

EPMOLD EP65

Extrudable Epoxy Paste

DESCRIPTION

EPMOLD EP65 is the extrudable epoxy paste used for design and styling models. Master models and mock-up for industries of wind energy, marine, composite and automobile.

PROPERTY

- Good behavior on vertical support up
- Good surface finish.
- to 30 mm
- Curing at low temperature • Easy to machine, low dust.

PHYSICAL PROPERTIES

Property	Test method	EPMOLD EP65Resin	EPMOLD EP65Hardener
Mixing ratio by weight		100	100
Aspect		Thixotropicpaste	Thixotropicpaste
Color		grey	white
Specificgravityat25°C (g/cm ³)	ASTMD4052	0.62-0.68g/cm3	0.62-0.68g/cm3
Specificgravityofcuredproductat25°C	ASTMD4052	0.65-0.70g/cm3	
Pot-life(500g)at25°C		50-70min	
Workabilityat25°C(30mmthickness)		1days	

Processing Condition

- The processing and material temperature should be between 20 - 25°C.
- On vertical support, it is 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. For thicker layers, it is recommended to apply the 2 nd layer after the first one has gelled.
- During pressing the dispensing nozzle must be maintained perpendicular to the surface on which the product is applied. Ensure overlap of ribbon.

Cause: Exotherm mostly depends on the type of machine and on the working parameters

such as :

- 1) room temperature
- 2) material temperature
- 3) applied thickness

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4) The mixture temperature (depending on the type of mixer: static or dynamic) and the speed of mixing and output

Mechanical and thermal property

	standard	Unit	EPMOLDEP65
Flexural strength	ISO178	MPa	15±2
Flexural modulus	ISO178	MPa	600±50
Compressive strength	ISO604	MPa	13±1
Tg(80°C8h)	DSC	°C	70±2
Shore D hardness	DINISO7619-1	Shore D	55±2
Coefficient of thermal expansion		10-6K-1	70±5

*Average values obtained on standard specimens/Hardening 24hr at 23°C +16 hr at 70°C

Package

EPMOLD EP65 RESIN	EPMOLDEP65HARDENER	INTERNAL DIAMETER OF DRUMS
28kg	28kg	360mm
120kg	120kg	570mm

Storing

At appropriate storage 18-25°C.

Occurring crystallization due to disadvantageous storage conditions can be made return by warming up the material at approx. 60° C. Opened containers should be closed immediately after use and be protected against moisture.

This material should be used up as soon as possible.

HANDLING PRECAUTIONS:

Process in a well-ventilated area. Avoid skin contact during machining and wear gloves, a mask, safety glasses and protective clothing. For further information, consult the material safety data sheet.

NOTE:

The data above is tested at specific conditions. Processing procedure and conditions might vary in practical applications, therefore it is recommended to carry out tests where necessary before using the product, and to ensure the product could meet the actual requirement. We at EPTEK guarantee that our products meet our highest quality management regulations.

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US customary-unit equivalents

US customary-unit equivalents are provided for convenience alongside the original SI test data. The original source values and test methods remain the controlling reference. Converted values are rounded.

Source value	US equivalent
30 mm	1.181 in
0.62-0.68 g/cm ³	38.7 to 42.5 lb/ft ³
0.65-0.70 g/cm ³	40.6 to 43.7 lb/ft ³
500 g	1.102 lb
20 - 25 °C	68 to 77 °F
15±2 MPa	2176 ± 290.1 psi
600±50 MPa	87023 ± 7252 psi
13±1 MPa	1885 ± 145 psi
80 °C	176 °F
70±2 °C	158 ± 3.6 °F
23 °C	73.4 °F
28 kg	61.7 lb
360 mm	14.2 in (1.181 ft)
120 kg	264.6 lb
570 mm	22.4 in (1.87 ft)
18-25 °C	64.4 to 77 °F