

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 surface aspect.
- Good behaviour on vertical support up to 30 mm
- Curing at low temperature
- Easy to machine, low dust.

PHYSICAL PROPERTY

Property	Test method	EPMOLD EP65 Resin	EPMOLD EP65 Hardener
Mixing ratio by weight		100	100
Aspect		Thixotropic paste	Thixotropic paste
Color		grey	white
Specific gravity at 25°C (g/cm ³)	ASTM D 4052	0.62-0.68 g/cm ³	0.62-0.68 g/cm ³
Specific gravity of cured product at 25°C	ASTM D 4052	0.65-0.70 g/cm ³	
Pot-life (500g) at 25°C		50-70 min	
Workability at 25°C (30mm thickness)		1 days	

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 2nd 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

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	EPMOLD EP65
Flexural strength	ISO 178	MPa	15±2
Flexural modulus	ISO 178	MPa	600±50
Compression strength	ISO 604	MPa	13±1
Tg(80°C8h)	DSC	°C	70±2
Shore D hardness	DIN SIO 7619-1	Shore D	55±2
Coefficient of thermal expansion		10 ⁻⁶ K ⁻¹	70±5

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

Package

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

Storing

At appropriate storage 18-25°C.

Occuring 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:

It should be processed at well-ventilated room; avoid to contact with skin during machining process; wear gloves, mask, safety glass and protective clothing.

For further information, please consult 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.