

TM  
©

CLEAR  
HIGH GLOSS  
FORMULA

# Limb Art Resin

Low odor and volatile emissions  
High viscosity epoxy based formula  
Produces a smooth high gloss surface  
Superior elevated vacuum performance  
Soap and water clean up  
Cures to a clear color

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.
- Produces bubble and tack 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

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# LimbArt Resin

## Directions for Use & Storage of LIMBART Resin

- 1 Shake container well before decanting resin
- 2 Always weigh resin into mixing container
- 3 Mix in between 2% and 3% hardener paste
- 4 Mix in 2% pigment as required
- 5 Mix hardener and any pigment into resin by stirring briskly for a minimum of 2 minutes until fully dissolved
- 6 Read Safety Data Sheet and review GHS HazCom info below before using, handling or exposure to this product. See Technical Info Sheet and Tech Notes for additional information
- 7 Keep container tightly sealed and avoid breathing vapors. Store in a ventilated place at a stable temperature between 10°C (50°F) and 28°C (82°F) Avoid direct exposure to sunlight and sources of heat or cold.
- 8 Gel Time with 2% BPO Hardener @ 75°F / 24°C: 15-20 min.

### Hazard statements:

Flammable liquid and vapor. Causes skin and eye irritation. May cause respiratory irritation. Causes damage to organs through prolonged and repeated exposure if inhaled.



### Precautionary statements:

Wear protective gloves, protective clothing & eye protection. Keep away from heat, sparks and open flames. Wash with soap and water if skin becomes contaminated. Avoid release to the environment.



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## 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 3%.
- ◆ Does not liberate gas and will not develop air pockets 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 between 13 ~ 18 minutes when combined with the recommended 2% BP100 paste hardener, measured by mass or volume, with a shop temperature of 75°F / 24°C.

Please use a precision scale or volumetric measuring spoon to measure the hardener to achieve consistent results.

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

Warmer summer shop temperatures will reduce the viscosity and speed up the curing time. (12 minutes @ 28°C)

Cooler winter shop temperatures will increase the viscosity and slow down the curing time. (18 minutes @ 20°C)

The cure rate of this resin is temperature and volume sensitive, which means that a large quantity of resin will cure faster than a smaller amount, causing the thinner sections of your laminate to take several minutes longer to cure than the thicker sections. Very thin sections may require the application of some external heat to speed up the cure.

Make sure that the PVA bag seals against the out ridge of the distal attachment device. After applying vacuum, allow the resin to be sucked through and 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.

Now start the stringing process to establish a uniform resin thickness over the entire surface of the socket.

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 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 Sheaths and a PVA release film bag 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. Test all coloration pigments first to determine if there are any compatibility issues.

Contact our office for more technical information and fabrication tips.

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