

APPLICATIONS

Quick repair and surfacing on SC 390 system.

PROPERTIES

- Machinable after 4 hours.
- Same aspect than modelling pastes.

PHYSICAL PROPERTIES				
		M 390 RESIN	M 10 HARDENER	MIXING
Mixing ratio by weight		100	33	
Mixing ratio by volume at 25°C		100	58	
Aspect		thick paste	thick paste	thick paste
Color		grey	white	grey
Specific gravity at 25°C (g/cm ³)	ISO 1675 : 1985	1.06	0.60	0.89
Specific gravity of cured product at 23°C	ISO 2781 : 1996	-	-	0.91
Pot life at 25°C on 133 g (min)	Gel Timer TECAM			35

PROCESSING CONDITIONS

Mix resin with hardener on a flat surface with spatula. As soon as colour is uniform, apply a thin coat on the support. Let it cure until required hardness.

MECHANICAL AND THERMAL PROPERTIES			
Hardness			
After 24 H 23°C	ISO 868-85	Shore D1	69
After 16 H 70°C			70
Glass transition temperature (Tg)			
After 24 H 23°C	ISO 11359-02	°C	67
After 16 H 70°C			83
Waiting time before machining at 23°C (thickness 3 mm)	-	hours	4
Complete hardening time at 23°C	-	hours	24

(1) : Average values obtained on standardized specimens

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.

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.

PACKAGING

M 390 RESIN	M 10 HARDENER
1 x 4.5 kg	1 x 3.0 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 of 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.