

EPMOLD MP100

Epoxy Modeling Paste

APPLICATIONS

EPMOLD MP100 is the epoxy modeling paste mixed in planetary mixer and lay-up in 10-40 mm on a rough form by hand, and could be cured at room temperature. To achieve high temperature resistance, it must be post cured at elevated temperature. EPMOLD MP100 has longer pot-life and lower exothermic. It is used for the making of large model, tooling mold and light checking fixtures.

FEATURES

- Longer pot-life and lower exothermic • Light weight and easy milling
- Mixing by hand or planetary mixer • Could be applied to 40mm thickness

PHYSICAL PROPERTIES

	TestStandard	RESIN	HARDENER
Mixratio by weight		100	40
Aspect	visual	Paste	Paste
Color	visual	white	Light gray
Specific gravity at 25°C (g/cm ³)	ISO1675:1985	Approx.0.8	Approx.0.52
Specific gravity of cured product at 25°C	ISO2781:1996	0.65-0.68g/cm ³	
Pot-life at 25°C(500g)		50-70min	
Time to milling at 25°C		20-24hours	
Peak exothermic temperature and time to reach peak temperature at 25°C(500g)		83°C	
		86min	

MECHANICAL PROPERTIES

Property	Test standard	EPMOLD MP100
Hardness	ISO868:2003	Shore D 63-67
Flexural strength	ISO178	17-23MPa
Compressive strength	ISO604	30-35MPa
Glass Transition Temperature	ISO11357(DSC)	>100°C
Coefficient of linear thermal expansion	ISO11359-2	$45 \pm 5 \times 10^{-6} \text{ K}^{-1}$

(1): Average values obtained on standard specimens/ Hardening 4hrs at 40°C+ 2hrs at 80°C+ 4hrs at 100°C

PACKAGE

EPMOLDMP100RESIN	EPMOLDMP100 HARDENER
10kgx2	4kgx2

STORAGE AND SHELF LIFE

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.

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
10-40 mm	0.3937 to 1.575 in
40 mm	1.575 in
25 °C	77 °F
0.65-0.68 g/cm ³	40.6 to 42.5 lb/ft ³
500 g	1.102 lb
83 °C	181.4 °F
17-23 MPa	2466 to 3336 psi
30-35 MPa	4351 to 5076 psi
>100 °C	>212 °F
80 °C	176 °F
100 °C	212 °F
15 to 25 °C	59 to 77 °F
40-60 °C	104 to 140 °F