

# MAKOBOND INFUSION RESIN 204

## PRODUCT DESCRIPTION

Makobond IR 204 is a very low viscosity infusion resin designed for various parts and structures. The mixed viscosity of IR 204 is very low making it ideal for large laminate systems that require deep penetration of fabrics. IR 204 has the added benefit of a room temperature cure as well.

## PRODUCT HIGHLIGHTS

- STRUCTURAL COMPONENTS
- ROOM TEMP CURE
- PENETRATES THICK FABRICS

## PRODUCT CHARACTERISTICS

	IR 204A	IR 204B
Viscosity @ 25°C	1,600 cps.	30 cps.
Specific Gravity	1.15	0.97
Color	Light Amber	Amber

## HANDLING PROPERTIES

Infusion Resin 204	
Mix Ratio By Weight, Resin, Hardener	100:25
Mix Ratio By Volume, Resin, Hardener	3.3:1
Mixed Viscosity @ 25°C	450 cps.
Pot Life @ 25°C	80-100 minutes

## PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	85-88D	D2240
Flexural Strength (psi)	16,427 psi	D790
Flexural Modulus (psi)	465,103 psi	D790
Compressive Strength (psi)	13,582 psi	D695
Tensile Strength (psi)	10,022 psi	D638
Tensile Modulus (psi)	417,852 psi	D638
Glass Transition Temperature, Tg, (DMA)	203°F	D4065

## HANDLING AND CURING

Measure out the proper weights of IR 204 and mix until uniform and no streaks are present throughout. Be sure to scrape the sides and bottom on mixing container to avoid any unmixed material. IR 204 will cure at room temperature and does not require any post cure to reach full properties.

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### PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit	Drum Kit
IR-204A	2 lbs	8 lbs	48 lbs	500 lbs
IR-204B	0.5 lbs	2 lbs	12 lbs	125 lbs
IR-204 Kit	2.5 lbs	10 lbs	60 lbs	625 lbs

### STORAGE AND SAFETY

Makobond IR 204 has a shelf life of 12 months from date of shipment when unopened and stored at ambient temperatures, (18-27°C). Nitrogen purging opened containers is recommended before re-sealing. IR 204B may darken over time, but this will have no effect on any finished product. Users need to exercise proper care while working with material; gloves, eyewear, and proper ventilation are recommended. Warning: All thermosetting matrix systems undergo exothermic reaction during vulcanization and/or curing, generating heat. If not properly managed, exothermic reactions may release possibly flammable or toxic gases into the surrounding. Users should exercise extreme caution when blending large volumes of ingredients (ie greater than 1 lb), and/or curing thick sections of components (typically greater than 0.200 inches). Users should monitor heat profiles of any curing or blended materials carefully and attentively during cure. Please contact a Mako team member with any concerns prior to use and/or to coordinate the proper management of safety and temperature monitoring process to avoid exothermic phenomena.