

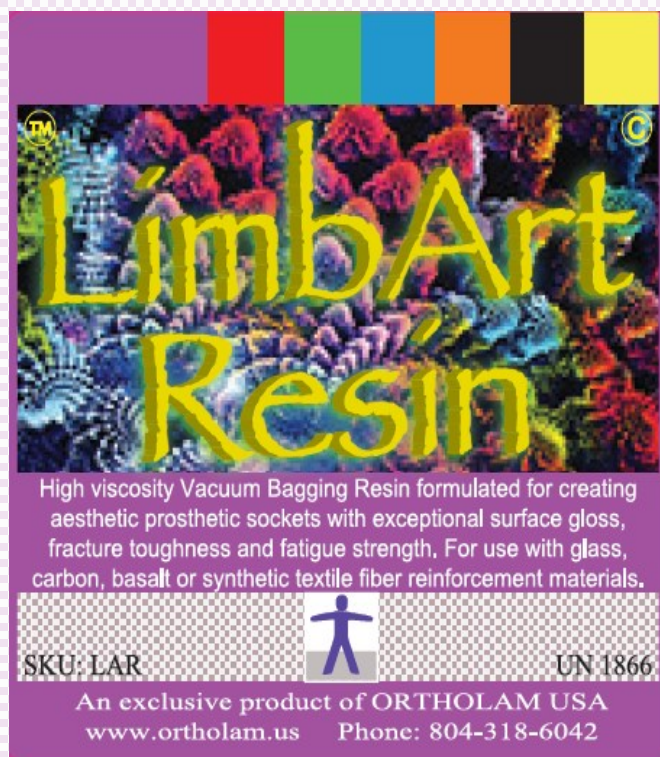


TM  
©

# LimbArt Resin

Low odor and volatile emissions  
High viscosity epoxy based formula  
Produces a smooth high gloss surface  
Superior elevated vacuum performance  
No PETG socket liner needed  
Soap and water clean up

The best choice  
of resin to make  
your socket  
graphic artwork  
“POP”



See Reverse Side for Product Technical Information Sheet

- Extremely easy to work with allowing you to fabricate rigid thin wall fabrications with super smooth finished edges and high surface gloss with a scratch and mar resistant surface for improved aesthetic durability.
- Produces bubble and crack free laminates with high flexural strength, excellent cured resin clarity, that saves you time, money, increases shop productivity, and will not crush your liners from excessive pressure.
- Available in 1, 2 and 4 Gallon Jug Kits. BP100 Paste Hardener sold separately.

ORTHOLAM USA

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# LimbArt Resin



## Product Technical Information Sheet

- ◆ High viscosity formulation producing excellent gloss.
- ◆ Very clear cured color with improved clarity.
- ◆ Easily pigmented to any desired color.
- ◆ Fast curing formula with low volatile emissions.
- ◆ Provides good fiber wet out and adhesion.
- ◆ Increased shelf life up to 12 months with proper storage, (between 50°F / 10°C and 82°F / 28°C) .
- ◆ Fabricates high quality light weight sockets.
- ◆ Skin friendly surface and the edges are easily sanded and buffed to a fine smooth finish.
- ◆ Low shrinkage of less than 2%.
- ◆ Will not liberate gas, develop air pockets, or block your vacuum lines during the curing process.
- ◆ Great resin for increased shop cost savings and productivity. Soap and water cleanup.

**LimbArt Resin** is a high viscosity vacuum bagging resin that provides exceptional physical properties and fracture toughness when fully cured at room temperature, as well as ease of use to the Prosthetic and Orthotic industry.

**LimbArt Resin** is formulated to have a gel time of 13 minutes using 2.5% BP100 paste hardener, measured by mass or volume, with a shop temperature of 75°F / 24°C. (3% = 11 mins.) Please use a precision scale or volumetric measuring cup and spoon to measure the Resin and Hardener to achieve consistent results.

The paste hardener must be thoroughly and evenly dispersed into the resin by hand or with a Helix Turbine mixer.

Warm the cast to 24°C / 75°F and laminate over as dry a cast as possible to achieve the best results.

Warmer summer shop temperatures will reduce the viscosity and speed up the curing time. (11 minutes @ 28°C)

Cooler winter shop temperatures will increase the viscosity and slow down the curing time. (17 minutes @ 20°C)

Make sure that the PVA bag seals against the outer ridge of the distal attachment device. Use high vacuum of around 28"Hg / 90kPa to allow the resin to be sucked through and just below the distal attachment before using your hands to gently squeeze the PVA bag and force additional resin past the distal attachment slowly and evenly down to the proximal trim lines of the socket. Be careful not to trap any air in the resin. Clamp off the supply of resin from the reservoir above the distal attachment. The vacuum level may be reduced to 10"Hg / 30kPa to produce a much smoother glossy surface during the stringing process to establish a uniform resin thickness over the entire surface of the socket.

The cure rate of **LimbArt Resin** is temperature and volume sensitive, thin sections of your laminate will take several minutes longer to cure than the thicker sections. After the resin has been strung into position satisfactorily, heat from a hot air gun set at 120°C / 250°F may be applied to the entire thin wall surfaces of the fabrication for 2 minutes to accelerate the curing process, thereafter the resin will cure and harden rapidly.

Before demolding, always check to make sure that the resin has fully cured.

**LimbArt Resin** will achieve high strength with a dust dry surface after 30 minutes, however, it will continue to get harder, stronger and tougher for up to 24 hours.

**LimbArt Resin** is formulated for use with both braided and knitted carbon, glass, basalt and synthetic textile fiber reinforcement materials. To achieve the best results, always laminate over as dry a cast as possible. If it is not possible to have a dry cast, we recommend that you seal the surface of the cast with a sealing resin, or use a Latex Isolation Sheath and a PVA release bag or film to isolate the resin from the moisture.

Remember to dry the inner and outer vacuum bag surfaces. Storage of **LimbArt Resin** beyond the expiry date specified on the Label does not necessarily mean that the product is no longer usable. In this case however, a performance test must be done on a small 50g sample of resin to determine its suitability for the intended usage.

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