

**EN Product Information**

**Elan-tech**®  
EC 152/AW 92      100:50

**2-component thixotropic adhesive for connecting layer epoxy system - extra slow curing time at RT**

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Resin  
**EC 152**

Hardener  
**AW 92**

Mixing ratio by weight  
**100:50**

**Application:** Connecting layer on cured fiber reinforced systems obtained by wet lay-up technique.

**Processing:** Brush application as a gelcoat or as connecting layer. Room temperature curing.

**Description:** Two component unfilled epoxy system. The use of system improves adhesion on hardened laminates in epoxy resin after sanding

**SYSTEM SPECIFICATIONS**

**Resin**

Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	1.200	1.800
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**Hardener**

Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	55.000	85.000
Gelation time	50°C	IO-10-52b (UNI 8701)	min	45	65

**TYPICAL SYSTEM CHARACTERISTICS**

**Processing Data**

Resin Colour				Pale/yellow	
Hardener Colour				Blue	
Mixing ratio by weight		for 100 g resin	g	100:50	
Mixing ratio by volume		for 100 ml resin	ml	100:60	
Density	25°C Resin	IO-10-51 (ASTM D 1475)	g/ml	1,13	1,17
Density	25°C Hardener	IO-10-51 (ASTM D 1475)	g/ml	0,93	0,97
Pot life	25°C (40mm;100ml)	IO-10-53 (*)	min	65	80
Exothermic peak	25°C (40mm;100ml)	IO-10-53 (*)	°C	50	60
Gelation time	25°C (1mm)	IO-10-88 (ASTM D5895-03)	h	8	10

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**TYPICAL CURED SYSTEM PROPERTIES**

**Properties determined on specimens cured: 24 h TA + 15 h 60°C**

Colour				Blue
Machinability				Excellent
Density 25°C		IO-10-54 (ASTM D 792)	g/ml	1,06 1,10
Hardness 25°C		IO-10-58 (ASTM D 2240)	Shore D/15	80 84
Glass transition (Tg)	48h TA	IO-10-69 (ASTM D 3418)	°C	42 48
	7gg/days TA		°C	54 60
	24 h TA + 15 h 60°C		°C	79 85
Max recommended operating temperature		(***)	°C	80

IO-00-00 = Elantas Italia's test method. The correspondent international method is indicated whenever possible.

nd = not determined na = not applicable RT = TA = laboratory room temperature (23±2°C)

Conversion units: 1 mPas = 1 cPs 1MN/m2 = 10 kg/cm2 = 1 MPa

(\*) for larger quantities pot life is shorter and exothermic peak increases

(\*\*) the brackets mean optionality

(\*\*\*) The maximum operating temperature is given on the basis of laboratory information available being it function of the curing conditions used and of the type of coupled materials. For further possible information see post-curing paragraph.

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- Instructions:** Verify and when necessary, homogenize the components before use. Add the appropriate quantity of hardener to the resin, mix carefully. Avoid air trapping. For the surface preparation (mould or model) refer to the release agents data sheet.
- Curing / Post-curing:** Post curing is always advisable for RT curing systems in order to stabilize the component and to reach the best mechanical properties. Users should evaluate the best conditions of curing or post-curing depending on the component size and shape. Post cure the tool as stated in the table, increasing gradually 10°C/hour.
- Storage:** Epoxy resins and their hardeners can be stored for two years in the original sealed containers stored in a cool, dry place. The hardeners are moisture sensitive therefore it is good practice to close the vessel immediately after each use.
- Handling precautions:** Refer to the safety data sheet and comply with regulations relating to industrial health and waste disposal.

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The information given in this publication is based on the present state of our technical knowledge but buyers and users should make their own assessments of our products under their own application conditions.