

**EPIKOTE™ Resin MGS RIMR235**  
**EPIKURE™ Curing Agent MGS RIMH233 – 238**

**CHARACTERISTICS**

|                                |  |
|--------------------------------|--|
| <b>Approval</b>                | DNV (except of RIMH233)  |
| <b>Application</b>             | Rotor blades for wind turbines, boat and shipbuilding, sports equipment, model construction, tooling and molding |
| <b>Operational temperature</b> | -40 °C up to +70 °C after appropriate cure   |
| <b>Processing</b>              | At temperatures between 15 °C and 50 °C  |
| <b>Features</b>                | very low viscosity<br>pot life from approx. 10 minutes to approx. 5h   |
| <b>Storage</b>                 | Shelf life of 24 months in originally sealed containers  |

**APPLICATION**

EPIKOTE™ Resin MGS RIMR235 is an epoxy-based low-viscous infusion resin system with a wide range of applications. It contains neither solvents nor fillers and is used for processing of glass, carbon, and aramid fibers.

The available curing agents cover a wide reactivity range from very fast to very slow. Additionally, mixing of curing agents (e.g. fast and slow) is possible to adjust reactivity to individual needs. After precuring at room temperature, the manufactured components are workable and demoldable, only for the very slow curing agent RIMH238 the manufactured component eventually will be a bit brittle. In this case the initial cure should be done at 40 – 50°C. The final properties, however, will only be reached after post-cure at elevated temperatures.

Due to the chemical characteristics of this system, we do not expect any problems concerning compatibility (e. g. blistering, tearing or changes in color), when it is processed with gelcoats. However, comprehensive tests are indispensable.

For epoxy resins crystallization is immanently possible. In an early stage, crystallization is visible as a clouding, and can progress to a stage, where the resin becomes a wax- like solid. Crystallization can be reversed by slow heating of the product to approx. 40 - 60 °C. without restriction to quality after removal, in fact a high purity of material will increase a tendency for crystallization. Although RIMR235 is very unlikely to crystallize at low temperatures, storage conditions of 15-30 °C are recommended.

After dispensing material, the containers must again be closed carefully, to avoid contamination or absorption of water. All amine hardeners show a chemical reaction when exposed to air, known as „blushing“. This reaction is visible as white carbamide crystals, which could make the materials unusable.

Curing agents are colored to facilitate an easier identification of a homogenous mixture. The color is only a visual aid and is therefore not exactly specified. Therefore, variations from batch to batch are possible. Furthermore, the color is not stable and can change over time. This can be especially observed for high reactive curing agents like RIMH233 and in addition for all curing agents due to UV radiation. Accordingly, the color can change over time depending on reactivity of curing agent and storage conditions (like exposure to sunlight), but this has no effect on the overall performance and does not constitute a quality complaint.

The materials have a shelf life of minimum 2 years, when stored in their originally sealed containers.

The relevant industrial safety regulations for the handling of epoxy resins and hardeners are to be observed.

## TYPICAL PROPERTIES

| Property                              | Unit              | Resin   | Curing agent |         |         |         |
|---------------------------------------|-------------------|---------|--------------|---------|---------|---------|
|                                       |                   | RIMR235 | RIMH233      | RIMH235 | RIMH236 | RIMH238 |
| Density <sup>1)</sup>                 | g/cm <sup>3</sup> | 1,16    | 0,99         | 0,96    | 0,94    | 0,95    |
| Viscosity <sup>1)</sup>               | mPa·s             | 1300    | 65           | 15      | 15      | 20      |
| Pot life <sup>2)</sup>                | min               |         | 11           | 100     | 210     | 350     |
| Ultimate T <sub>G</sub> <sup>3)</sup> | °C                |         | 110          | 90      | 90      | 90      |

These are typical values and should not be construed as specifications.

