



EL-346 TOUGHENED EPOXY LAMINATING SYSTEM

PRODUCT BULLETIN



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DESCRIPTION

EL-346 is a water clear, UV stabilized, toughened epoxy laminating system developed for production processing of high performance composite parts. Used for laminating with graphite, S-Glass, E-Glass or Kevlar fabrics, composites made with EL-346 exhibit greater impact shock resistance and flexural strength. For production use, the low mixed viscosity of EL-346 speeds up fabric wet-out and the fast oven-cure-to-demold times quicken production cycles.

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (parts-by-weight)	100R/19H
Mix Ratio (parts-by-volume)	4.65R/1H
Mixed Density	1.13 gms/cc
.....	9.43 lbs/gallon
Mixed Viscosity	500 cps
Work Life (200 gram mass)	22 minutes
De-mold Cycle Time @ 85°C/185°F (100 gram mass)	11 minutes
Complete Cure @ 85°C/185°F (maintains water clear color)	4 hours
Mixed Color	Water Clear
Shelf Life Resin and Hardener (in original unopened containers)	2 years

TYPICAL PHYSICAL PROPERTIES (Tested Following 2 Hour Cure @ 85°C)

Cast Bar:

Tensile Strength	12,203 psi	12.20 ksi
Tensile Modulus	575,600 psi	575.6 ksi
Tensile Elongation.....	10%		
Flexural Strength	19,630 psi	19.63 ksi
Flexural Modulus	421,400 psi	421.4 ksi
Compressive Strength.....	13,240 psi	13.24 ksi
Compressive Modulus.....	206,900 psi	209.9 ksi
Impact Strength	12.46 in-lbf/in		
Heat Deflection Temperature @ 66 psi.....	148°F	64.8°C
Heat Deflection Temperature @ 264 psi.....	144°F	62.2°C

EL-346 Tech/Revised 4/21/06
Supersedes EO8-082 3/20/06



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