

Information on areas of application and recommendations for lamination resins

Duroplastics

	Acrylic resins							Epoxy resin
	Orthocryl Sealing Resin	Orthocryl Lamination Resin 80:20	Orthocryl Lamination Resin 80:20 PRO	C-Orthocryl	C-Orthocryl Sanitized	Orthocryl, soft	Orthocryl, extra soft	Araldit Lamination Resin
Article number	617H21	617H19	617H119	617H55	617H255	617H17	617H51	617H4
Areas of application	Suitable for sealing and reinforcing	Components with fibreglass content, as well as components with low to no carbon fibre content	Components with high carbon fibre content; for densely woven reinforcements	Components with high carbon fibre content	Components with high carbon fibre content	Components without fibreglass or carbon fibre content	Components without fibreglass or carbon fibre content	Components with high carbon fibre content, for solid laminate
Characteristics								
Viscosity	●●●●○	●●●●○	●○○○○	●●○○○	●●○○○	●●●●○	●●●●●	●●●●○
Strength	●●●●●			●●●●○			●●●●○	●●●●●
Flexibility	—			●○○○○		●●●●○	●●●●○	—
Forming properties	All resins are duroplastics (not thermoplastics), the components lose their profile of properties through deformation, meaning their mechanical effect is destroyed.							
Complexity in the model		●●●○○	●●●●●	●●●○○	●●●●○	●●●○○	●●●○○	●●●○○
Antibacterial effectiveness	—	—	—	—	✓	—	—	—
Setting time	approx. 5 min.	approx. 30 min.	approx. 40 min.	approx. 30 min.	approx. 30 min.	approx. 30 min.	approx. 30 min.	10 hrs (hardener) or 5 hrs (quick hardener)
Reinforcement material								
Fibreglass	—	●○○○○	●●○○○	●○○○○	●○○○○	○○○○○	○○○○○	●○○○○
Stockinette	—	●●●●●	●○○○○	●●○○○	●●○○○	●●●●○	●●●●○	●●○○○
Carbon fibre	—	●○○○○	●●●●●	●●●●●	●●●●●	○○○○○	○○○○○	●●○○○
Useful information	Carbon laminate with corresponding reinforcement • High bending strength in the fibre direction (0°) • Medium torsional strength Unidirectional (0°): Always with an internal and an external layer! Pure carbon laminate without additional reinforcement • Low bending strength in 90° • High torsional strength Unidirectional (0°): Always with an internal and an external layer!							
Accessories	PVA sheeting (616F4=*) Pharma Talcum (639A1=1) or Microbal-lon, white (617Z8=1)	PVA sheeting (616F4=*)	PVA sheeting (616F4=*)	PVA sheeting (616F4=*)	PVA sheeting (616F4=*)	PVA sheeting (616F4=*)	PVA sheeting (616F4=*)	PVA sheeting, clear (616F1=*)
	Resin colour pastes: light skin colour (617Z2=*), tan skin colour (617Z3); white (617Z4); yellow (617Z5); red (617Z6); blue (617Z7); black (617Z9), green (617Z58=3)							Quick hardener (617P15) Hardener (617P3=1)
	Hardener 617P37=*							
Processing	749Y8=40 749Y7=B*x* 749Y26=*	749Y8=40 749Y7=B*x* 749Y26=*	749Y8=40 749Y7=B*x* 749Y26=*	749Y8=40 749Y7=B*x* 749Y26=*	749Y8=40 749Y7=B*x* 749Y26=*	749Y8=40 749Y7=B*x* 749Y26=*	749Y8=40 749Y7=B*x* 749Y26=*	749Y8=40 749Y7=B*x* 749Y26=*
Grinding tools (recommendation)	—	—	—	—	—	749Z12=*	749Z12=*	—
Adhesives	—	• Otto Bock Contact Adhesive [636N9] • UHU Plus, final strength 300 (dual-component system) [636W23] • Orthocryl Sealing Resin Compact Adhesive [636K18] • Two-Component High Performance Adhesive [636W18] • Cyanoacrylate Quick-Drying Adhesive as dosage pen [636K36]						• UHU Plus, final strength 300 (dual-component system) • Two-Component High Performance Adhesive [636W18]
Mixing ratio	Resin : Hardener : Colour paste 100 : 1 : 3	Resin : Hardener : Colour paste 100 : 2–3 : 3				Resin : Hardener : Colour paste 100 : 1–2 : 3		Resin : Hardener : Colour paste 100 : 20 : 3
Accessories	Measuring Cup (642B2=*) Wooden Spatula (699Y3)							
Net contents								
0.9 kg: 4.6 kg: 25 kg:	617H21=0.900 617H21=4.600 617H21=25	617H19=0.900 617H19=4.600 617H19=25	617H119=0.900 617H119=4.600 617H119=25	617H55=0.900 617H55=4.600 617H55=25	617H255=0.900 617H255=4.600 617H255=25	617H17=0.900 617H17=4.600 617H17=25	617H51=0.900 617H51=4.600 617H51=25	1 kg: 617H4=1 5 kg: 617H4=5 25 kg: 617H4=25

Key:

●○○○○○ = very low
●●○○○○ = low
●●●○○○ = medium
●●●●○○ = high
●●●●●● = very high

●○○○○ = very soft
●●○○○ = soft
●●●○○ = stiff
●●●●● = very stiff

●○○○○ = very stiff
●●○○○ = stiff
●●●○○ = flexible
●●●●● = very flexible

●○○○○ = very low
●●○○○ = low
●●●○○ = high
●●●●● = very high

○○○○○ = Combination not recommended
●○○○○ = Low fibre content combination
●●○○○ = Medium fibre content combination
●●●○○ = High fibre content combination
●●●●● = Very high fibre content combination

✓ = Antibacterial effectiveness

Further information

Further information can be found in the product information 646D453=EN and on our website (scan the QR code with your smartphone).

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