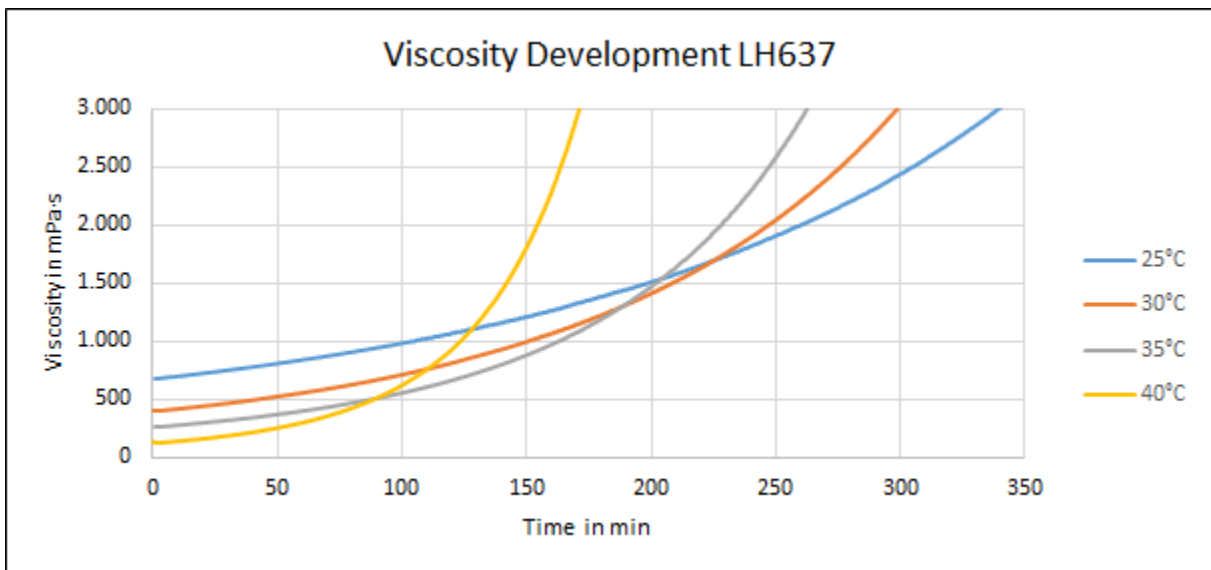
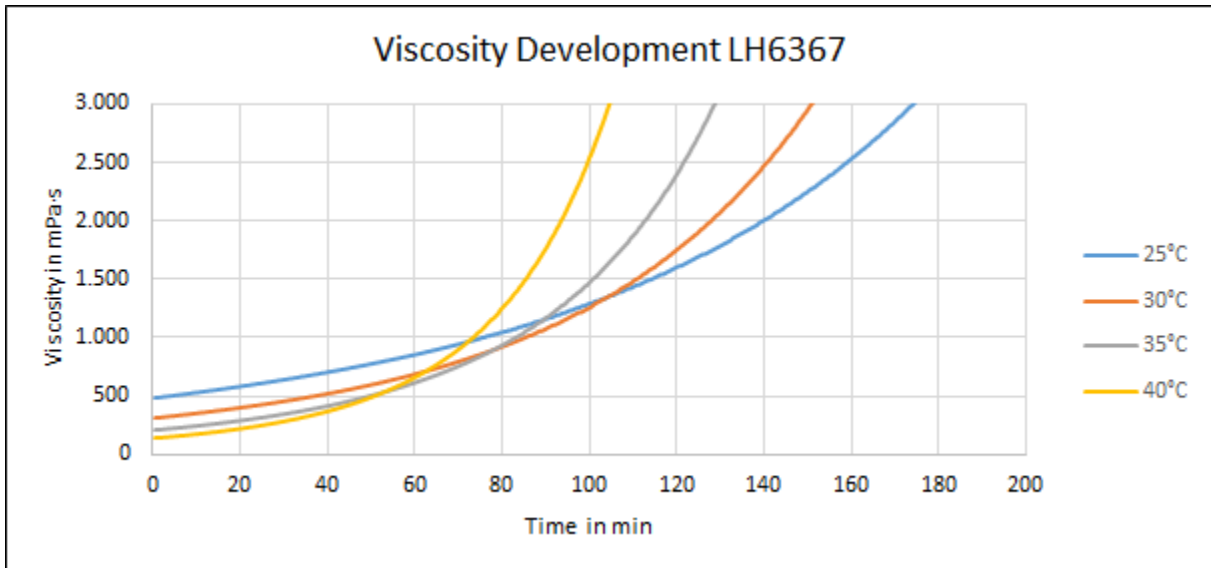
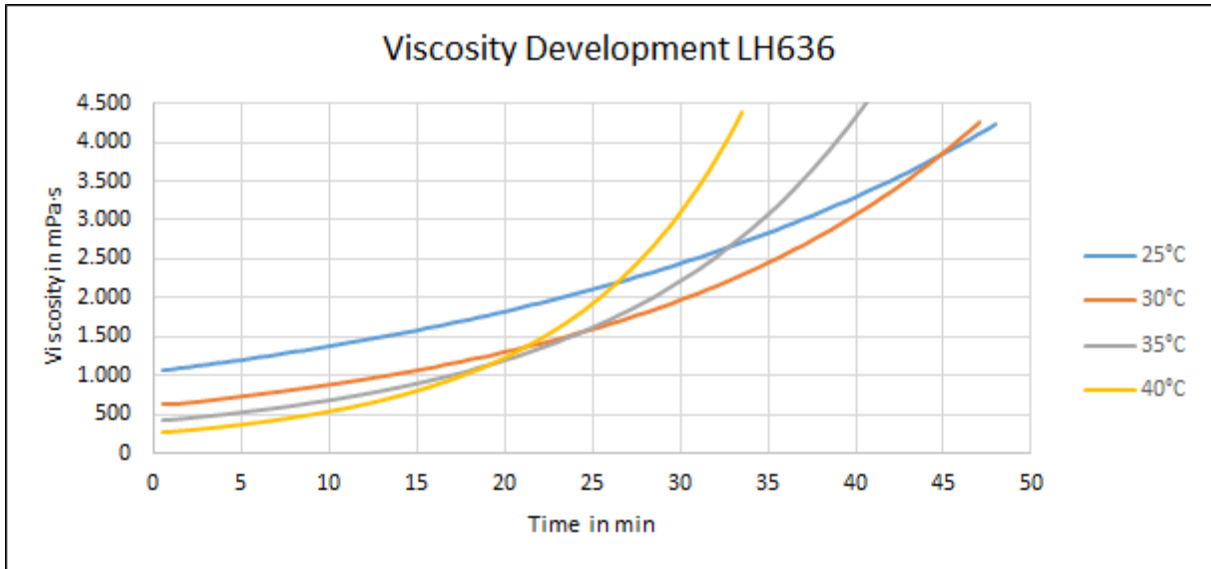


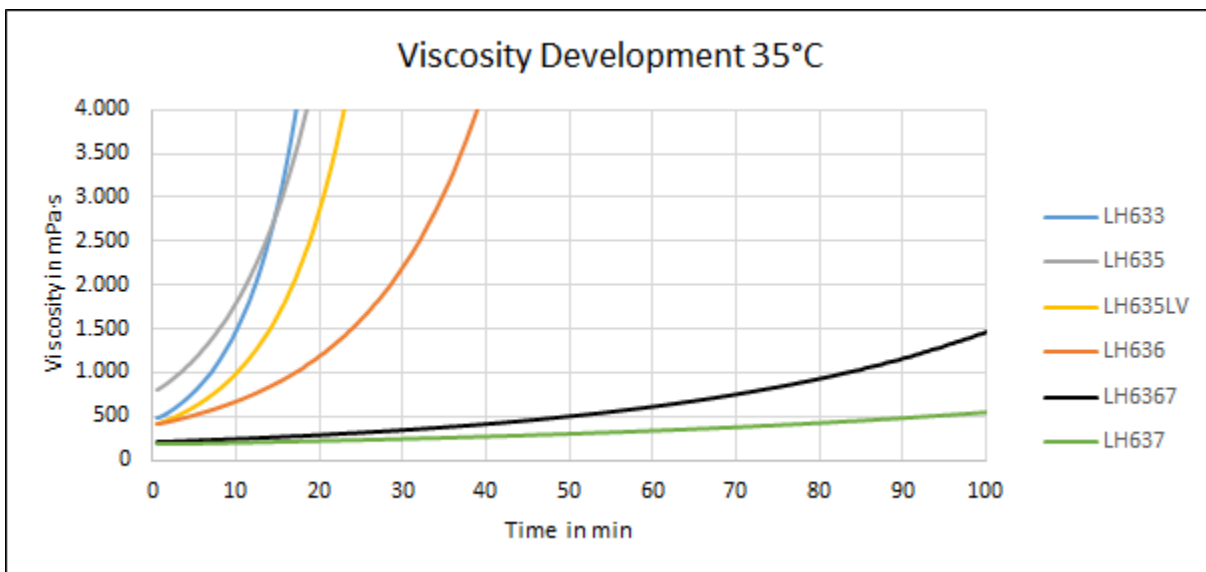
