

Innovium TOOL : Tool manufacturing applications

*Low viscosity systems*

Product	Process	Viscosity (mPa.s)	Gel time (min) on 100g @ 25°C	Recommended cure	Tg °C (°F)	Hardness (shore D)	Comments
XIN 8665	Infusion	500	420	24h @ Room temperature + 7h @ 50°C (122°F) + 3h @ 90°C (194°F) + 3h @ 120°C (248°F) + 3h @ 150°C (302°F) +	185 (365)	90	Longer gel times available upon request
XIN 8666	Infusion	500	480		190 (374)	92	

*Semi-solid epoxy resin films*

Product	Process	Viscosity @ 60°C (mPa.s)	GC* (J/m²)	Recommended cure	Tg °C (°F)	Storage modulus* kPa (psi)	Film density (g/sqm)	Film thickness (µm)	Comments
LEO 8376	Preimpregnation, RFI	160 000	430	2h @ 130°C (266°F) + 2h @ 200°C (392°F)	160 (320)	7250 (50)	40 - 400	35 - 350	Semi solid resin films are designed for a simple implementation in common production lines to produce prepreg. On-the-shelf formulations are low tack versions. Tack may be adjusted on-demand.
LEO 8377	Preimpregnation, RFI	260 000	630		160 (320)	6800 (47)	40 - 400	35 - 350	
LEO 8378	Preimpregnation, RFI	350 000	860		160 (320)	6400 (44)	40 - 400	35 - 350	

*Hotmelt systems*

Product	Process	Viscosity @ 60°C (mPa.s)	GC* (J/m²)	Recommended cure	Tg °C (°F)	Storage modulus* kPa (psi)	Comments
XIN 8376	Preimpregnation	160 000	430	2h @ 130°C (266°F) + 2h @ 200°C (392°F)	160 (320)	7250 (50)	On-the-shelf formulations are low tack versions. Tack may be adjusted on-demand.
XIN 8377	Preimpregnation	260 000	630		160 (320)	6800 (47)	
XIN 8378	Preimpregnation	350 000	860		160 (320)	6400 (44)	

\* Values determined on carbon based fibre composite [B layers] cured in autoclave