

# AMPREG™ 3X THIXOTROPIC PREGEL

## EPOXY WET LAMINATING SYSTEM RESIN ADDITIVE

**Ampreg 3X Series Thixotropic Pregel is a resin additive with a grease-like consistency, which can be used with a variety of hardeners from the Gurit laminating resin range. It is used primarily as a thixotrope - to be added to low viscosity laminating resins for applications where resin drainage is a concern. It is therefore typically used in vertical and overhead laminating situations, particularly where heavy, open weave fabrics are being used, since these are the most prone to resin drainage.**

Ampreg 3X Series Thixotropic Pregel can be used as the base resin component of an adhesive for bonding honeycomb & foam cores, and other rigid materials, whilst offering improved health & safety through the careful selection of low toxicity raw materials.

The properties of an Ampreg 3X Series Thixotropic Pregel / laminating hardener combination are broadly similar to those of the hardener with its usual resin. This is because the thixotropic agents are added to a high-quality resin base and because the Pregel is usually added to the laminating system at relatively low levels. At higher addition levels, the resulting laminate has the potential to be more brittle than the “neat” laminating system.

- Uses Ampreg 3X low toxicity hardeners
- Reduces drainage of vertical laminates
- For use with Ampreg 30, 31 and 36 resins
- Can be used as a core bonding adhesive
- Improved hazard labeling
- Non-CMR & SVHC Free
- Reduced environmental hazards
- Mix ratio dependent on blend see included table

## INSTRUCTIONS FOR USE

The product is optimized for use between 18 - 25°C (64 – 77°F). At lower temperatures the product thickens and may become unworkable. At higher temperatures working times will be significantly reduced. Maximum relative humidity for use is 70%.

### MIXING AND HANDLING

Ampreg 3X Thixotropic Pregel can be used with Ampreg 30, 31 & 36 resins and in conjunction with Ampreg 3X Series hardeners to modify the thixotropy, resistance to flow and drain, of these systems. It is normally used as a percentage of the total mix, the Ampreg 3X Thixotropic Pregel being blended with the parent systems resin before the addition of the parent systems hardener. Due to the addition of the colloidal silica in the Ampreg 3X Thixotropic Pregel this does change the mix ratio dependent on the ratio of parent resin to Ampreg 3X Thixotropic Pregel. The Ampreg 3X Thixotropic Pregel will increase the viscosity and so the minimum percentage addition suitable for the application and the workshop conditions should be used.

Accurate measurement and thorough mixing are essential when using this system, and any deviation from the prescribed mix ratios will seriously degrade the physical properties of the cured system. Ampreg 3X Fast and Extra-slow hardeners can be blended in order to achieve intermediate speeds as indicated in the table.

HARDENER	FAST	STANDARD	SLOW	EXTRA-SLOW
Ampreg 3X Fast	100%	67%	25%	0%
Ampreg 3X Extra-slow	0%	33%	75%	100%

The resin and hardener must be stirred well for two minutes or more, with particular attention being paid to the sides and bottom of the container. As soon as the material is mixed the reaction begins. This reaction produces heat (exothermic), which will in turn accelerate the reaction. If this mixed material is left in a confined mixing vessel the heat cannot disperse and the reaction will become uncontrollable.

NOTE: When used with Ampreg 30, 31 or 36, particularly at high loadings (>50%), the viscosity and working time behaviour can be significantly different. Therefore, at high pre-gel loadings, consideration should be given to utilising a slower hardener speed if extended working time is required.

Gurit produces a separate full Safety Data Sheet for each component of this system. Please ensure that you have the correct SDS to hand for the materials you are using before commencing work. A more detailed guide for the safe use of Gurit resin systems is also available from Gurit and can be found on our website at [www.gurit.com](http://www.gurit.com). Any accidental spillage should be soaked up with sand, sawdust, cotton waste or any other absorbent material. The area should then be washed clean (see appropriate Safety Data Sheet).

### APPLICATION

Acting as a flow retardant, Ampreg 3X Series Thixotropic Pregel will slow the wet-out of reinforcements. This should be borne in mind when selecting the appropriate speed of hardener. Consult the datasheet for the resin system with which Ampreg 3X Thixotropic Pregel is to be used, for information regarding application and cure schedule. Test panels should always be made prior to application to ensure the correct Pregel loading and hardener have been selected for the given working conditions. For further advice, please contact Gurit Technical Support.

### CURE SCHEDULE

Refer to the corresponding Ampreg 30, Ampreg 31 or Ampreg 36 technical datasheet. For advice on effective vacuum bag consolidation, please contact Gurit Technical Support.

