



Innovium TOOL - Tool manufacturing applications

Low viscosity systems

Product	Process	Viscosity (mPa.s)	Gel time (min) on 100g @	Recommended cure	T _g °C (°F)	Hardness (shore D)	5
INK 8665	Infusion	500	420	2h @ Room temperature + 7h @ 50°C (122°F) + 3h @ 90°C (194°F) + 3h @ 120°C (248°F) + 3h @ 150°C (302°F) + 1h @	185 (365)	90	Longer gel times available upon request
INK 8666	Infusion	500	480		190 (374)	92	

Semi-solid epoxy resin films

Product	Process	Viscosity @ 60°C (mPa.s)	GC* (J/m ²)	Recommended cure	T _g °C (°F)	Storage modulus* MPa (GPa)	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 formulation 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	880		160 (320)	6400 (44)	40 - 400	35 - 350	

Hotmelt systems

Product	Process	Viscosity @ 60°C (mPa.s)	GC* (J/m ²)	Recommended cure	T _g °C (°F)	Storage modulus* MPa (GPa)	Comments
INK 8376	Preimpregnation	160 000	430	2h @ 130°C (266°F) + 2h @ 200°C (392°F)	160 (320)	7250 (50)	On-the-shelf formulation are low tack versions. Tack may be adjusted on-demand.
INK 8377	Preimpregnation	260 000	630		160 (320)	6800 (47)	
INK 8378	Preimpregnation	350 000	880		160 (320)	6400 (44)	

* Values determined on carbon based fibre composite (8 layers) cured in autoclave