

# Biresin® CR82

## Composite resin system

### Product Description

Biresin® CR82 is an epoxy resin system designed for the hand lay-up, vacuum bagging and filament-winding processes, especially for applications where curing temperatures of  $\geq 75$  °C cannot be implemented.

### Application Areas

Biresin® CR82 is especially suitable for the hand lay-up process and can be used in many areas including marine and general industrial composite.

### Features / Advantages

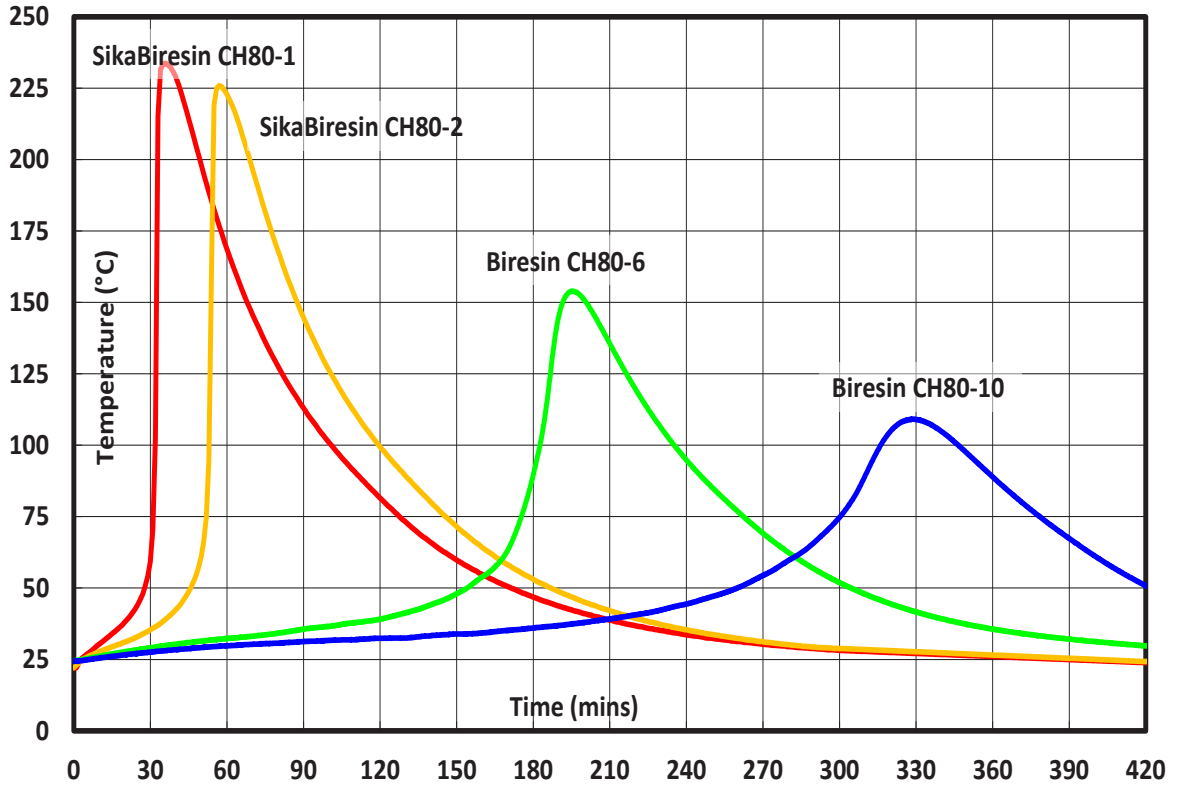
- 4 hardeners (B) with just one mixing ratio by weight, give a wide range of processing times
- The reactivity can be adapted by mixing the hardeners
- Biresin® CR82 systems have optimized viscosity and thus good impregnation and non-draining properties.
- Hardeners Biresin CH80-6 and Biresin CH80-10 are DNV GL approved. Certificate No. TAK00001YC
- Glass transition temperatures up to 80°C can be achieved dependent on curing conditions

