



# Trelleborg Epoxy Resin Systems Overview

## Resin Systems without Fillers – Hot cure

A = Resin | B = Hardener

System Description	Colour Resin (A)/ Hardener (B)	Mixing Ratio (weight)	Pot Life (liner)	Hot Water Cure Curing Time	Steam Cure Curing Time
Trelleborg Epoxy HC60 (A + B) <sup>1)</sup>	neutral/brown	100 : 33	60 min (1 h) 25 °C/77 °F	60 min (1 h) 60 °C/140 °F	30 min (0,5 h) 80 °C/176 °F
Trelleborg Epoxy HC120 (A + B) <sup>2)</sup>	neutral/blue	100 : 33	120 min (2 h) 25 °C/77 °F	90 min (1,5 h) 60 °C/140 °F	45 min (0,75 h) 80 °C/176 °F

## Resin Systems with Fillers – Hot cure

A = Resin | B = Hardener

System Description	Colour Resin (A)/ Hardener (B)	Mixing Ratio (weight)	Pot Life (liner)	Hot Water Cure Curing Time	Steam Cure Curing Time
Trelleborg Epoxy HC120+ (A + B) <sup>2) 4)</sup>	white/blue	100 : 30	120 min (2 h) 25 °C/77 °F	90 min (1,5 h) 60 °C/140 °F	45 min (0,75 h) 80 °C/176 °F

## Resin Systems ambient cure – Fast cure

A = Resin | B = Hardener

System Description	Colour Resin (A)/ Hardener (B)	Mixing Ratio (weight)	Pot Life (liner)	Curing Time			
Trelleborg Epoxy FC15 (A + B)	neutral/purple	100 : 33	15 min 25 °C/77 °F	330 min (5,5 h) 10 °C/50 °F	150 min (2,5 h) 15 °C/59 °F	120 min (2 h) 20 °C/68 °F	90 min (1,5 h) 25 °C/77 °F
Trelleborg Epoxy FC30 (A + B) <sup>3)</sup>	neutral/purple	100 : 33	30 min 25 °C/77 °F	600 min (10 h) 10 °C/50 °F	360 min (6 h) 15 °C/59 °F	240 min (4 h) 20 °C/68 °F	150 min (2,5 h) 25 °C/77 °F

<sup>1)</sup> General Technical Approval by DIBt Certification technique DIBt (No. Z 42.3-375)

<sup>2)</sup> General Technical Approval by DIBt Certification technique DIBt (No. Z.42.3-468)

<sup>3)</sup> General Technical Approval by DIBt Certification technique DIBt (No. Z 42.3-466)

<sup>4)</sup> General Technical Approval by DIBt Certification technique DIBt (No. Z 42.3-488)



# Trelleborg Silicate Resin Systems Overview

## For Patch Repair + LCR-S

**B = Resin | A = Hardener**

System Description	Colour Resin (B)/Hardener (A)	Mixing Ratio (B : A) volume	Pot Life	Curing Time
Trelleborg Silicate Resin Type A (B + A)	brown/neutral	2 : 1	7 ±1 min 5 °C/41 °F	110 ±10 min 5 °C/41 °F
			8 ±1 min 20 °C/68 °F	55 ±10 min 20 °C/68 °F
Trelleborg Silicate Resin Type W (B + A)	brown/neutral	2 : 1	25 ±2 min 5 °C/41 °F	330 ±20 min 5 °C/41 °F
			17 ±2 min 20 °C/68 °F	170 ±20 min 20 °C/68 °F
Trelleborg Silicate Resin Type S (B + A)	brown/neutral	2 : 1	73 ±3 min 5 °C/41 °F	800 ±100 min 5 °C/41 °F
			32 ±2 min 20 °C/68 °F	260 ±30 min 20 °C/68 °F

## For Drain Liner

**B = Resin | A = Hardener**

System Description	Colour Resin (B)/Hardener (A)	Mixing Ratio (B : A) volume	Pot Life	Curing Time
Trelleborg Silicate Resin Type L30E1 (B + A)	brown/neutral	2 : 1	85 ±5 min 20 °C/68 °F	540 ±60 min (9 ±1 h) 20 °C/68 °F