

DESCRIPTION

Production of large dimensions tools, mock-ups & master plugs by extrusion process.

PROPERTIES

- Very good surface aspect
- Good thermal resistance
- Good behavior on vertical support up to 30 mm

PHYSICAL PROPERTIES				
Composition		RESIN	HARDENER	MIXED
Mix ratio by weight		100	100	
Aspect		viscous paste	viscous paste	viscous paste
Colour		grey	white	grey
Viscosity at 25°C 0.9 s ⁻¹ (mPa.s)	ISO 3219 : 1993	900	800	800
Specific gravity at 25°C (g/cm ³)	ISO 1675 : 1985	0.79	0.79	-
Specific gravity of cured product at 23°C	ISO 2781 : 1996	-	-	0.82

PROCESSING CONDITIONS

On vertical support, it is sometimes recommended to apply a thin coat of product with a spatula. This will help to reinforce the bonding on the support.

For ceiling application, we recommend 30 mm of maximum thickness.

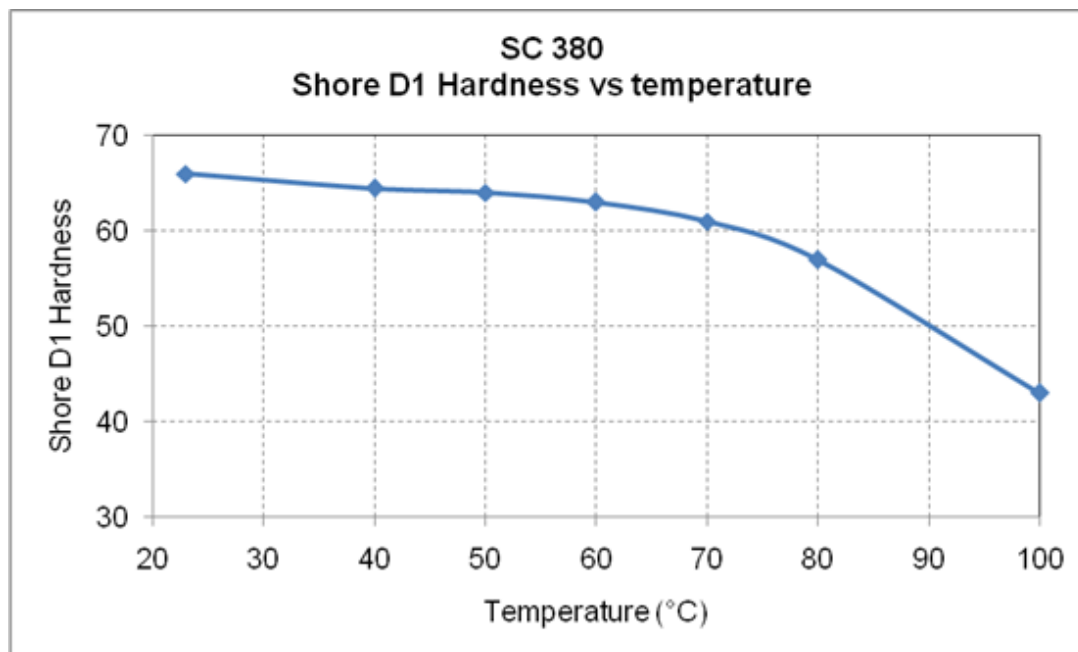
During processing, the dispensing nozzle must be maintained perpendicular to the surface on which the product is applied. Ensure overlap of ribbon.

CAUTION : Exotherm mostly depends of the type of machine and of the working parameters such as :

- Room temperature
- Insulating property of support
- The mixture temperature (depending of the type of mixer: static or dynamic) and the speed of mixing and output
- Applied thickness

EXOTHERMIC PEAK AND HARDENING TIME (1)				
Thickness (mm)	Product temperature (°C)	Exothermic peak (hours /temperature)	Workability (hours)	Linear shrinkage (mm/m)
25	27	2.5 / 60	24	<1

(1) Room temperature : 20/22°C – polystyrene support



MECHANICAL PROPERTIES at 23°C (2)

Hardness	7 days at 23°C 16 hours at 70°C	ISO 868 : 2003	Shore D1	65 67
Tensile modulus		ISO 527 : 1993	MPa	1,100
Tensile strength		ISO 527 : 1993	MPa	14
Elongation at break		ISO 527 : 1993	%	2.8
Flexural modulus		ISO 178 : 2010	MPa	1,100
Flexural strength		ISO 178 : 2010	MPa	22
Compressive modulus		ISO 604 : 2002	MPa	800
Compressive strength at yield		ISO 604 : 2002	MPa	23

THERMAL AND SPECIFIC PROPERTIES (2)

Glass transition temperature (Tg)	7 days at 23°C 16 hours at 70°C	ISO 11359-2 : 1999	°C	50 83
Coefficient of thermal expansion (CTE)		ISO 11359-2 : 1999	10 ⁻⁶ K ⁻¹	65
Maximal filling thickness		-	mm	30

(2) Average values obtained on standardized specimens / Hardening 24 h at 23°C + 16 h at 70°C

EPOXY TOOLING PASTE

DENSITY 0.82 – HARDNESS 65D SHORE

HANDLING PRECAUTIONS

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

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes

For further information, please consult the product safety data sheet.

STORAGE CONDITIONS

Shelf life of both parts is 12 months in a dry place and in their original unopened containers at a temperature between 15 and 25°C

Any open must be tightly closed under dry nitrogen.

PACKAGING

RESIN	HARDENER	INTERNAL DIAMETER OF DRUMS
1 x 150 kg 1 x 35 kg	1 x 150 kg 1 x 35 kg	570 mm 360 mm

GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.