### TRANSPORT & STORAGE

The resin and hardener should be kept in securely closed containers during transport and storage. Any accidental spillage should be soaked up with sand, sawdust, cotton waste or any other absorbent material. The area should then be washed clean (see appropriate Safety Data Sheet). Adequate long term storage conditions will result in a shelf life, as per table, from the date of manufacture for both the resin and hardeners, see product container label for expiry date.

COMPONENT	UNITS	10 – 25°C (50 – 77°F)
Ampreg 3X Series Thixotropic Pregel	Months	12

Storage should be in a warm dry place out of direct sunlight and protected from frost. The storage temperature should be kept constant between 10 - 25°C (50 – 77°F), cyclic fluctuations in temperature can cause crystallization. Containers should be firmly closed. Hardener, in particular, will suffer serious degradation if left exposed to air. Hardeners may darken over time, however the physical properties are not affected. Be aware of a possible mixed system color change if very old and new hardeners are used on the same project.

## AMPREG 3X THIXOTROPIC PREGEL & AMPREG 3X HARDENERS

All data has been generated from typical production material and does not constitute a product specification.

### MIXED SYSTEM PROPERTIES\*

PROPERTY	UNITS	A3X Fast	A3X Standard	A3X Slow	A3X X-Slow	TEST METHOD
Earliest time to apply vacuum	hrs:min	00:45	01:30	03:30	05:40	Internal method
Latest time to apply vacuum	hrs:min	01:15	02:10	04:40	07:15	Internal method
Earliest demold time	hrs:min	02:00	03:15	06:40	09:40	Internal method

\* These times may vary due to exotherm of quantity used.

## AMPREG 30 LAMINATING SYSTEM & AMPREG 3X THIXOTROPIC PREGEL

### MIX RATIO GUIDELINES (PARTS BY WEIGHT)

AMPREG 30 RESIN	THIXOTROPIC PREGEL RESIN	AMPREG 3X SERIES HARDENERS
100	0	26
75	25	26
50	50	25
25	75	24
0	100	24

## AMPREG 31 LAMINATING SYSTEM & AMPREG 3X THIXOTROPIC PREGEL

### MIX RATIO GUIDELINES (PARTS BY WEIGHT)

AMPREG 31 RESIN	THIXOTROPIC PREGEL RESIN	AMPREG 3X SERIES HARDENERS
100	0	26
75	25	26
50	50	25
25	75	24
0	100	24

## AMPREG 36 LAMINATING SYSTEM & AMPREG 3X THIXOTROPIC PREGEL

### MIX RATIO GUIDELINES (PARTS BY WEIGHT)

AMPREG 36 RESIN	THIXOTROPIC PREGEL RESIN	AMPREG 3X SERIES HARDENERS
100	0	29
75	25	28
50	50	26
25	75	25
0	100	24

## HEALTH AND SAFETY

The following points must be considered:

1. Skin contact must be avoided by wearing protective gloves. Gurit recommends the use of disposable nitrile gloves for most applications. The use of barrier creams is not recommended, but to preserve skin condition a moisturizing cream should be used after washing.
2. Protective clothing should be worn when mixing, laminating or sanding. Contaminated work clothes should be thoroughly cleaned before re-use.
3. Eye protection should be worn if there is a risk of resin, hardener, solvent or dust entering the eyes. If this occurs flush the eye with water for 15 minutes, holding the eyelid open, and seek medical attention.
4. Ensure adequate ventilation in work areas. Respiratory protection should be worn if there is insufficient ventilation. Solvent vapors should not be inhaled as they can cause dizziness, headaches, loss of consciousness and can have long term health effects.
5. If the skin becomes contaminated, then the area must be immediately cleansed. The use of resin-removing cleansers is recommended. To finish, wash with soap and warm water. The use of solvents on the skin to remove resins etc must be avoided.

Washing should be part of routine practice:

- before eating or drinking
- before smoking & vaping
- before using the lavatory
- after finishing work

6. The inhalation of sanding dust should be avoided and if it settles on the skin then it should be washed off. After more extensive sanding operations a shower/bath and hair wash is advised.

Gurit produces a separate full Safety Data Sheet for all hazardous products. Please ensure that you have the correct SDS to hand for the materials you are using before commencing work.

## NOTICE

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The Company reserves the right to change specifications and prices without notice and Customers should satisfy themselves that information relied on by the Customer is that which is currently published by the Company on its website. Any queries may be addressed to the Technical Services Department.

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## CONTACT INFORMATION

Please see local contact information at [www.gurit.com](http://www.gurit.com)

## 24-HOUR CHEMICAL EMERGENCY NUMBER

For advice on chemical emergencies, spillages, fires or exposures:

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