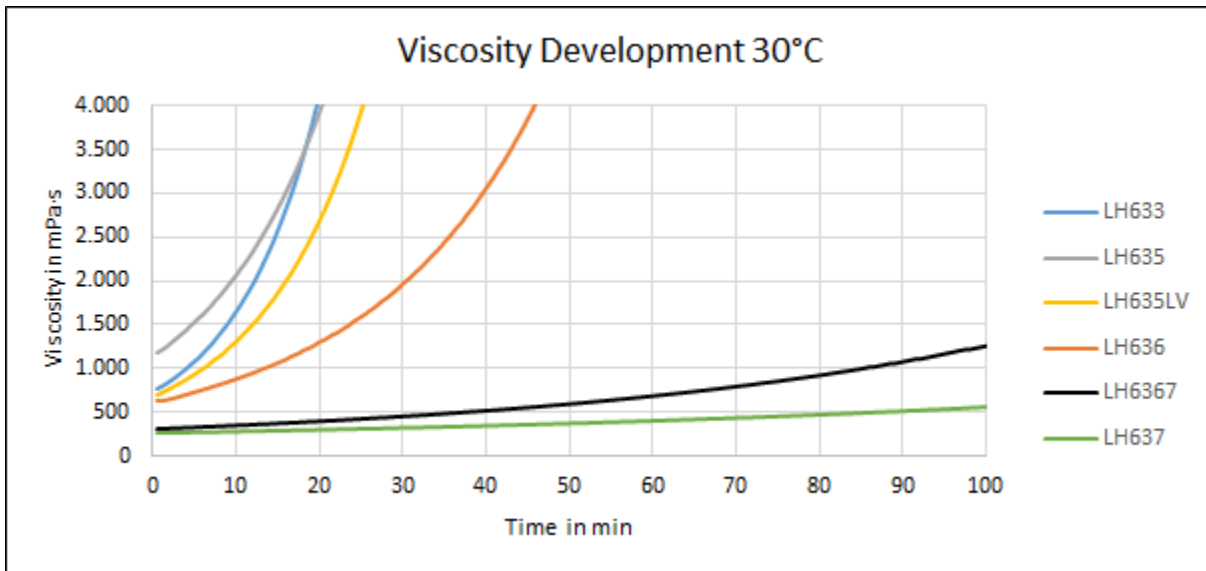
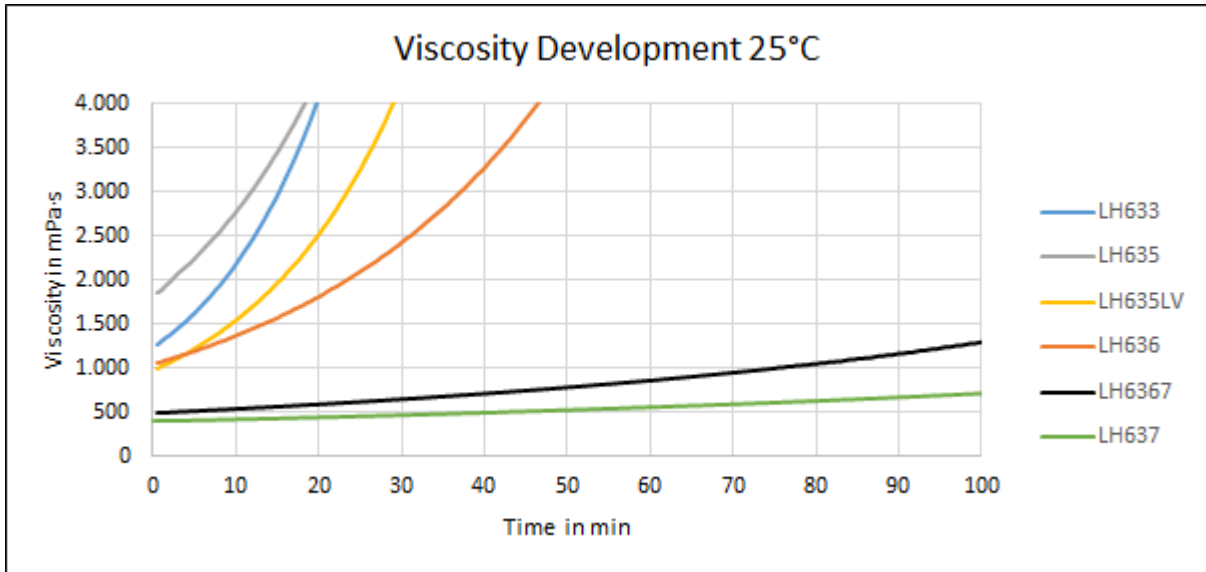
Measuring conditions: Rheometer, CP50-1, measuring gap 0.1mm

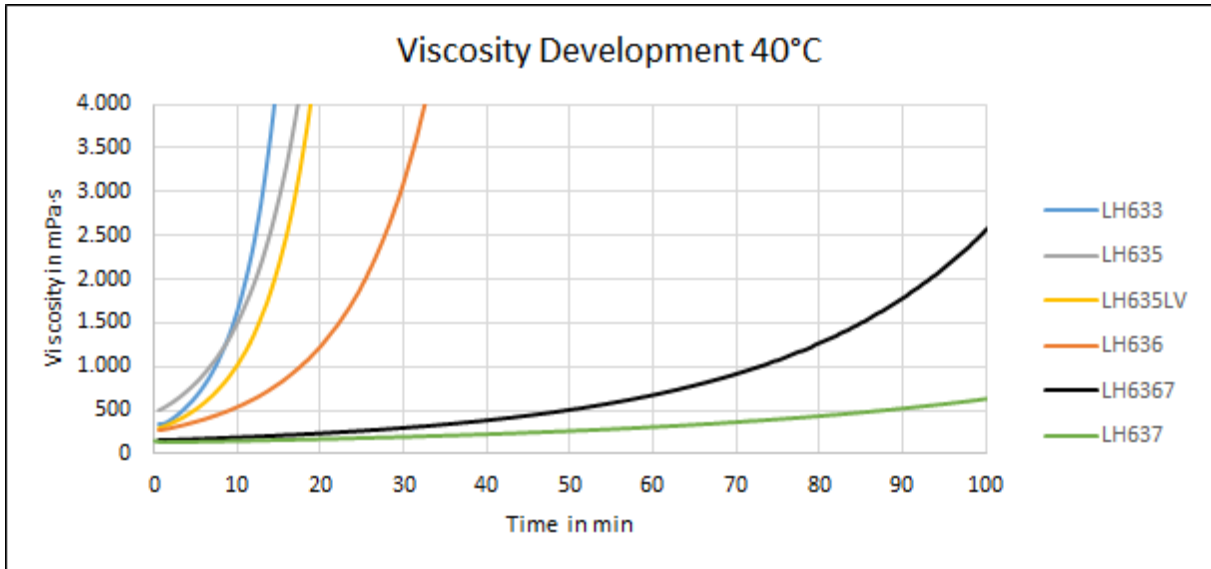


