

TECHNIREZ R2519 is a solvent free, liquid epoxy system specifically formulated for use with H2403 and H2409 hardeners to provide excellent high temperature performance after post cure.

R2519 provides significantly lower mixed viscosities, than its predecessor R2515, while retaining high temp resistance.

Typical applications include the casting and laminating of jigs and tools that will be used in high temperature applications, such as pre-preg moulds and vacuum forming tools.

**MIX RATIO**

25 parts of H2403 hardener to 100 parts of resin by weight

34 parts of H2409 hardener to 100 parts of resin by weight

*Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.*

UNCURED PROPERTIES			
	R2519 resin	H2403 hardener	H2409 hardener
Physical State	Clear liquid	Clear liquid	Clear liquid
Viscosity mPas@25°C	7,000-9,000	15-20	100 - 140
Specific Gravity g/ml@25°C	1.12	0.93	0.95

CURE CHARACTERISTICS		
	H2403	H2409
Pot Life-100g @ 25°C	110-120 mins	260 - 320 mins
Demould Time @ 25°C	12 hrs +3 hrs@40°C	12 hrs +24 hrs@80°C
Mix Viscosity mPas@25°C	1100	2,600
Shore D Hardness	87	87
HDT*	60 - 145°C	60 - 150°C

\* R2519 resin with H2403 and H2409 hardeners exhibit brittle "B" stage at ambient temperature prior to post cure.

*POST CURE SCHEDULE		
	H2403	H2409
12 hours @ 25°C + 24 hours @ 60°C	60°C	80°C
+ 24 hours @ 80°C	120°C	110°C
+ 24 hours @120°C	145°C	150°C

**PACK SIZES**

Order Code

Resin		Hardener	
RC 2519	4 kg	HC 2403	1 kg
RD 2519	18 kg	HD 2403	4.5 kg
RF 2519	200 kg	HE 2403	22 kg
		HC 2409	1 kg
		HD 2409	5 kg
		HE 2409	22.5 kg

**STORAGE**

TECHNIREZ R2519 resin, and H2403 and H2409 hardeners will keep for 2 years if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

**HEALTH AND SAFETY**

TECHNIREZ R2519 resin, and H2403 and H2409 hardeners have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with ATL's 845 hand cleaner and water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
- If swallowed:

**Resins** - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre. **Hardeners** - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 09/10/18