Physical Data		Resin (A)		Hardener (B)		
Individual Components		Biresin® CR82	SikaBiresin® CH80-1	SikaBiresin® CH80-2	Biresin® CH80-6	Biresin® CH80-10
Mixing Ratio, parts by	<b>Weight</b>	100	27			
Mixing Ratio, parts by	<b>Volume</b>		30	30	32	32
Colour		translucent	colourless to brownish		colourless to yellow	
Viscosity, 25°C	mPa.s	~1,600	~170	~80	< 10	< 10
Density, 25°C	g/ml	1.11	1.01	1.01	0.95	0.95
		<b>Mixture</b>				
Potlife, 100 g / RT, approx. values	min		30	50	220	330
Mixed viscosity, 25°C, approx. values	mPa.s		1,100	800	400	390

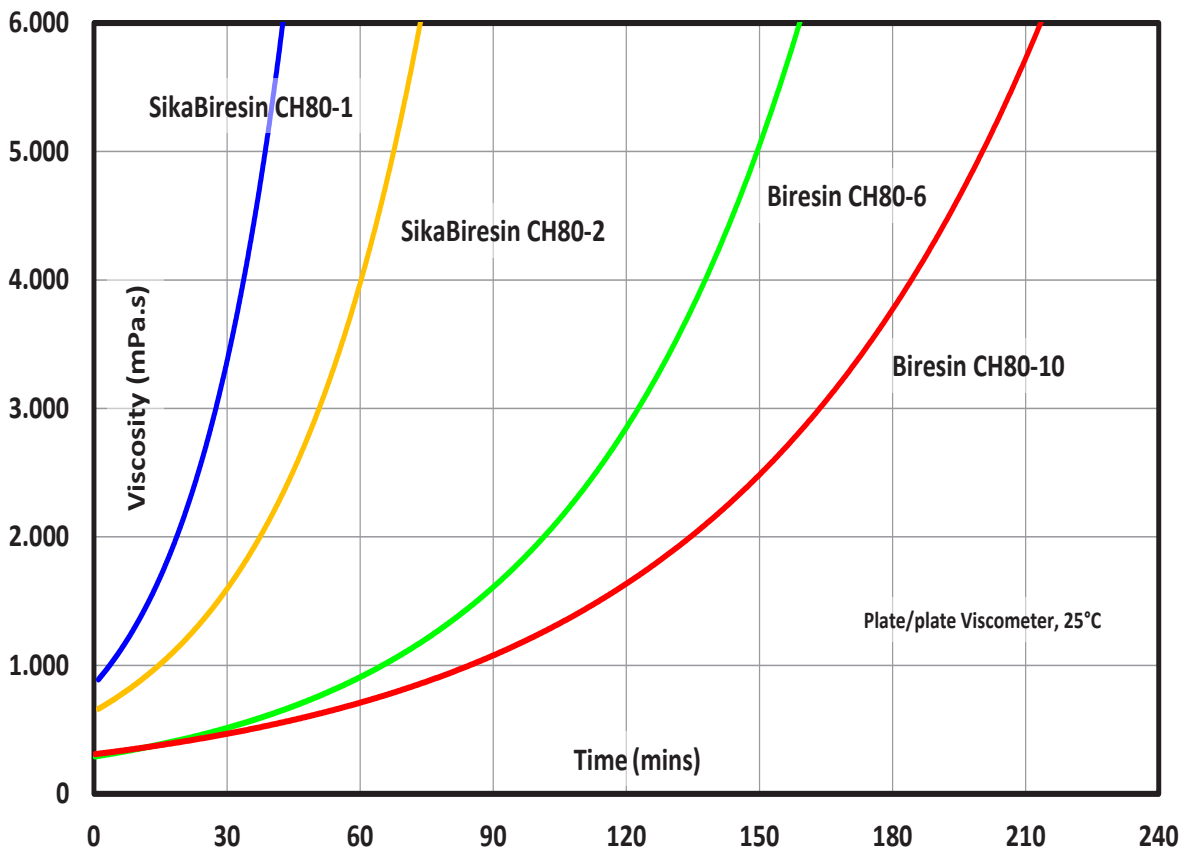
### Processing

- The material and processing temperatures should be from 18 to 35°C.
- The mixing ratio must be followed accurately to obtain best results. Deviating from the correct mix ratio will lead to lower performance.
- The final mechanical and thermal values are dependent on the applied postcuring cycles.
- To clean brushes or tools immediately Sika Reinigungsmittel 5 is recommended.
- Additional information is available in "Processing Instructions for Composite Resins".