### VISCOSITY DEVELOPMENT



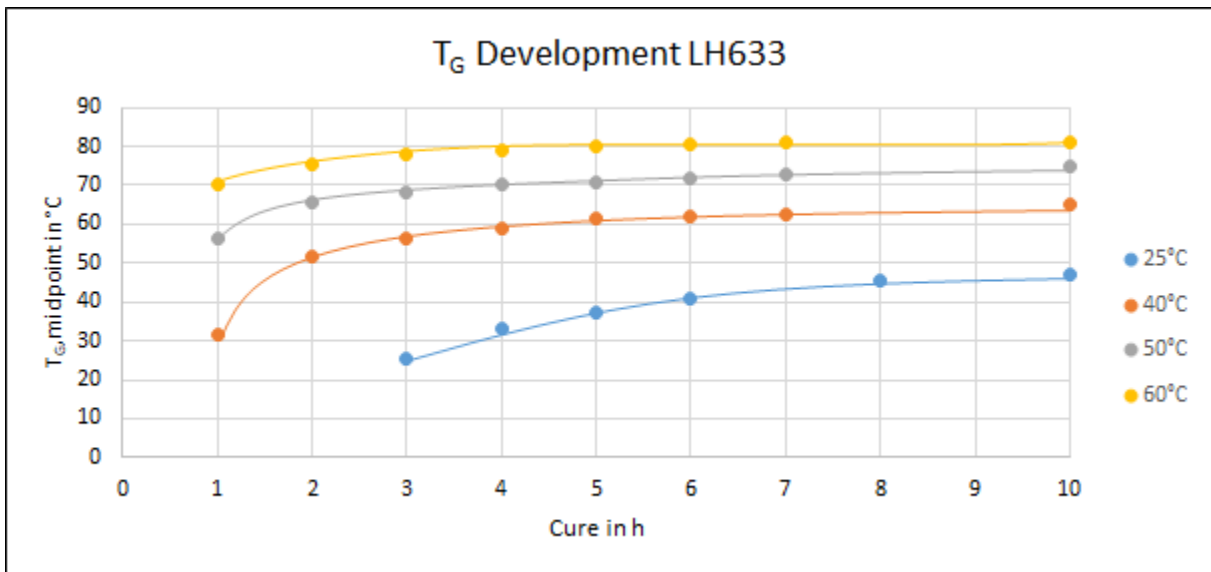


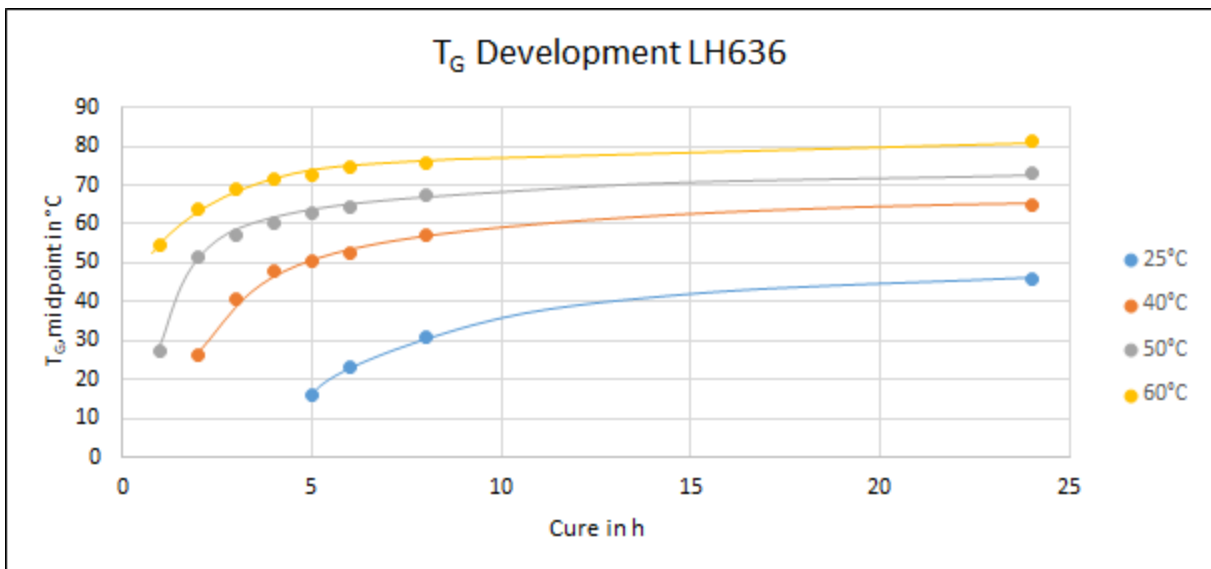
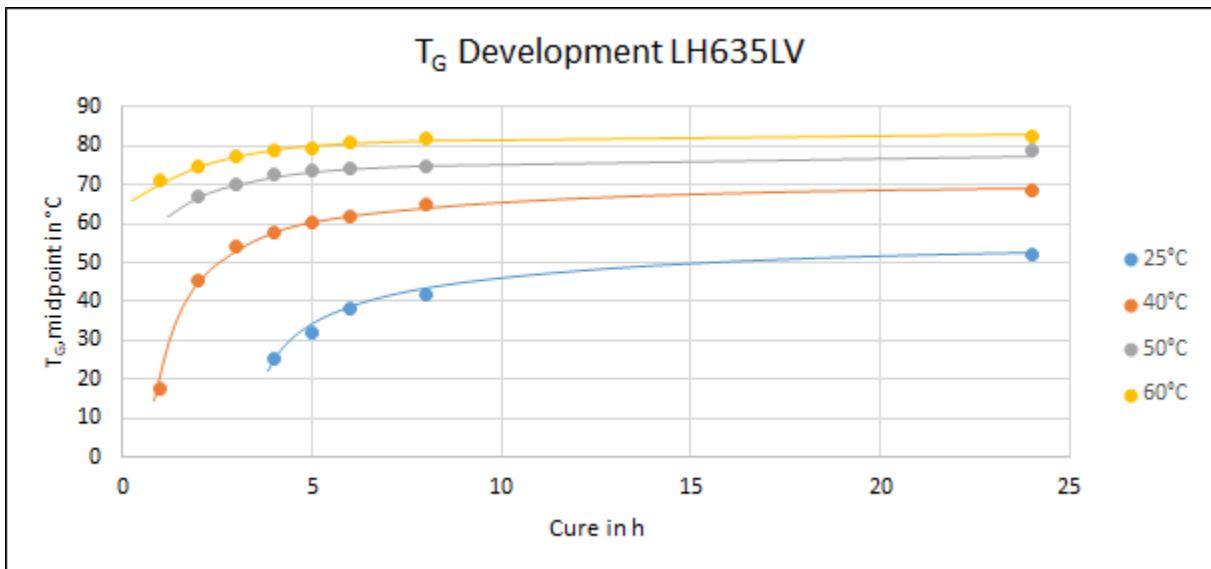
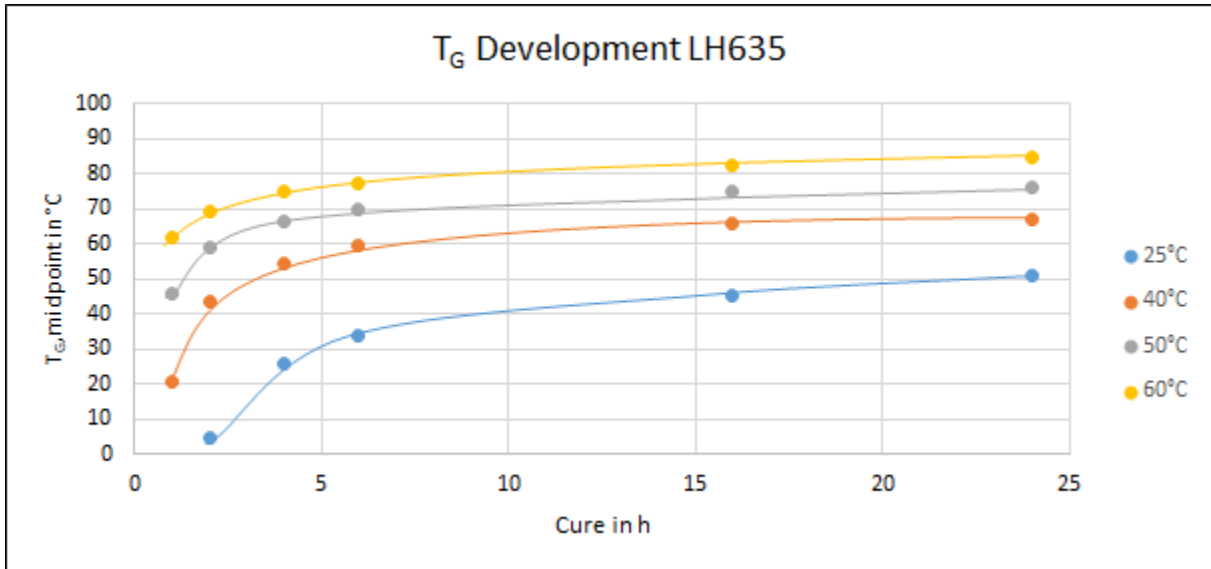




