

TECHNIREZ R2532 is a solvent free, glass-fibre reinforced epoxy paste specifically designed for use with H2406 and H2421 hardeners that cures at room temperature and is suitable for tooling, foundry and pattern making applications.

Mixed resin and hardener produces an easily hand-workable laminating paste. High temperature applications such as pre-preg moulds can be produced with a combination of R2532 and H2421 hardener.

MIX RATIO

15 parts H2406 hardener to 100 parts resin by weight
 15 parts H2421 hardener to 100 parts resin by weight

Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.

UNCURED PROPERTIES			
	R2532	H2406	H2421 high temp
Physical State	White fibrous paste	Blue low viscosity liquid	Red low viscosity liquid
Viscosity mPas@25°C	-	850	750
Specific Gravity g/ml@25°C	1.07	0.96	0.97
Flash Point	>155°C	140°C	140°C

CURE CHARACTERISTICS		
	H2406	H2421
Pot Life - 100g @25°C (in air)	80-90 minutes	50-60 minutes
Demold Time	20-24 hours	20-24 hours
HDT*	45°C	110°C

* After post curing at 60°C for 10 hours

TYPICAL CURED PROPERTIES		
	H2406	H2421
Flexural strength	30-40 MPa	30-40 MPa
Flexural modulus	4.5-5.5 GPa	4.5-5.5 GPa
Linear shrinkage	0.2-0.3%	0.2-0.3%

APPLICATION

The resin and hardener must be accurately measured and mixed carefully to avoid air entrapment.

Apply by brush a coat of either TECHNIREZ R2523 or R2524 gelcoat to a minimum thickness of 1.5mm or as specified on the tool drawing.

Fillet sharp corners with a mix of TECHNIREZ laminating resin and hardener and WEST SYSTEM® 413 Microfibre Blend, to reduce the chance of air entrapment between the gelcoat and the laminating paste.

Apply a coupling layer of TECHNIREZ laminating resin and hardener to the firm gelcoat, before the first layer of laminating paste is applied to the surface.

Build up the required tool thickness by hand forming R2532 Laminating Paste mixture onto the tool, **WEAR PROTECTIVE GLOVES** taking care to work the paste thoroughly into the corners and to remove the air bubbles.

MOULD PREPARATION AND RELEASE COMPOUNDS

Metal and plastic surfaces do not require sealing, but gypsum, cement, wood and plaster surfaces should be coated with lacquer before applying polyvinyl alcohol film. *PVA is soluble in water - a wet or damp gypsum, or plaster, mould may prevent the film from thoroughly drying. Lacquer serves as a moisture barrier.*

Before applying the PVA, wax the lacquered surface to assist the removal of the epoxy casting from the mould.

PACK SIZES

Order Code			
Resin		Hardener	
RD 2532	15 kg	HC 2406	2.25 kg
		HC 2421	2.25 kg
		HE 2421	15 kg

STORAGE

TECHNIREZ R2532 resin and H2406 and H2421 hardeners will keep for 2 years if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

HEALTH AND SAFETY

TECHNIREZ R2532 resin and H2406 and H2421 hardeners have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
 - If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with water, avoiding the use of solvents except in the case of massive contamination.
 - If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
 - If swallowed:
- Resins** - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.
- Hardeners** - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 18.4.17

