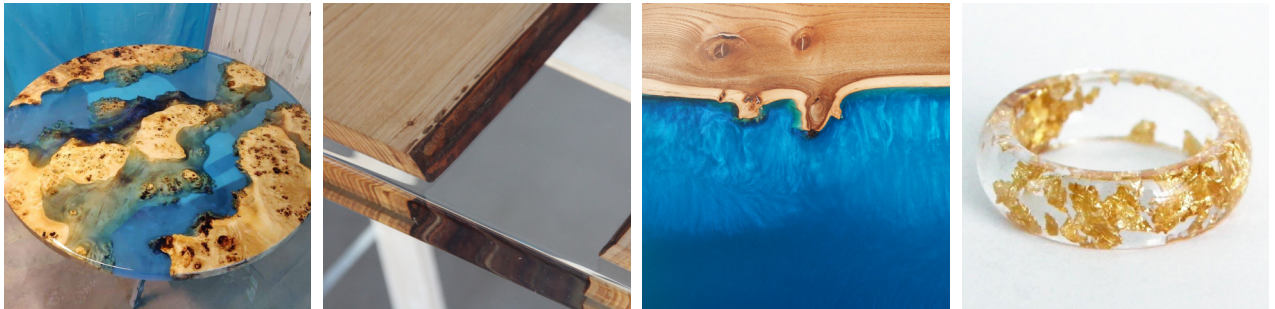


AC26

Epoxy accelerator for WWA & WWA ECO resins



- Enables custom made reactivities
- For WWA & WWA ECO resins
- Improved shelf life compared to WWAS
- No yellowing of the liquid resin over time
- Compatible with all WWA hardeners

INTRODUCTION

AC26 is an epoxy accelerator for WWA & WWA ECO resins.

The use of AC26 allows to adjust the reactivity of the system in order to improve productivity by adding & mixing 1-10 parts of accelerator in the resin before adding the hardener.

At those ratios, AC26 does not significantly modify the other properties of the system (hardness, rigidity...).

AC26 can be used with WWB4 and WWB HT hardeners.

MIXING RATIO

WARNING : Always mix the AC26 in the resin before adding and mixing the resin with the hardener.

| System | WWA (ECO) / AC26 / WWB4 | WWA (ECO) / AC26 / WWB HT |
|------------------------|-------------------------|---------------------------|
| Mixing ratio by weight | 100 / 1 to 10 / 40 | 100 / 1 to 10 / 30 |

Example :

100g of WWA resin / 1 to 10g of AC26 / 40g of WWB4

APPLICATION

CAUTION, the use of AC26 will :

- reduce the gel time
- increase the exotherm temperature
- reduce the time before demolding

Always procede step by step when adding and increasing the AC26 ratio. Adding too much AC26 may cause high exotherm temperatures that could lead to yellowing, shrinkage, bubbles and cracks.

Mixing :

1. Add the selected amount of AC26 in the WWA(ECO)
2. Stirr thoroughly to ensure full homogeneity.
3. Add the corresponding amount of hardener.
4. Stirr thoroughly to ensure full homogeneity.

Customers who are seeking to match WWAS reactivity will need to add 10 parts of AC26 in 100 parts of WWA resin.

PHYSICAL CHARACTERISTICS

1 Visual aspect

AC26 :

Clear to slightly yellow liquid

2 Viscosity

| Reference | AC26 |
|---------------------------|------|
| Viscosity at 23°C (mPa.s) | 200 |

ISO 12058.2, ± 15% tolerance

MAXIMUM THICKNESS

This tables indicates the maximum thicknesses to be casted according to the ratio of AC26 added

| System / ratios | 0 part of AC26 | 5 parts of AC26 | 10 parts of AC26 |
|--------------------|----------------|-----------------|------------------|
| WWA (ECO) - WWB4 | 9 cm | 2.5 cm | 1 cm |
| WWA (ECO) - WWB HT | 4 cm | 1 cm | 0.5 cm |

Those values were measured in polypropylene molds, 10cm diameter at 23°C
Maximum thickness will depend on the temperature, the nature of the molds and the volume to be casted.
It is mandatory to always proceed to test before casting new parts.

REACTIVITIES

| System | WWA (ECO) / WWB4 | | | | | |
|-----------------------------------------|------------------|----------|---------|---------|---------|----------|
| AC26 ratio | 0 part | 2 parts | 4 parts | 6 parts | 8 parts | 10 parts |
| Gel time on 70 mL at 23 °C* (4 cm high) | 27h20min | 11h50min | 7h10min | 4h10min | 2h20min | 1h |

* Gel time measurements realized with Rheotech*

PACKAGING

AC26 :

- 0.1kg (plastic jerrycan)
- 1kg (plastic jerrycan)
- 2.5kg (plastic jerrycan)
- 5kg (plastic jerrycan)
- 25kg (plastic drum)
- 200kg (steel drum)

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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