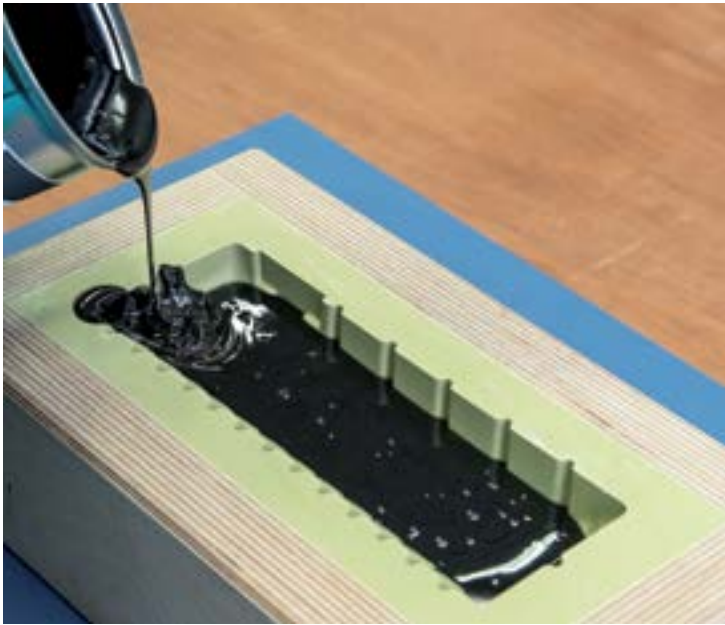


EP CASTING RESINS

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Typical advantages of EP resins are their good resistance to mechanical, chemical or thermal influence and easy processing due to low shrinkage and low moisture sensitivity.



Casting of foundry pattern out of EPO 5019

EP CASTING RESINS FOR TOOLING

EPO 5019:

- Black allrounder resin with good workability
- Offers good compressive strength and abrasion resistance (e. g. foundry patterns)

Biresin® G32:

- Green filled casting resin for backfilling
- With Biresin® F4 hardener for additional filler loading to reduce shrinkage

Biresin® G33:

- Black filled casting resin offers highest abrasion resistance and dimensional accuracy



Vacuum forming mould for blister packaging out of Biresin® G38

EP CASTING RESINS FOR TOOLING

	A	EPO 5019	Biresin® G32		Biresin® G33
	B	EPO 5019	Biresin® F4	Biresin® F2	Biresin® S15
Mixing ratio [g]	A	100	100		100
	B	10	7	17	6
Colour		black	green		black
Characteristics		multi-purpose with good workability, low shrinkage, good compressive strength and abrasion resistance	low viscosity, high filler loading for higher casting thickness		very low shrinkage, high abrasion resistance and compressive strength
Applications		production moulds, metal sheet forming tools, foundry patterns	backfilling in foundry pattern / mould making		abrasion resistant guiding rails and supports for engineering
Processing data (approx. values)					
Mixed viscosity [mPas]		19,000	1,700	2,600	6,000
Potlife [min]		100	70	180	45 – 60
Demoulding time [h]		24	24	48	16
Physical data (approx. values)					
Density [g/cm³]		2.25	1.6		1.9
Shore hardness		D 90	D 90	D 86	D 90
Compressive strength [MPa]		110	112	71	120
HDT [°C]		-	51	48	60 / 95*
T _c [°C]		74	-	-	-

* after appropriate treatment