

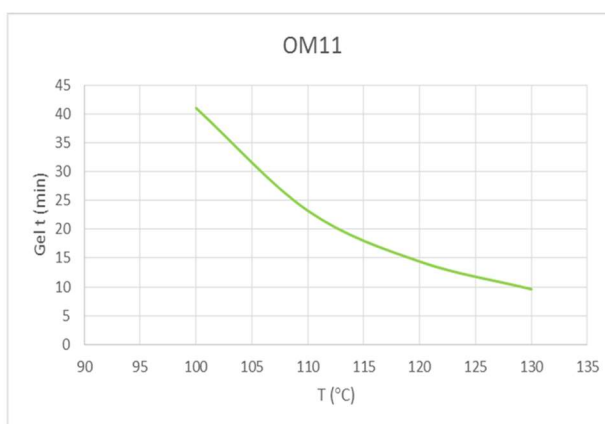
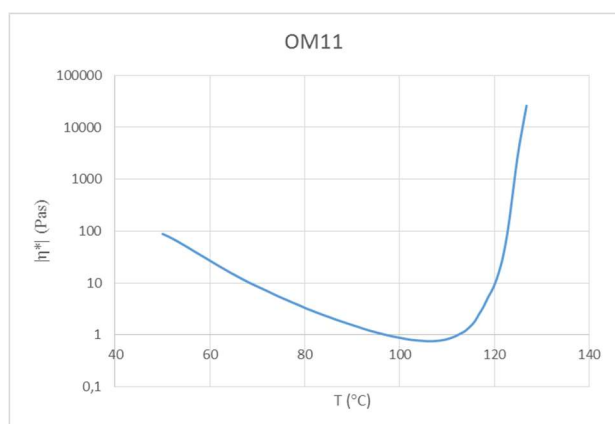
## TECHNICAL DATA SHEET

<b>Resin System</b>	OM11
<b>Applications</b>	Industrial composites, automotive
<b>Key Features</b>	Structural; fatigue applications; translucent when cured
<b>Cure Temperature</b>	90°C - 130°C
<b>Work Life</b>	28 days @ RT
<b>Storage Life</b>	1 year @ -18°C
<b>Fiber</b>	Carbon, E-glass
<b>Weaving Style</b>	Plain, twill, UD
<b>Dry Fabric Areal Weight (gsm)</b>	110 - 600
<b>%Resin Content (by weight)</b>	34 - 44 ± 2

### Cured Matrix Properties

Cured Matrix Properties (cured at 90 °C 0.5h + 130 °C 2h)		
<b>Tensile Test (ISO 527-2)</b>	Tensile Strength (MPa)	39
	Young's modulus (GPa)	2.8
	Elongation at break (%)	2
	Shear modulus (MPa)	1038
<b>Flexural Test (ISO 178)</b>	Flexural Strength (MPa)	130
	Flexural Modulus (GPa)	2.4
	Elongation at maximum (%)	7
<b>Tg (°C) (DMA)</b>	Onset of E'	≥120

### Resin Matrix Properties



## Cure Profile

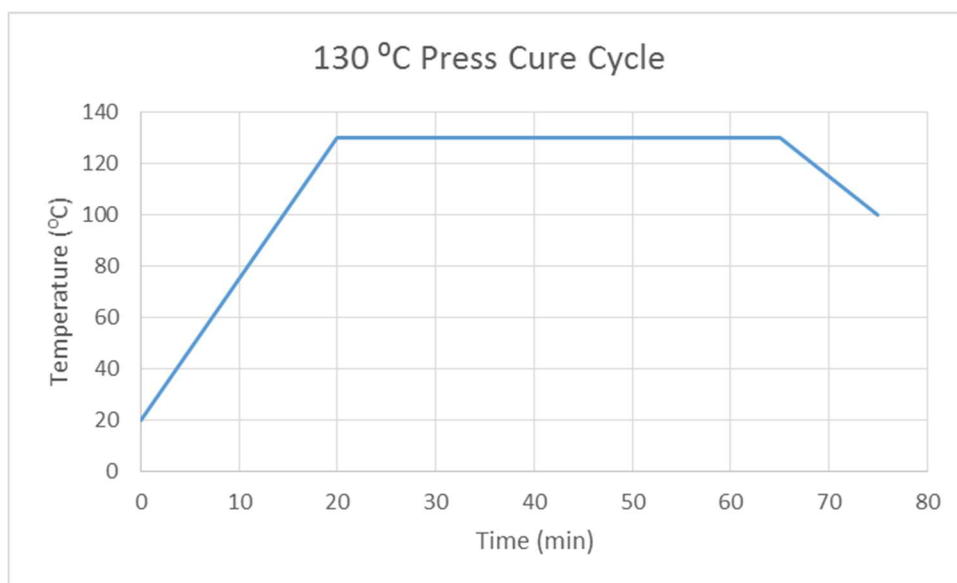
### Compression Molding

The resin system is suitable for hot molding and de-molding. Thick parts up to 100 mm in thickness can be cured in a heated press without any unwanted exothermic reaction.