### Measuring conditions:

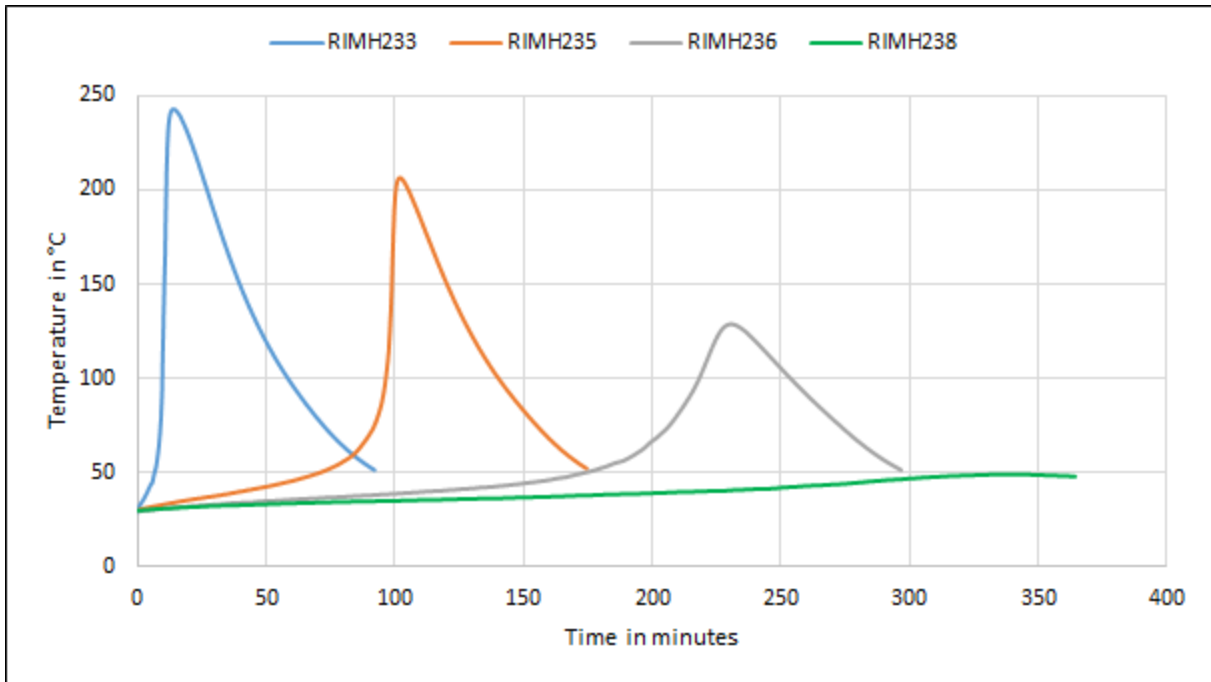
- 1) measured at 25°C
- 2) 100g mixture in water bath at 30°C  
 Pot life is a standardized lab test under fixed conditions which does not necessarily reflect real process conditions. The usage or working time varies depending on real processing conditions (environmental temperature, lay-up thickness)
- 3) DSC after full cure, 20K/min, midpoint

## MIXING RATIO

|                 | Parts curing agent per 100 parts resin RIMR235 |         |         |         |
|-----------------|--|---------|---------|---------|
|                 | RIMH233  | RIMH235 | RIMH236 | RIMH238 |
| Parts by weight | 34 ± 2   |         |         |         |
| Parts by volume | 40 ± 2   | 41 ± 2  | 42 ± 2  | 42 ± 2  |

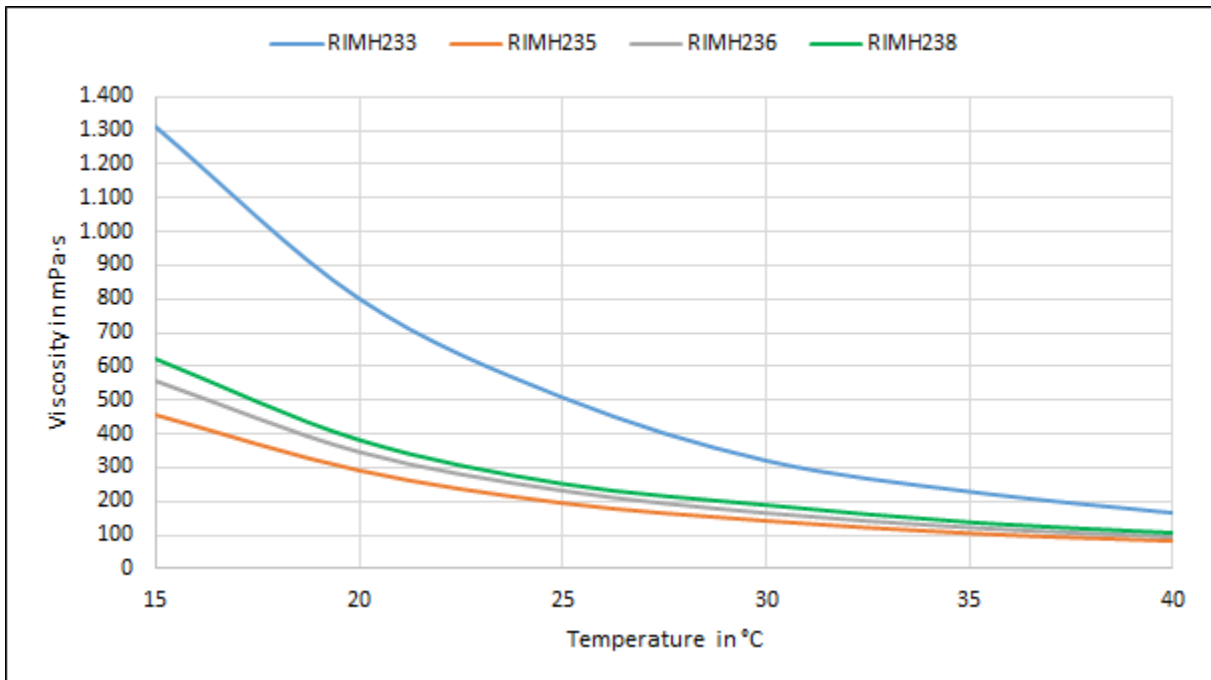
The mixing ratio stated must be observed very carefully. Adding more or less curing agent will not result in a faster or slower reaction, but in incomplete curing which can't be corrected in any way. Resin and curing agent must be mixed very thoroughly. Pay special attention to the walls and bottom of the mixing container.

