

# DRAGONKRAFT

## THE BIO-RESIN SPECIALISTS

### 202H07 TECHNICAL DATA

Hardener system for use with Dragonkraft Resins for filling, fairing and adhesive applications.

#### GENERAL DESCRIPTION

The Dragonkraft Hardener is designed to be used with the Dragonkraft resins where they combine to form systems that are high strength with a flexible, non-brittle, non-chalking and low shrinkage finish. The Dragonkraft systems are also more tolerant of damp conditions and high temperatures making application and use easier in more testing environments.

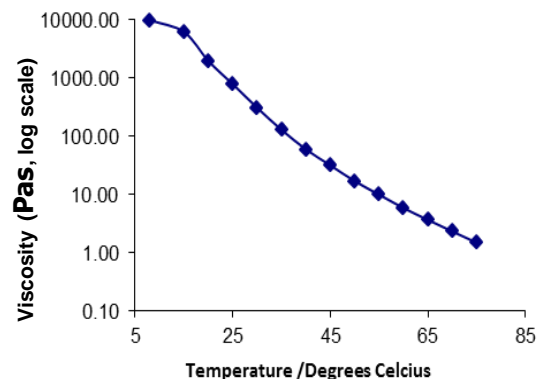
Dragonkraft 202H07 is low odour, amine free and BPA free reducing the impact on the environment and improving user safety.

The system can be used alone or with fillers for filling/fairing applications and also as an adhesive between substrates such as steel, plywood, insulation board, polystyrene and teak.

As a filling material it is self levelling and, as with other Epoxy systems, takes a number of days to achieve full bond strength. A second coat applied within 48 hours will have a chemical as well as mechanical bond to the first layer improving the tie between the layers.

#### PROPERTIES

Description	An Anhydride based hardener in a polymerisable solvent system
Appearance @ 45°C	Pale Amber liquid
Viscosity	See Graph opposite
Shelf Life	12 months in unopened container at <40°C



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### FORMULATION INFORMATION

The Resin/Hardener mix ratio	2:1 (by weight)
Pot life (see note 1)	20 – 40 minutes
Initial cure time to non-tacky finish	12 – 24 hours
Full bond strength	7 days
Minimum Cure temp	10°C
Optimum working temperature	22 - 25°C

#### Note 1. Pot life will depend on two parameters:

- 1. The ambient temperature.** The higher the ambient temperature the quicker the epoxy will cure thus reducing the pot life.
- 2. The type of container used after mixing.** If the mixed material is allowed to heat up excessively by the heat of reaction as the curing process starts (an exothermic reaction) then the pot life will be reduced. This effect can be reduced by putting material into a flat tray for application as the heat is dissipated faster than in a mixing vessel.

### PREPARATION AND MIXING INFORMATION

The following are some guidelines to heed when preparing the resin/hardener prior to use:

- Before applying any of the Dragonkraft systems, ensure that the surface being bonded and coated are clean and free from grease/dirt.
- ONLY use Dragonkraft resins and hardeners in combination. If either are substituted for materials from other suppliers they are highly unlikely to work
- If using fillers or pigments, pre-blend into the resin prior to mixing the hardener
- Use the correct ratio of resin to hardener to get the best results
- Stir slowly to blend the resin/hardener together and prevent excess aeration
- Use metal containers to mix/hold as the system will get hot when it starts to cure. The higher the ambient temperature, the quicker the material will cure, the higher the temperature it will reach as the heat generated will dissipate slower
- Higher temperatures will lower the viscosity of the material but reduce the pot life and working time.

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### TECHNICAL DATA

When used with Dragonkraft 101R100 resin the adhesion with two pieces of teak has been measured at 133kg/cm<sup>2</sup> with the teak failing. The end finish has some flexibility and not the brittleness associated with many epoxy systems.

### STORAGE

All components should be stored at room temperature in sealed containers to prevent moisture ingress and contamination. The 202H07 Hardener may form some crystals over time and will thicken considerably at lower temperatures. The crystals formed will go back into solution on warming to 40-50°C.

### SAMPLING

Samples of this novel technology are available but as all formulations are the propriety information of Dragonkraft Europe the standard Dragonkraft Non-disclosure agreement must be completed prior to any sample or MSDS being supplied.

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