



BUILDING TRUST



EPOPAST 402 RESIN EPOPAST 400 HARDENER

LAMINATING EPOXY PASTE
TEMPERATURE RESISTANCE 70°C
Low density

DESCRIPTION

- *Negatives and tools*
- *Checking fixtures or positioning models*
- *Designed for fillets and reinforcements*
- *Alternative to liquid lamination techniques for production of laminates*

PROPERTIES

- *Low odour*
- *Very easy to mix and apply*
- *Low density*
- **Mechanical properties**

PHYSICAL PROPERTIES				
Composition		RESIN EPOPAST 402	HARDENER EPOPAST 400	MIXED
Mix ratio by weight		100	14	
Aspect		fibrous paste	liquid	fibrous paste
Colour		white	green	green
Specific gravity at 25°C (g/cm ³)	ISO 1675 : 1985	0.68	0.97	-
Specific gravity of cured product at 23°C	ISO 2781 : 1996	-	-	0.72
Pot life at 25°C on 570 g (min)	-			120

PROCESSING CONDITIONS

Final properties are guaranty when the products are used and stored between + 18 to 25°C; If the conditions are different, viscosity and reactivity will change.

Processing is carried out by hand for quantities below 1 kg. For larger quantities mix with a planetary mixer like a kneader fitted out with a pigtail agitator. Put the agitator in the tank. Then weigh quantities to be blended and place the whole under the kneader. 50 rev / min is the maximum speed recommended. When mixing at a higher speed product rises in temperature and incurs a higher shrinkage.

Remark: *To obtain a surface finish coat (surface aspect, chemical resistance), apply EPOPAST 402 Resin / EPOPAST 400 Hardener on a gel coat. It is always recommended to apply the laminating paste on a tacky but not cured gel coat.*

Advised gel coats : GC 1 050, GC 1 080,

Advised binder layer : EPOLAM 2010, EPOLAM 2020

AXSON FRANCE - SikaAxson Head Office France +33 1 34 40 34 60 axson@axson.com www.sikaaxson.com	GERMANY +49 (0)7125 940 492 tooling@de.sika.com www.sikaaxson.de	SPAIN & PORTUGAL +34 93 225 16 20 axson@axson.es axson.es	SLOVAKIA +421 37 642 25 26 office@axson-ce.sk axson-ce.sk	NORTH AMERICA +1 517 663 8191 info@axsontech.us axsontech.us	JAPAN +81 564 26 25 91 sales@axson.jp axson.jp	INDIA +91 20 25560710 info.india@axson.com axson.com
	ITALY +39 02 96 70 23 36 axson@axson.it axson.it	U.K. +44 1 638 66 00 62 sales@axson.co.uk axson.com	MEXICO +52 55 52 64 49 22 axson@prodigy.net.mx axson.com.mx	CHINA +86 21 58 68 30 37 china@axson.cn axson.cn	MIDDLE EAST +971 7 2432227 info.middleeast@axson.com axson.com	

MECHANICAL PROPERTIES at 23°C (1)			
Hardness	ISO 868 : 2003	Shore D1 / D15	80/78
Flexural modulus	ISO 178 : 2001	MPa	4,000
Flexural strength	ISO 178 : 2001	MPa	42
Compressive strength	ISO 604 : 2002	MPa	55
THERMAL AND SPECIFIC PROPERTIES (1)			
Glass transition temperature (T _g)	ISO 11359-2 : 1999	°C	70
Coefficient of thermal expansion (CTE) (+10°C to +60°C)	ISO 11359-2 : 1999	10 ⁻⁶ K ⁻¹	24
Maximal casting thickness	-	mm	40
Demoulding time at 25°C		hour	24
Complete hardening time at 25°C		day	7

(1) Average values obtained on standardized specimens / Hardening 16h at 60°C

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

PACKAGING

EPOPAST 402 RESIN	EPOPAST 400 HARDENER
10 kg	1.4 kg

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.