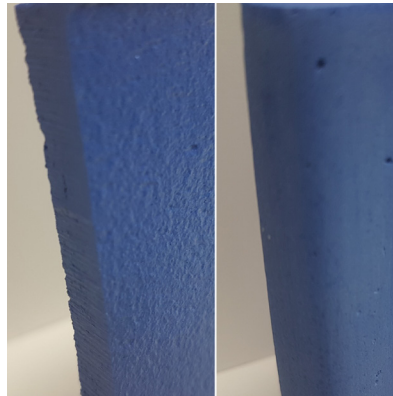
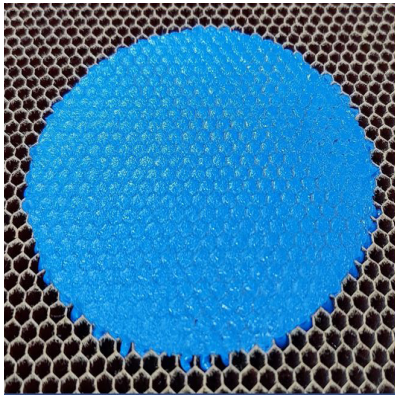


resoltech 8060

Hardener 8068

High T_g epoxy filler



- T_g up to 119°C
- Fast curing
- Easy sanding
- Suitable for radio-electric applications

INTRODUCTION

RESOLTECH 8060 / 8068 filler is an epoxy formulated for profiling or repairing parts with **high temperature resistance** demand.

After curing at ambient temperature, a post-curing at 60°C will be needed to release from the mold.

To reach optimal mechanical and thermomechanical properties with **T_g up to 119°C**, a post-curing of 4 hours at 120°C is required.

RESOLTECH 8060 / 8068 is suitable for radio-electric applications as radome.

MIXING RATIO

The mixing ratio must be accurately followed. It is not possible to change the ratio, it would result in lower mechanical properties.
The mixture should be thoroughly stirred to ensure full homogeneity.

Systems	8060 / 8068
Mixing ratio by weight	100/40
Mixing ratio by volume	100/45

APPLICATION

- It is recommended to use products at a **temperature close to 18-25°C** in order to facilitate the mixing and the reinforcements impregnation.
- Lower temperatures will increase the viscosity of the mixture and the gel time
- On the contrary, a higher temperature will reduce the viscosity of the mixture as well as the pot life.

PHYSICAL CHARACTERISTICS

1 Visual aspect

8060 :
Blue paste

8068 :
White to yellowish paste

Mix :
Blue paste

2 Density

References	8060	8068
Density at 23°C	0.83	0.65
Mix density at 23°C	-	0.78

ISO 1675, ± 0.05 tolerance

3 Viscosity

References	8060	8068
Viscosity at 23°C (mPa.s)	90 000	30 000
Mix viscosity at 23°C (mPa.s)	-	50 000

Measured with rheometer, shear rate 20s⁻¹, gap 1mm, 2min, ± 15% tolerance

4 Water absorption

System	8060 / 8068
Water absorption	0.10 %

According to ISO 62

REACTIVITIES

System	8060 / 8068
Gel time on 70mL at 23°C* (4cm high)	23min
Time at exothermic peak on 70mL at 23°C	28min
Temperature at exothermic peak on 70mL at 23°C	120.7°C
Gel time on 1mm film at 23°C**	1h20min

* Gel time measurements realized with Rheotech*

** Gel time on film measurement realized on rheometer

RETICULATION & POST-CURING

In order to obtain the maximum thermo-mechanical properties, it is necessary to respect the recommended curing cycle. The table below shows the glass transition temperatures (DSC) according to different curing cycles.

System		8060 / 8068
4h at 120°C	T _g	119°C
	Shore D Hardness	70

T_g measured by DSC, 10°C/min, inflexion point
Shore D hardness measured at 23°C according to ISO 868

Post-curing cycles previously presented were chosen in order to reach the maximum potential of each systems. Depending on parts size, oven performance and hardener used, shorter post-curing cycles could lead to fully cured parts.

Please contact our laboratory service for any help on post-curing cycles.

2 Temperature stability

Curing cycles	% of expansion over 1 cm (thickness)
After 2 h at 60°C + 4h at 120°C	0.52%
After cooling back at 23°C	0.29%

MECHANICAL PROPERTIES

System		8060 / 8068
4h at 120°C	FLEXION Modulus	1.93 GPa
	Maximum strength	29.5 MPa
	Elongation at max strength	1.71%
	Elongation at break	1.71%

Flexion properties on pure resin according to ISO 178

RADIOELECTRIC TRANSPARENCY

System		8060 / 8068
Frequency	ε'	11 - 15 GHz
	tg Δ	2.4
		0.025

PACKAGING

- Metal box kit of 0.5kg + 0.2kg
- Metal bucket kit of 3kg + 1.2kg
- Metal bucket kit of 18kg + 7.2kg

TRANSPORT & STORAGE

Keep containers sealed and away from heat and cold preferably between 10°C and 30°C in a well ventilated area. Our products are guaranteed in their original packaging (check expiry date on the label).

HEALTH & SAFETY

Skin contact must be avoided by wearing protective nitrile gloves & overalls or other protective clothing. Eye protection should be worn to avoid risk of resin, hardener, solvent or dust entering the eyes. If this occurs flush the eye with water for 15 minutes, holding the eyelid open, and seek medical attention.

Ensure adequate ventilation in work areas. Respiratory protection should be worn with ABEKP coded filters.

Resoltech issues full Material Safety Data Sheet for all hazardous products. Please ensure that you have the correct MSDS to hand for the materials you are using before commencing work.



The data provided in this document is the result of tests and is believed to be accurate. We do not accept any responsibility over the mishandling of these products and our liability is limited strictly to the value of the products we manufacture and supply.



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