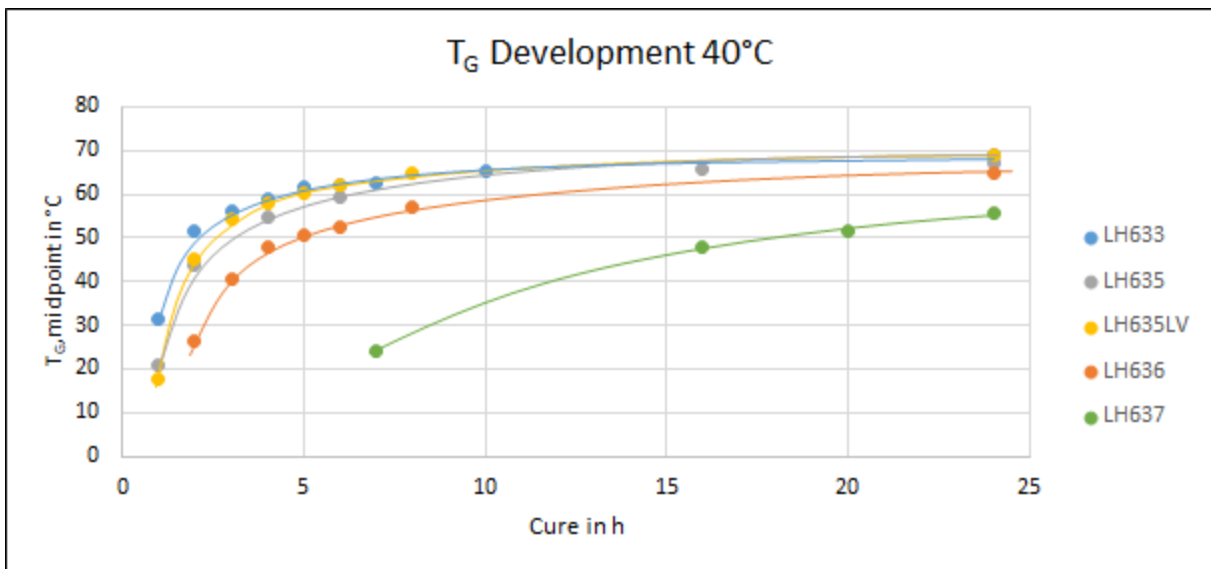
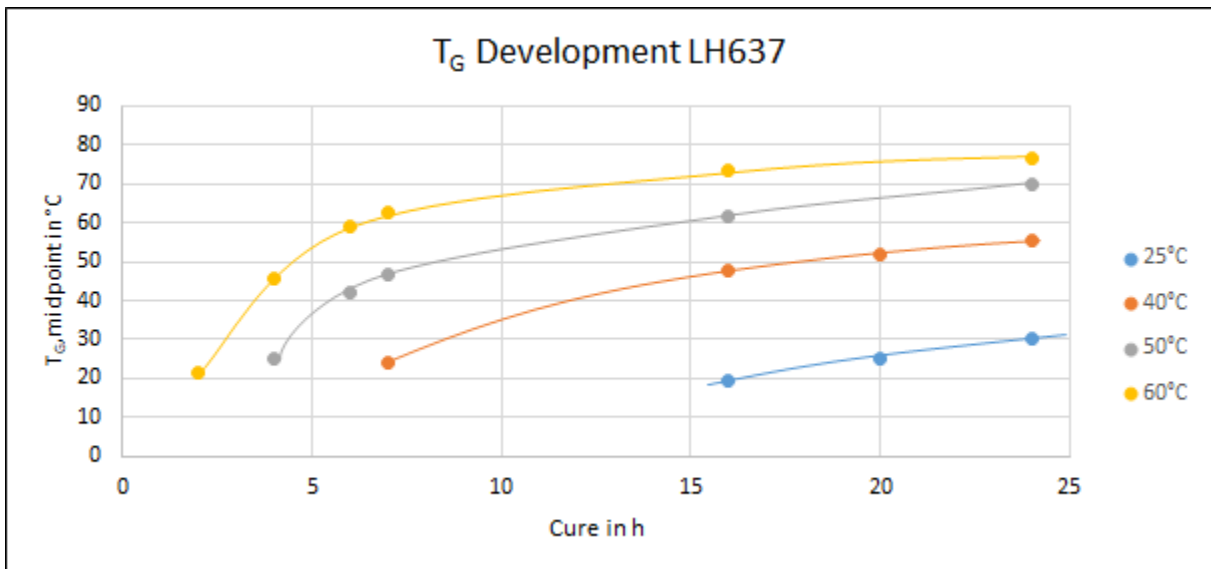
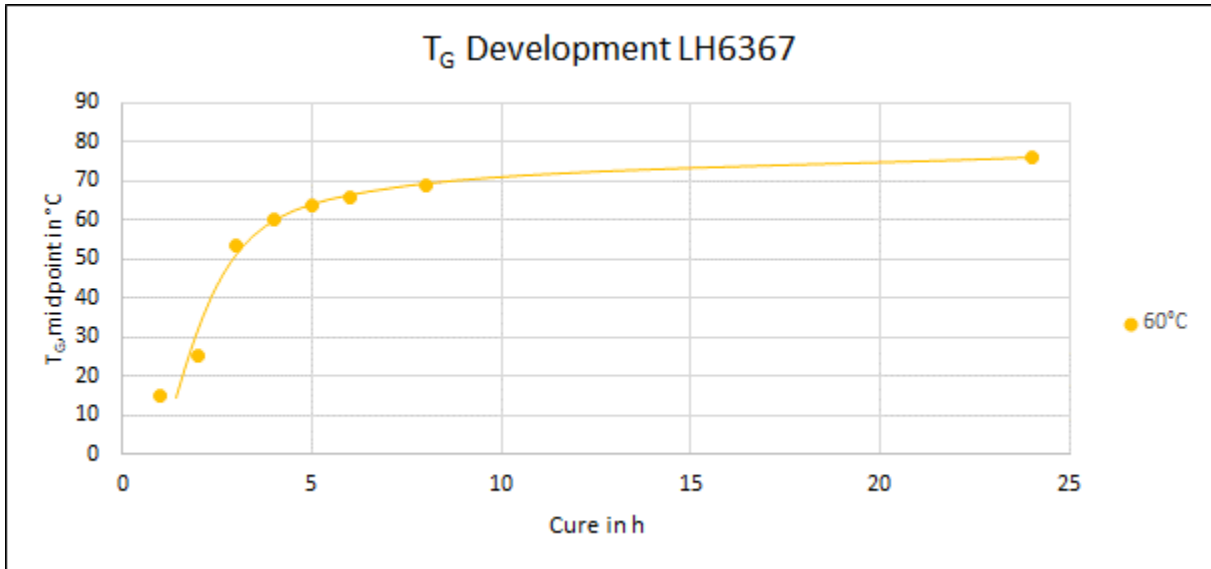
Measuring conditions: Rheometer, CP50-1, measuring gap 0.1mm

