

PRODUCT DATA SHEET

# SikaBiresin® CR76 (Formerly EL-360)

Epoxy Infusion System with Very Long Pot Life/Working Time, for Room Temperature Applications

**TYPICAL PHYSICAL PROPERTIES (FOR FURTHER VALUES SEE SAFETY DATA SHEET)**

Properties	SikaBiresin® CR76 (A) Resin	SikaBiresin® CH76-9 (B) Hardener
Composition	Epoxy	Amine
Mix ratio – by weight	100	32
Aspect	Liquid	Liquid
Color	Clear	Light amber
Color (mixed)	Clear light amber	
Viscosity – Brookfield (mixed)	280 cps	
Specific gravity at 77°F (25°C) (mixed)	9.49 lbs./gal (1.14 g/cc)	
Gel time (130 g) at 77°F (25°C)	550 - 570 Minutes	

**DESCRIPTION**

SikaBiresin® CR76 is a two-component, epoxy-based infusion system designed for use in the production of composite structures. SikaBiresin® CR76 is well suited for vacuum infusion molding, laminating, filament winding, pultrusion and compression molding. The system exhibits excellent mechanical properties and good cure characteristics at room temperature.

**PRODUCT BENEFITS**

- Excellent mechanical properties
- Very long pot life/working time
- Low mixed viscosity for good wet out
- Clear, light amber color for good clarity

**AREAS OF APPLICATION**

Typical applications include the production of high performance composite tools or parts for a wide range of industries including marine, transportation, industrial, and others. The very long pot life/working time allows for several processing techniques, such as, infusion, filament winding, pultrusion, compression molding and others.

**TYPICAL MECHANICAL AND THERMAL PROPERTIES**

Properties, Test Method	SikaBiresin® CR76 (A) Resin	SikaBiresin® CH76-9 (B) Hardener
Hardness - Shore D, ASTM 2240	80	
Tensile strength, ASTM D638	10,684 psi (74 MPa)	
Tensile elongation, ASTM D638	4%	
Flexural strength, ASTM D790	19,040 psi (131 MPa)	
Flexural modulus, ASTM D790	450,000 psi (3,103 MPa)	
HDT - Heat Deflection temperature @ 66 psi	164 °F (73°C)	
Glass Transition Temperature (Tg) – DSC	170 °F (77°C)	

Cure 24 hours at 77°F (25°C) + 8 hours at 176°F (80°C)

**PROCESSING**

Normal health and safety precautions should be observed when handling these products:

- Ensure adequate ventilation
- Wear gloves, glasses, and protective clothes

For further information, please consult the Safety Data Sheets

**STORAGE CONDITIONS**

Shelf life of resin and hardener is 24 months when stored in original, unopened containers between 65-77°F (15 - 25°C). Keep containers tightly closed.

**PACKAGING INFORMATION**

Packaging information is available upon request. Please contact your local Sika sales representative.

**FURTHER INFORMATION**

Advice on specific applications will be given on request. To contact Sika corporation’s Industry Technical Services Department, send an email to [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Copies of Safety Data Sheets and Product Data Sheets are available upon request.

**BASIS OF PRODUCT DATA**

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

**ENVIRONMENTAL, HEALTH AND SAFETY**

For further information and advice regarding transportation, handling, storage and disposal of chemical

products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

**LEGAL DISCLAIMER**

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates (“SIKA”), the user must always read and follow the warnings and instructions on the product’s most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA’s Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product. SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product’s shelf life. User determines suitability of product for intended use and assumes all risks. User’s and/or buyer’s sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL**

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