#### Recommended Curing Cycle at 130 °C

- 1) Pre-heat the press to 130 °C
- 2) Place the laminate into hot press and hold the laminate at that temperature applying 4 - 7 bars of pressure for 30 minutes
- 3) De-mold the laminate (if possible cool below 100 °C)

Post-cure in oven at 155 °C for 1 to 2 hours can be applied.

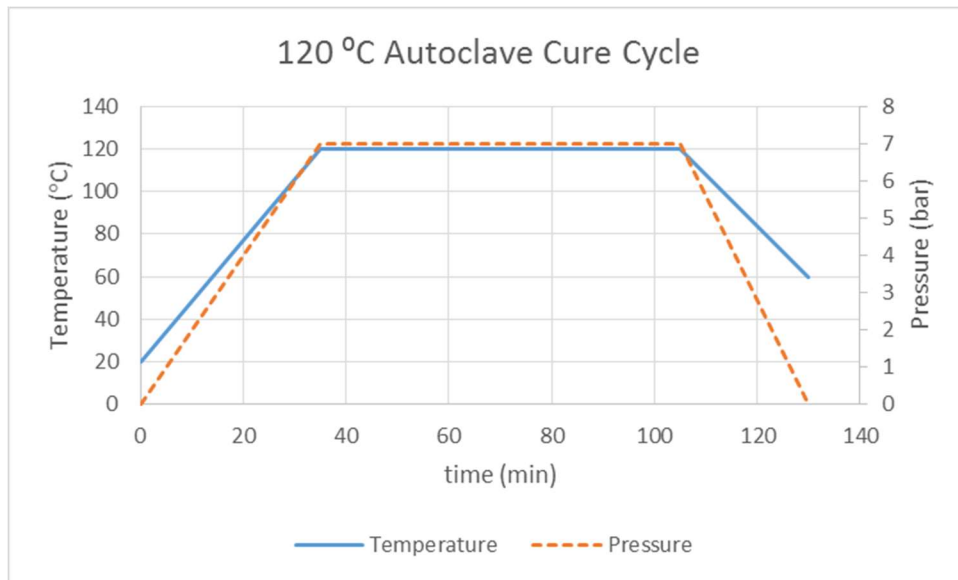


## Autoclave Molding

### Recommended Curing Cycle at 120 °C

A typical autoclave cure cycle for a thin laminate is 60 minutes at 120°C.

- 1) Apply full vacuum (1 bar).
- 2) Apply 7 bar gauge autoclave pressure.
- 3) Reduce the vacuum to a safety value of 0.2 bar when the autoclave pressure reaches approximately 1 bar gauge.
- 4) Heat-up at 1 – 3 °C/minute to 120°C.
- 5) Hold at 120°C for 60 minutes ± 5 minutes.
- 6) Cool at 2 – 5 °C per minute.
- 7) Vent autoclave pressure when the component reaches 60°C or below.



### Industrial GFRP Panels (Press Cured Laminates)

UD Tape	Fiber	Prepreg Resin Content %
KG2400 UD300	CE 2400tex	35

Test	Standard	Property	KG2400 UD300
0° Tensile	ASTM D3039	Strength (MPa)	830
		Modulus (GPa)	42
		Strain (%)	1.98
		Poisson's ratio	0.31
0° Compression	ASTM D3410	Strength (MPa)	637
		Modulus (GPa)	43
		Strain (%)	2.36
0° 3 Pt Bending	ASTM D790	Strength (MPa)	1240
		Modulus (GPa)	43
		Strain (%)	3.10
0° ILSS	ASTM D2344	Strength (MPa)	71
0° V-notch shear	ASTM D5379	Strength (MPa)	71
% Fiber volume	ASTM D3171	%Vf	50 - 55
DMA Tg	ASTM D7028	Tg (°C)	≥120

### Industrial CFRP Panels (Autoclave Cured Laminates)

Fabric	Fiber	Prepreg Resin Content %
KCF3K TW245	Toray T300	42

Test	Standard	Property	KCF3K TW245
0° Tensile	ASTM D3039	Strength (MPa)	733
		Modulus (GPa)	60
		Strain (%)	1.9
0° Compression	ASTM D3410	Strength (MPa)	577
		Strain (%)	3.3
0° 4 Pt Bending	ASTM D7264	Strength (MPa)	809
		Modulus (GPa)	75
		Strain (%)	1.1
0° ILSS	ASTM D2344	Strength (MPa)	70
DMA Tg	ASTM D7028	Tg (°C)	≥120

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