

Orca Composites 1469 Resin

Orca Composites offers a unique thermosetting Bisphenol A epoxy matrix resin system featuring a 3-month shelf life without refrigeration. This resin is currently used for tow/roving, unitape, and fabric, and is available for carbon, glass, aramid, and other fibers. Resin content, resin flow during cure, and tack levels can be tailored to suit your process requirements.

Neat Resin Properties and Applications

Density (g/cc)	Tg (°F/°C) (from G" DMA curve)	Tensile Modulus (ksi/GPa)	Tensile Strength (ksi/MPa)	Elongation at Break (%)	Tg after 24-Hr Water-Boil (°F/°C)	Water Absorption (%)	Available Fiber Form
1.18	242 / 117	417 / 2.83	10.9 / 68.9	5.3	152 / 67	5.1	Tow/Roving, Unitape, Fabric

Typical Use

High pressure SCBA tanks, rocket motor cases, sporting goods, infrastructure repair, etc., where moderately low-temperature cure is required. High translation/performance in pressure vessels when used with Toray T700SC, Toho G30-700 and Mitsubishi TRH-50 and most other Carbon fibers.

Cure *

There are three recommended cure cycles for Orca Composites 1469 resin. All three will produce similar properties.

1. < 5°F-per-minute ramp up to 250°F (121°C), hold for 1.5 hours, < 5°F-per-minute ramp down to at least 150°F (66°C) before removing from oven.
2. < 5°F-per-minute ramp up to 230°F (110°C), hold for 4 hours, < 5°F-per-minute ramp down to at least 150°F (66°C) before removing from oven.
3. < 5°F-per-minute ramp up to 210°F (99°C), hold for 24 hours, < 5°F-per-minute ramp down to at least 150°F (66°C) before removing from oven.

*Higher temperatures and shorter hold times should also work but have not yet been thoroughly tested.

Storage Requirements

The preimpregnated materials manufactured from this resin shall remain sealed and stored in the original package. The material is to be stored indoors, out of the weather.

The shelf life is 3 months from the date of manufacture when the maximum storage temperature shall not exceed 75°F (24°C).

The shelf life is 1.5 months from the date of manufacture when the maximum storage temperature shall not exceed 90°F (32°C).

The shelf life is 6 months from the date of manufacture when the maximum storage temperature shall not exceed 40°F (4°C), with an additional 2 months at <75 °F (24°C).

The shelf life is 18 months from the date of manufacture when the maximum storage temperature shall not exceed 0°F (-18°C), with an additional 2 months at <75 °F (24°C)

The values here represent expected ranges based on actual test data. Since the values are specimen-preparation- and test-method-dependent, Orca Composites cannot guarantee that these properties will be obtained in all cases. The data should be used as an indication only, since part or component properties are highly equipment- and process-dependent. It is recommended that end users determine the suitability of this material for each application through their own testing and evaluation.