

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
- Low exothermic
- Good surface aspect
- Non-sagging on vertical up to 30mm
- Easy machinable, low dust

PHYSICAL PROPERTY

	Test method	EPMOLD EP72 RESIN	EPMOLD EP72 HARDENER
Mix ratio by weight		100	100
Mix ratio by volume		100	100
Aspect	visual	Thixotropic paste	Thixotropic paste
Color	visual	grey	white
Density at25℃ (g/cm ³)	ASTM D 4052	Approx. 0.72	Approx. 0.72
Density at 25℃ (g/cm ³)	ASTM D 4052	Approx. 0.74	
Pot-life at 25℃ (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℃;
- 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.

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	EPMOLD EP72
Flexural strength	ISO 178	MPa	18±2
Flexural modulus	ISO 178	MPa	800±50
Impact strength	ISO 179	KJ/m ²	3±0.3
Compression strength	ISO 604	MPa	15±1
Tg	23°C/7days 80°C/8hours	DSC	°C 50 70
Hardness	23°C/7days	DIN SIO 7619-1	Shore D 58±2
Coefficient of thermal expansion (CTE)		10 ⁻⁶ K ⁻¹	68±2

(1) Average values obtained on standardized specimens / Hardening 24 h at 23°C + 8h at 80°C

PACKAGE

EPMOLD EP72 RESIN	EPMOLD EP72 Hardener	INTERNAL DIAMETER of DRUM
30 kg	30 kg	360mm
125 kg	125 kg	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.