

# LAPOX<sup>®</sup> ARL-125 | AH-332



Technical Data Sheet | Polymers Business

## Ambient cure epoxy system for infusion

Lapox ARL-125	100	pbw
Lapox AH-332	32	pbw

## Description

Lapox ARL-125 is a modified epoxy laminating resin designed for high performance applications and Lapox AH-332 is a modified polyamine based hardener suitable for high mechanical performance applications in static and dynamic load conditions. The moderate initial viscosity of this system ensures fast and complete impregnation of reinforcing fibers such as glass, carbon and polyamide. It allows components to be produced by various process techniques with high consistency in performance properties. The components cured at room temperature provides excellent handling strength, the optimum properties, however, will only be obtained after post curing at temperature of more than 50°C. Fully cured components prepared by this system are recommended to operate between -60°C and 80°C temperature.

## Applications

This system is suitable for very large range of applications including wind turbine blades, ships and boats, gliders, motor gliders and planes, recreational and sporting goods, moulds and tools, automotive, electrical, as well as other industrial and house hold components.

## Processing

Contact pressure mouldings  
Filament winding  
Pultrusion  
Resin infusion (RI)  
Resin transfer moulding (RTM)  
Vacuum and pressure bag techniques  
Wet lay-up lamination

## Typical specifications

### Lapox ARL-125

Properties	Unit	Test method	Values
Appearance	-	Visual	Clear liquid
Colour	GS	ASTM D1544	Max 2
Density at 25°C	g/cm <sup>3</sup>	ISO 1183	1.1 - 1.2
Viscosity at 25°C	m Pas	ASTM D2196	1,000 - 1,500
Epoxy value	Eq/kg	ASTM D1652	5.40 - 6.02

### Lapox AH-332

Properties	Unit	Test method	Values
Appearance	-	Visual	Clear liquid
Colour	GS	ASTM D1544	Max 4
Density at 25°C	g/cm <sup>3</sup>	ISO 1183	0.98 - 1.04
Viscosity at 25°C	m Pas	ASTM D2196	150 - 300

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## Processing properties

Properties	Unit	Test method	Values
Mixing ratio (by weight)	-	Visual	Resin : 100 Hardener: 32
Initial mix viscosity at 25°C	m Pas	ASTM D2196	600 - 800
Pot life	Minutes	ASTM D2471	10 - 16 / 20°C 8 - 14 / 25°C
Curing shrinkage	%	-	1.7
Curing schedule	°C / hours	-	25°C / 24 hours + 70°C / 8 hours

## Typical properties of neat cured system

Curing schedule: 25°C / 24 hours + 70°C / 8 hours  
Determined on standard test specimen at 25°C

Properties	Unit	Test method	Values
Tensile strength	MPa	ISO 527	60 - 70
Elongation at break	%	ISO 527	4 - 7
Elastic modulus in tension	GPa	ISO 527	2.8 - 3.4
Flexural strength	MPa	ISO 178	115 - 130
Elastic modulus in flexural	GPa	ISO 178	3.0 - 3.6
Compressive strength	MPa	ISO 604	120 - 140
Hardness	Shore D	ISO 868	80 - 90
Glass transition temperature (DSC)	°C	ISO 11357 - 2	80 - 90
Water absorption 25°C / 24 hours	% w/w	ISO - 62	Max 0.5

## Packaging

Lapox ARL-125 is available in 30 kg, 110 kg and 240 kg carboys. Lapox AH-332 is available in 1 kg HDPE bottles. Other packing may be considered on request.

## Storage and handling

Lapox ARL-125 and Lapox AH-332 have shelf-life of 2 year if stored in their original sealed containers. Resin and hardener may crystallise if stored below 15°C. Crystallisation may be reversed completely by heating the material between 60°C and 70°C. It is recommended to use resin and hardener only when they are clear and free from cloudiness. Both resin and hardener may cause irritation to sensitive skins. If contact does occur to such operators then it should be washed off immediately with soap and warm water. Please refer to the Safety Data Sheet (SDS) for detailed instructions on storage and handling.

## Safety

Wear personal protective equipment (PPE). Avoid contact with the eyes and skin. In case of direct contact and irritation, the resin should be washed off immediately with soap and warm water. Avoid breathing vapours, mist or gas. Please refer to the SDS for detailed safety instructions.

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**Spills and disposal** In case of spills, sweep up and shovel the spilled material. Keep spilled material in suitable, closed containers for disposal. Soak up with an absorbent such as clay, sand or other suitable material. Flush area with water to remove trace residue. Do not allow the product to reach the sewage system. Waste must be disposed of in accordance with federal, state or local regulations, as applicable.

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**Note** Lapox<sup>®</sup> is a registered trademark of Atul Ltd.

## Manufacturing site

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