

## Hot curing epoxy system based on Araldite<sup>®</sup> LY 556\* / Hardener XB 3473\*

Araldite LY 556 is an epoxy resin  
Hardener XB 3473 is a formulated amine hardener

<b>Applications</b>	<ul style="list-style-type: none"> <li>Industrial composites</li> <li>Structural composites</li> </ul>																																	
<b>Properties</b>	Laminating system																																	
<b>Processing</b>	<ul style="list-style-type: none"> <li>Filament Winding</li> <li>Resin Transfer Moulding (RTM)</li> <li>Pressure Moulding</li> <li>Pultrusion</li> </ul>																																	
<b>Key data</b>	<p><b>Araldite LY 556</b></p> <table border="1"> <tr> <td>Aspect (visual)</td> <td>clear, pale yellow liquid</td> <td></td> </tr> <tr> <td>Colour (Gardner, ISO 4630)</td> <td>≤ 2</td> <td></td> </tr> <tr> <td>Viscosity at 25 °C (ISO 12058-1)</td> <td>10000 - 12000</td> <td>[mPa s]</td> </tr> <tr> <td>Density at 25 °C (ISO 1675)</td> <td>1.15 - 1.2</td> <td>[g/cm<sup>3</sup>]</td> </tr> <tr> <td>Flash point (ISO 2719)</td> <td>&gt; 200</td> <td>[°C]</td> </tr> <tr> <td>Storage temperature (see expiry date on original container)</td> <td>2 - 40</td> <td>[°C]</td> </tr> </table> <p><b>Hardener XB 3473</b></p> <table border="1"> <tr> <td>Aspect (visual)</td> <td>clear yellow to brown liquid</td> <td></td> </tr> <tr> <td>Viscosity at 25 °C (ISO 12058-1)</td> <td>95 - 145</td> <td>[mPa s]</td> </tr> <tr> <td>Density at 25 °C (ISO 1675)</td> <td>0.99 - 1.02</td> <td>[g/cm<sup>3</sup>]</td> </tr> <tr> <td>Flash point (ISO 2719)</td> <td>121</td> <td>[°C]</td> </tr> <tr> <td>Storage temperature (see expiry date on original container)</td> <td>2 - 40</td> <td>[°C]</td> </tr> </table>	Aspect (visual)	clear, pale yellow liquid		Colour (Gardner, ISO 4630)	≤ 2		Viscosity at 25 °C (ISO 12058-1)	10000 - 12000	[mPa s]	Density at 25 °C (ISO 1675)	1.15 - 1.2	[g/cm <sup>3</sup> ]	Flash point (ISO 2719)	> 200	[°C]	Storage temperature (see expiry date on original container)	2 - 40	[°C]	Aspect (visual)	clear yellow to brown liquid		Viscosity at 25 °C (ISO 12058-1)	95 - 145	[mPa s]	Density at 25 °C (ISO 1675)	0.99 - 1.02	[g/cm <sup>3</sup> ]	Flash point (ISO 2719)	121	[°C]	Storage temperature (see expiry date on original container)	2 - 40	[°C]
Aspect (visual)	clear, pale yellow liquid																																	
Colour (Gardner, ISO 4630)	≤ 2																																	
Viscosity at 25 °C (ISO 12058-1)	10000 - 12000	[mPa s]																																
Density at 25 °C (ISO 1675)	1.15 - 1.2	[g/cm <sup>3</sup> ]																																
Flash point (ISO 2719)	> 200	[°C]																																
Storage temperature (see expiry date on original container)	2 - 40	[°C]																																
Aspect (visual)	clear yellow to brown liquid																																	
Viscosity at 25 °C (ISO 12058-1)	95 - 145	[mPa s]																																
Density at 25 °C (ISO 1675)	0.99 - 1.02	[g/cm <sup>3</sup> ]																																
Flash point (ISO 2719)	121	[°C]																																
Storage temperature (see expiry date on original container)	2 - 40	[°C]																																
<b>Storage</b>	<p>Provided that Araldite LY 556 and Hardener XB 3473 are stored in a dry place in their original, properly closed containers at the above mentioned storage temperatures they will have the shelf lives indicated on the labels. Partly emptied containers should be closed immediately after use.</p>																																	

\* In addition to the brand name product denomination may show different appendices, which allows us to differentiate between our production sites: e.g., BD = Germany, US = United States, IN = India, CI = China, etc.. These appendices are in use on packaging, transport and invoicing documents. Generally the same specifications apply for all versions. Please address any additional need for clarification to the appropriate Huntsman contact.

**Processing data**

<b>Mix ratio</b>	<i>Components</i>	<i>Parts by weight</i>	<i>Parts by volume</i>
	Araldite LY 556	100	100
	Hardener XB 3473	23	27

We recommend that the components are weighed with an accurate balance to prevent mixing inaccuracies which can affect the properties of the matrix system. The components should be mixed thoroughly to ensure homogeneity. It is important that the side and the bottom of the vessel are incorporated into the mixing process.

When processing large quantities of mixture the pot life will decrease due to exothermic reaction. It is advisable to divide large mixes into several smaller containers.

