

EPMOLD EP72

Extrudable Epoxy Paste

DESCRIPTION

EPMOLD EP72 is a two components epoxy paste applied by professional extrusion machine. It is used to production of large dimensions tools, mock-ups & master plugs by extrusion process.

CHARACTERISTIC

- Mix ratio 1:1 by weight • Non-sagging on vertical up to 30mm
- Low exothermic • Easy machinable, low dust
- Good surface aspect

PHYSICAL PROPERTY

	Testmethod	EPMOLDEP72 RESIN	EPMOLDEP72 HARDENER
Mixratio by weight		100	100
Mixratio by volume		100	100
Aspect	visual	Thixotropic paste	Thixotropic paste
Color	visual	grey	white
Density at 25°C (g/cm ³)	ASTMD4052	Approx. 0.72	Approx. 0.72
Density at 25°C (g/cm ³)	ASTMD4052	Approx. 0.74	
Pot-life at 25°C (500g) (min)	Gel-timer	45-60	

HANDLING PROCEDURES

- It is recommended that the material temperature and the room temperature should be kept between 20-25 °C ;
- Processing only by means of standard two-components machines for applying pastes. Before processing make sure that the base construction is solid, stable and dust free.
- While applied on vertical surface, it is recommended to apply a thin layer with spatula to improve the adhesion on the supporting surface.
- The maximum thickness of one layer should not exceed 30mm , in case a thick layer is wanted, a second layer is applied after gelling of the first layer.
- The outlet must be perpendicular to the molding surface. Ensure that there is overlap between each row of material without leaving gaps.

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Exothermic mostly depends on type of machine and of the working parameters such as: 1) Extruded material temperature 2) Environmental temperature 3) Applied layer thickness 4) Insulating property of support

MECHANICAL AND THERMAL PROPERTY

Property	Standard	Unit	EPMOLDEP72
Flexuralstrength	ISO178	MPa	18±2
Flexuralmodulus	ISO178	MPa	800±50
Impactstrength	ISO179	KJ/m2	3±0.3
Compressionstrength	ISO604	MPa	15±1
Tg 23°C/7days 80°C/8hours	DSC	°C	50 70
Hardness 23°C/7days	DINSIO7619-1	ShoreD	58±2
Coefficientofthermalexpansion(CTE)		10-6K-1	68±2

(1) Averagevaluesobtainedonstandardizedspecimens/Hardening24hat23°C+ 8hat80°C

PACKAGE

EPMOLD EP72RESIN	EPMOLDEP72Hardener	INTERNALDIAMETERofDRUM
30kg	30kg	360mm
125kg	125kg	570mm

STORAGE

Shelf life of both parts is 12 months in a dry place and in their original unopened containers at a temperature between 15 to 25°C. Stored under low temperatures, it would be getting hard and not easy for mixing. It is recommended to warm it at 40-60°C until it is getting soft enough for mixing. The warming process will not affect the property of the final product. Any open can must be tightly closed right after use.

PRECAUTIONS

Normal health and safety precautions should be observed when handling these products : - ensure good ventilation
- wear gloves and safety glasses For further information, please consult the product safety data sheet.

WARRANTY INFORMATION-PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective and fully satisfactory for the intended end use.

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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
500 g	1.102 lb
20-25 °C	68 to 77 °F
18±2 MPa	2611 ± 290.1 psi
800±50 MPa	116030 ± 7252 psi
15±1 MPa	2176 ± 145 psi
23 °C	73.4 °F
80 °C	176 °F
30 kg	66.1 lb
360 mm	14.2 in (1.181 ft)
125 kg	275.6 lb
570 mm	22.4 in (1.87 ft)
15 to 25 °C	59 to 77 °F
40-60 °C	104 to 140 °F