

Technical Data Sheet

Castropox[®] 1233 A/B1/B2/B3

Characteristics Low viscosity epoxy injection system with different pot lives

Properties and Fields of Application *Castropox 1233 A/B* is a low viscous epoxy system designed for injection technologies like RTM and SCRIMP. This epoxy system is suitable for the production of high performance laminates for the automotive industry, marine applications, wind mill rotor blades and sport equipment.
Due to special hardeners the range of pot life is between approx. 0,5 and 4 h. The curing temperature is 6h @ 70°C, but higher curing temperature (80-120°C) is possible (e.g. 8h @ 80°C).
The mixing viscosity is very low, but it may be lowered to 150 mPas by heating the resin up to 30°C. The resin system does not contain any non-reactive components. Therefore the processing under vacuum even at elevated temperatures is possible.

Typical Data	Property	Unit	Comp A	B1	B2	B3
	Viscosity @ 25°C	mPas	700-1000	10-30	10-30	10-30
	EEW	g/equiv.	165-175	-		
	Amine equivalent	g/equiv.	-	50	51	51
	Density @ 20°C	g/cm³	1.14-1.16	0,95-0,98	0,93-0,95	0,92-0,94
Mixing Ratio	Parts by Weight	pbw	100	30	30	30
Typical System Properties	Viscosity of Mixture @ 25°C	Pas		0,29 - 0,34	0,25 - 0,30	0,25 - 0,30
	Pot life (100g) Temp. 23-40°C	min		20	60	100
	Pot life (100g) Tecam	h		0,5	1,5-2,0	3-4
Properties of Cured Resin	Curing condition: 6 h @ 70 °C					
	Flexural Strength	MPa		110	103	101
	Tensile strength	MPa		69	62	58
	E-Modulus	Mpa		3900	3580	4810
	Tg (DSC mid point)	°C		92	81	74

Shelf Life & Storage Store this material in a clean, dry environment in its tightly closed original container. These products are not considered especially temperature or moisture sensitive, but should ideally be stored at temperatures between 18-25°C and kept from moisture contamination. Storage at lower temperatures could lead to crystallization and may require the application of heat to reverse. If the product appears crystalline or is thicker than normal when opened, heat for 4-6 hours at 65°C to re-liquefy prior to use. If the recommended storage conditions are observed the products will have a minimum shelf-life of 6 months from the date of shipment.

Occupational Safety Mandatory and recommended industrial hygiene procedures should be followed whenever these products are being handled and processed. For additional information please consult the corresponding material safety data sheets

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