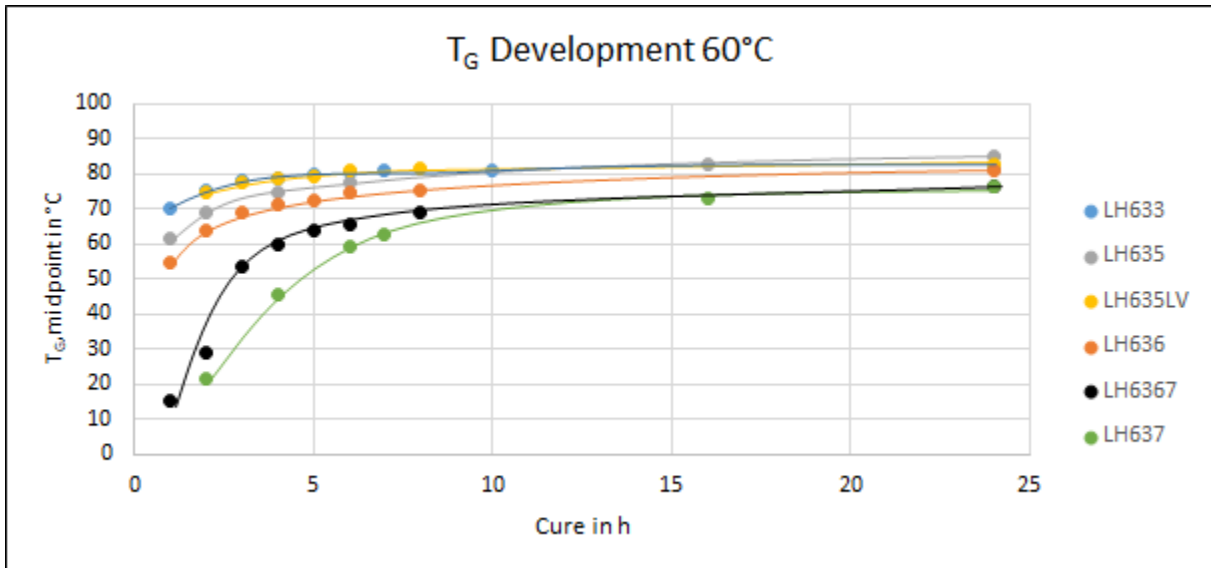
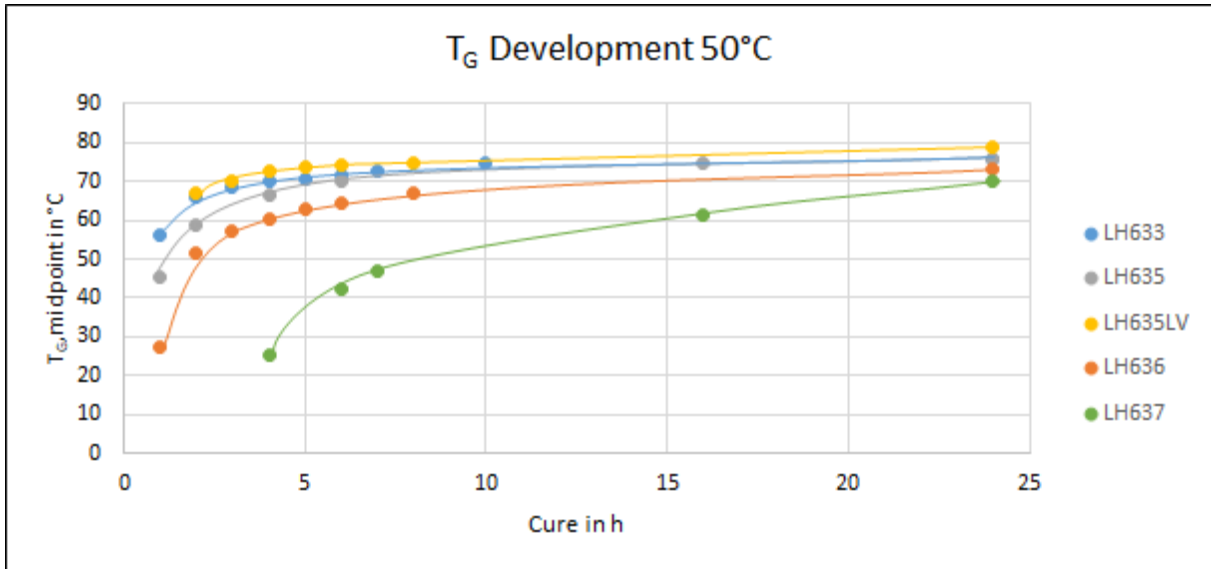
### T<sub>G</sub> DEVELOPMENT











**Measuring conditions:** DSC-measuring heat rate: 20°C/min, sample mass 10-20 mg

**PHYSICAL AND MECHANICAL DATA**

Property	Unit	LH633	LH635	LH635LV	LH636	LH637
<b>Cured density</b>	g/cm <sup>3</sup>	1.15 – 1.20				
<b>Tensile Modulus</b> DIN EN ISO 527-2	GPa	~ 3.4	~ 3.6	~ 3.4	~ 3.6	~ 3.2
<b>Tensile strength</b> DIN EN ISO 527-2	MPa	~ 80	~ 85	~ 80	~ 85	~ 70
<b>Elongation at break</b> DIN EN ISO 527-2	%	~ 7	~ 6	~ 8	~ 7	~ 8
<b>Flexural modulus</b> DIN EN ISO 178	GPa	~ 3.3	~ 3.8	~ 3.3	~ 3.5	~ 3.3
<b>Flexural strength</b> DIN EN ISO 178	MPa	~ 130	~ 140	~ 125	~ 140	~ 115

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