**Development of Exotherm of Biresin® CR82-Resin(A)-Hardener(B)-Mixtures, 100 g / RT, insulated,**



**Development of Viscosity of Biresin® CR82-Resin(A)-Hardener(B)-Mixtures, 25°C**



Typical Mechanical Properties of Fully Cured Neat Resin (source: Sika internal)						
Biresin® CR82 resin (A)	with hardener (B)		SikaBiresin® CH80-1	SikaBiresin® CH80-2	Biresin® CH80-6	Biresin® CH80-10
Tensile strength	ISO 527	MPa	94	90	84	82
Tensile E-Modulus	ISO 527	MPa	3,000	3,000	2,900	2,900
Elongation at break	ISO 527	%	4.9	5.6	6.4	6.2
Flexural strength	ISO 178	MPa	140	130	127	118
Flexural E-Modulus	ISO 178	MPa	3,300	3,200	2,900	2,800
Compressive strength	ISO 604	MPa	120	105	110	110
Density	ISO 1183	g/cm <sup>3</sup>	1.14	1.14	1.14	1.14
Shore hardness	ISO 868	-	D 85	D 85	D 85	D 85
Impact resistance	ISO 179	kJ/m <sup>2</sup>	38	66	55	56

Typical Thermal Properties of Fully Cured Neat Resin						
Biresin® CR82 resin (A)	with hardener (B)		SikaBiresin® CH80-1	SikaBiresin® CH80-2	Biresin® CH80-6	Biresin® CH80-10
Heat distortion temperature	ISO 75A	°C	93	83	71	71
Glass transition temperature	ISO 11357	°C	97	90	83	85

### Postcuring

The suitable cure cycle and the attainable mechanical and thermal values depend on various factors, such as laminate thickness, fibre volume, reactivity of the resin system etc.

An appropriate cure cycle could look as follows:

- Heat-up rate of ca. 0.2°C/Minute until approx. 10°C below the required glass transition temperature (T<sub>g</sub>)
- Followed by a dwell at that temperature of between 2 and 12 hours.
- Part(s) should then be cooled at ~0.5°C per minute

The specific postcure should be adapted to the required technical and economic requirements.

- With hardeners (B) SikaBiresin® CH80-1 and CH80-2 demoulding after room temperature cure is possible.
- With hardeners (B) Biresin® CH80-6 and CH80-10 curing at 45°C before demoulding is required dependent on components.

To measure the mechanical performance of the resin system a Sika Advanced Resins standard cycle is used to ensure that the full T<sub>g</sub> potential of the system in question is reached.

### Packaging (net weight, kg)

Biresin® CR82 resin (A)	1,000	200	30	11.1
Biresin® CH80-1 hardener (B)		180		3
Biresin® CH80-2 hardener (B)		180		3
Biresin® CH80-6 hardener (B)		180	20	3
Biresin® CH80-10 hardener (B)		180	25	3

### Storage

- Minimum shelf life of Biresin® CR82 resin (A) is 24 month and of SikaBiresin® CH80-1, CH80-2 and Biresin® CH80-6, CH80-10 hardener (B) is 12 months under room conditions (18 - 25°C), when stored in original unopened containers.
- After prolonged storage at low temperature, crystallisation of resin (A) may occur. This is easily removed by warming up for a sufficient time to at least 60°C.
- Containers must be closed tightly immediately after use. The residual material needs to be used up as soon as possible.

## Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety related data.

## Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

## Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## Legal Notice

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's re-recommendations in accordance to our most recent product data sheet. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current General Terms and Conditions of Sales, Delivery and Payment. The most recent product data sheet applies. General Terms and product data sheets can be requested from us or are available to download at [www.sika.de](http://www.sika.de). Please check availability of local product data sheet at your local website. In cases of doubt the German text is valid.

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# TYPE APPROVAL CERTIFICATE

**This is to certify:**

**That the Epoxy Systems**

with type designation(s)  
**Biresin CR82 - Series**

Issued to  
**Sika Deutschland GmbH**  
**Bad Urach, Baden-Württemberg, Germany**

is found to comply with  
**DNV GL class programme DNVGL-CP-0089 – Type approval – Epoxy resin systems**  
**DNV GL rules for classification – High speed and light craft**  
**DNV GL rules for classification – Yachts**

**Application :**

**Laminating resin for construction of laminates made of fibre reinforced plastics**

Issued at **Hamburg** on **2020-10-01**

This Certificate is valid until **2025-09-30**.

for **DNV GL**

DNV GL local station: **Augsburg**

Approval Engineer: **Joachim Rehbein**

.....  
**Thorsten Lohmann**  
**Head of Section**

This Certificate is subject to terms and conditions overleaf. Any significant change in design or construction may render this Certificate invalid. The validity date relates to the Type Approval Certificate and not to the approval of equipment/systems installed.

LEGAL DISCLAIMER: Unless otherwise stated in the applicable contract with the holder of this document, or following from mandatory law, the liability of DNV GL AS, its parent companies and subsidiaries as well as their officers, directors and employees ("DNV GL") arising from or in connection with the services rendered for the purpose of the issuance of this document or reliance thereon, whether in contract or in tort (including negligence), shall be limited to direct losses and under any circumstance be limited to 300,000 USD.



Job Id: **262.1-033894-1**  
Certificate No: **TAK00001YC**

## Product description

Epoxy resin Biresin CR82 with following hardener:

- Biresin CH80-1
- Biresin CH80-2
- Biresin CH80-6
- Biresin CH80-10

## Material Properties

The following properties (mean value) have been verified by initial type testing:

Property	Test Method		CR82/ CH80-1	CR82/ CH80-2	CR82/ CH80-6	CR82/ CH80-10
Tensile Strength <sup>1</sup>	ISO 527-2	MPa	73	82	76	80
Tensile Modulus <sup>1</sup>	ISO 527-2	MPa	3366	3260	3378	3246
Fracture Elongation <sup>1</sup>	ISO 527-2	%	2.6	5.4	5.2	6.1
HDT (A)	ISO 75-2	°C	68.9	70.0	66.9	67.7
DSC <sup>2</sup>	ISO 11357	°C	77.73	69.91	65.77	66.55
Water Absorption <sup>3</sup>	ISO 175	mg	29	24	26	26

Curing procedure used for type testing: 16h at 55°C

Notes:

<sup>1</sup>: Material test by Sika Deutschland GmbH, dated 2020-07-08

<sup>2</sup>: Onset temperature, second run

<sup>3</sup>: Water absorption after 168h

## Application/Limitation

The resin complies with the applicable requirements of DNV GL and is compatible to the fibres, adhesives and core materials. Any significant changes in design and / or quality of the material will render the approval invalid.

## Type Approval documentation

### Marking of product

Product shall be marked with *manufacturer's name, place of production, type designation and batch number*.

The marking is to be carried out in such a way that it is visible, legible and indelible. The marking of product is to enable traceability to the DNV GL Type Approval Certificate.

### Assessed production sites

SIKA Deutschland GmbH  
Stuttgarter Str. 117  
72574 Bad Urach  
Germany

Job Id: **262.1-033894-1**  
Certificate No: **TAK00001YC**

### **Periodical assessment**

Periodical assessments for type approvals with a validity period of five years will be required after 2 years and after 3.5 years.

If an approval of manufacturer certificate which is still valid for at least one year is available, an exemption from the obligation concerning retention and renewal surveys listed in the class programme will apply.

END OF CERTIFICATE