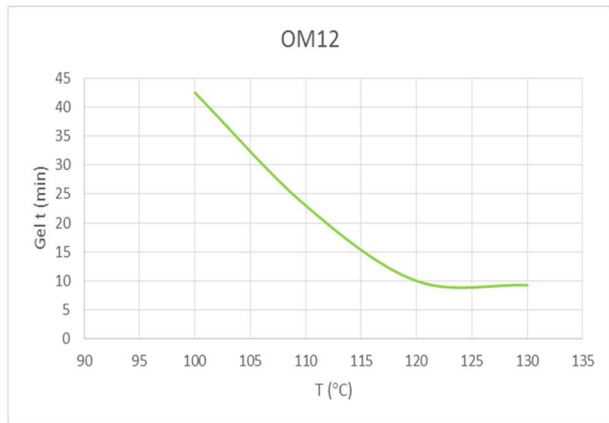
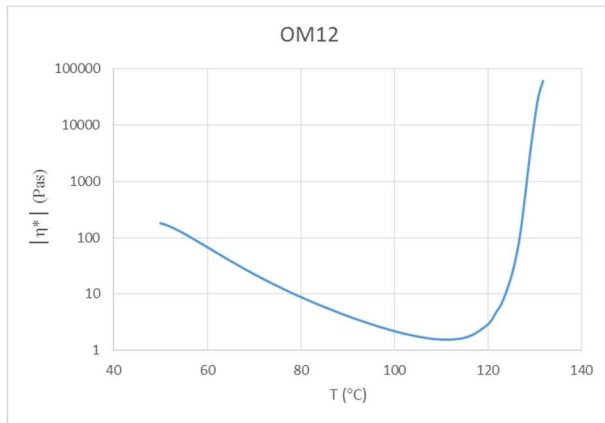


## TECHNICAL DATA SHEET

<b>Resin System</b>	OM12
<b>Applications</b>	Industrial composites
<b>Key Features</b>	Structural; oven curable; white opaque when cured
<b>Cure Temperature</b>	80°C - 130°C
<b>Work Life</b>	28 days @ RT
<b>Storage Life</b>	1 year @ -18°C
<b>Fiber</b>	Carbon, E-glass, polyester peel ply
<b>Weaving Style</b>	Plain, twill, biaxial, UD, peel ply
<b>Dry Fabric Areal Weight (gsm)</b>	110 - 600
<b>%Resin Content (by weight)</b>	34 - 44 ± 2

### Resin Matrix Properties



## Cure Profile

### Vacuum Bagging and Oven Molding Recommended Curing Cycle

- 1) Apply minimum 25 Hg vacuum
- 2) 0.3 - 2°C per minute to the dwell temperature (85 °C)
- 3) Keep the laminate at 85 °C for 1 hour
- 4) Increase the temperature to 120 °C (final cure temperature)
- 5) Keep the laminate at the final cure temperature for 1 hour
- 6) Vacuum should be maintained as high as possible
- 7) Upon completion of cure, turn off heat and cool the part before de-molding

De-bulking at each 900 gsm is strictly recommended.

Cure time may be extended for thick and long parts.

Table 1. Recommended cure cycles

Temperature (°C)	Time (hours)
80	12
85	10
90	6
100	3
120	1

Table 2. Recommended cure conditions

Property	Oven/vacuum bag	
Typical ramp rate	1 – 2 °C/min	
Cure Temperature	80 °C	120 °C
Cure Dwell Time	12 hours	1 hour
Cure Pressure	-1 bar	
De-mold temperature	<60 °C	
Dry Tg (DMA)	<100 °C	>110 °C

[www.kordsaglobal.com](http://www.kordsaglobal.com)

[reinforcer@kordsaglobal.com](mailto:reinforcer@kordsaglobal.com)

NOTICE –All rights reserved. Kordsa reserves the right to update, revise or modify such technical data and information at any time. The data disclosed herein is for information purposes only without any legal responsibility attributable to Kordsa. Kordsa recommends Customer's own testing of the suitability of our products for its particular purpose. Kordsa makes no express or implied warranty or representation, including but not limited to the warranties of merchantability, commercial availability and/or fitness for a particular purpose.