**TEMPERATURE DEVELOPMENT**



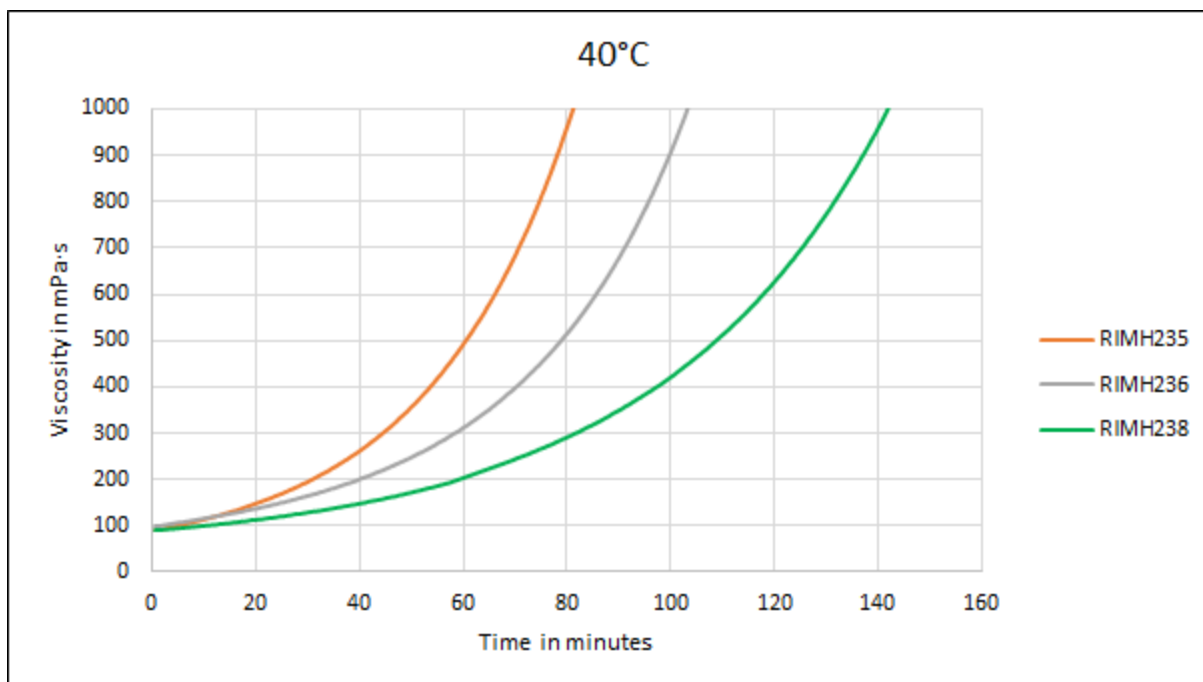
**Measuring conditions:** measured 100g in a paper cup isolated in a water bath at 30°C

**VISCOSITY OF MIXTURE**



**Measuring conditions:** Viscometer, cone-plate configuration, diameter 50 mm, gap 0.1 mm

## VISCOSITY DEVELOPMENT



**Measuring conditions:** Viscometer, cone-plate configuration, diameter 50 mm, gap 0.1 mm

## PHYSICAL AND MECHANICAL DATA

| Test                                      | Property  | Typical Value |
|---|---|---------------|
| <b>Cured density</b><br>DIN EN ISO 1183-1 | <b>Density [g/cm<sup>3</sup>]</b>               | 1,16          |
| <b>Tensile test</b><br>DIN EN ISO 527-2   | <b>Tensile strength [MPa]</b>                   | 65            |
|   | <b>Tensile modulus [GPa]</b>                    | 3,0           |
|   | <b>Tensile strain at break<sup>1)</sup> [%]</b> | > 6           |
| <b>Flexural test</b><br>DIN EN ISO 178    | <b>Flexural strength [MPa]</b>                  | 110           |
|   | <b>Flexural modulus [GPa]</b>                   | 3,1           |

<sup>1)</sup> Tensile strain at break results strongly depends on specimen quality, especially void content  
All tests accomplished at standard climate; specimens cured up to a T<sub>g</sub> midpoint (DSC) of at least 75°C

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