<b>Initial mix viscosity</b> (cone/plate viscosimeter)		<i>[°C]</i>	<i>[mPa s]</i>
	LY 556/XB 3473	at 25	5200 - 6000
		at 40	700 - 900

<b>Pot life</b> (Tecam, 23°C, 65 % RH)		<i>[g]</i>	<i>[h]</i>
	LY 556/XB 3473	100	32 - 37

<b>Gel time</b> (Hot plate)		<i>[°C]</i>	<i>[min]</i>
	LY 556/XB 3473	at	68 - 78
		120	35 - 43
		at	18 - 23
		140	9 - 13
		at	
		160	
		at 180	

The values shown are for small amounts of pure resin/hardener mix. In composite structures the gel time can differ significantly from the given values depending on the fibre content and the laminate thickness.

**Properties of the cured, neat formulation**

<b>Glass transition temperature</b> (IEC 1006, DSC, 10 K/min)	<i>Cure:</i> 4 h 80°C + 4 h 160°C 2 h 120°C + 4 h 180°C 2 h 120°C + 2 h 160°C + 2h 200°C 2 h 120°C + 2 h 160°C + 2h 200°C + 4h 220°C	$T_g$ [°C] [°C] [°C] [°C]	LY 556 XB 3473 162 - 168 185 - 194 185 - 193 187 - 195
<b>Glass transition temperature</b> (ISO 6721, DMA, 2 K/min)	<i>Cure:</i> 2 h 120°C + 2 h 140°C + 2h 180°C	$T_g$ [°C]	LY 556 XB 3473 175 - 185
<b>Flexural test</b> (ISO 178)	<i>Cure:</i> 2 h 120°C + 2 h 140°C + 2 h 180°C		
	Flexural strength	[MPa]	110 - 120
	Elongation at flexural strength	[%]	5,5 - 6,5
	Ultimate strength	[MPa]	110 - 120
	Ultimate elongation	[%]	5,5 - 6,5
	Flexural modulus	[MPa]	2700 - 2900
<b>Fracture properties</b> <b>Bend notch test</b> (PM 258-0/90)	<i>Cure:</i> 2 h 120°C + 2 h 140°C + 2 h 180°C		
	Fracture toughness $K_{1C}$	[MPa√m]	0,70 - 0,85
	Fracture energy $G_{1C}$	[J/m <sup>2</sup> ]	190 - 220

**Properties of the cured, reinforced formulation**

	Short beam: Laminate comprising 12 layers unidirectional E-glass fabric (425 g/m <sup>2</sup> ) Laminate thickness t = 3.1 - 3.3 mm Fibre volume content: 63 - 65 %		
<b>Interlaminar shear strength</b> (ASTM D 2344)	<i>Cure:</i> 2 h 120 °C + 2 h 140 °C + 2 h 180 °C		
	Shear strength	[MPa]	62 - 66
<b>Flexural test</b> (ISO 178)	<i>Cure:</i> 2 h 120 °C + 2 h 140 °C + 2 h 180 °C		
	Flexural strength	[MPa]	1050 - 1250
	Ultimate elongation	[%]	2.4 - 2.8
	Flexural modulus	[MPa]	40000 - 44000

**Handling precautions** Mandatory and recommended industrial hygiene procedures should be followed whenever our products are being handled and processed. For additional information please consult the corresponding product safety data sheets and the brochure "Hygienic precautions for handling plastics products".

### Personal hygiene

#### Safety precautions at workplace

protective clothing	yes
gloves	essential
arm protectors	recommended when skin contact likely
goggles/safety glasses	yes

#### Skin protection

before starting work	Apply barrier cream to exposed skin
after washing	Apply barrier or nourishing cream

#### Cleansing of contaminated skin

Dab off with absorbent paper, wash with warm water and alkali-free soap, then dry with disposable towels.  
Do not use solvents

#### Disposal of spillage

Soak up with sawdust or cotton waste and deposit in plastic-lined bin

#### Ventilation

of workshop	Renew air 3 to 5 times an hour
of workplaces	Exhaust fans. Operatives should avoid inhaling vapours

### First aid

Contamination of the eyes by resin, hardener or mix should be treated immediately by flushing with clean, running water for 10 to 15 minutes. A doctor should then be consulted.

Material smeared or splashed on the *skin* should be dabbed off, and the contaminated area then washed and treated with a cleansing cream (see above). A doctor should be consulted in the event of severe irritation or burns. Contaminated clothing should be changed immediately.

Anyone taken ill after *inhaling* vapours should be moved out of doors immediately.

In all cases of doubt call for medical assistance.

### Note

Araldite® is a registered trademark of Huntsman LLC or an affiliate thereof in one or more countries, but not all countries.

Huntsman LLC  
®Registered trademark



IMPORTANT: The following supersedes Buyer's documents. SELLER MAKES NO REPRESENTATION OR WARRANTY, EXPRESS OR IMPLIED, INCLUDING OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. No statements herein are to be construed as inducements to infringe any relevant patent. Under no circumstances shall Seller be liable for incidental, consequential or indirect damages for alleged negligence, breach of warranty, strict liability, tort or contract arising in connection with the product(s). Buyer's sole remedy and Seller's sole liability for any claims shall be Buyer's purchase price. Data and results are based on controlled or lab work and must be confirmed by Buyer by testing for its intended conditions of use. The product(s) has not been tested for, and is therefore not recommended for, uses for which prolonged contact with mucous membranes, 4/4  
abraded skin, or blood is intended; or for uses for which implantation within the human body is intended.