

EPMOLD MP50

Light Weight Epoxy Modeling Paste

DESCRIPTION

EPMOLD MP50 is the epoxy modeling paste mixed in planetary mixer and lay-up in 10-50 mm thickness on a rough form by hand, and could be cured at room temperature. EPMOLD MP50 has longer pot-life and lower exothermic. It is used for the making of large model, tooling mould and light checking fixtures.

PROPERTIES

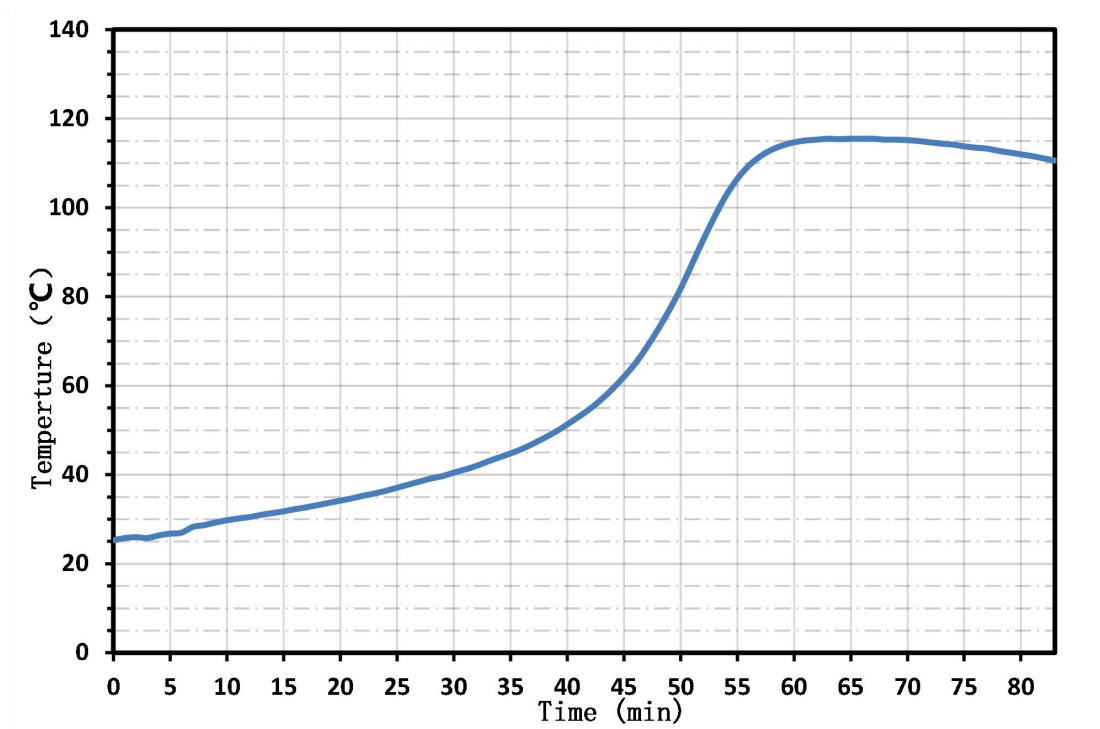
- Mixing ratio by weight 1:1
- Mixing by hand or planetary mixer
- Could be applied to 50mm thickness
- Longer pot-life and lower exothermic
- Light weight and easy milling
- Fine surface after milling

PHYSICAL PROPERTIES

	Test Standard	RESIN	HARDENER
Mix ratio by weight		100	100
Aspect	visual	Paste	Paste
Color	visual	white	pink
Specific gravity at 25°C (g/cm ³)	ISO 1675 : 1985	0.50-0.55	0.45-0.50
Specific gravity of cured product at 25°C	ISO 2781 :1996	0.45-0.50 g/cm ³	
Pot-life at 25°C (500)		40-70 min	
Time to milling at 25 °C		16-20 hours	
Shelf life		12 months	

Exothermic curve

Exothermic curve of MP50 at 25 °C (mixing 500g)



MECHANICAL PROPERTY

	Test Standard	EPMOLD MP50
Hardness	ISO 868 :2003	Shore D52-60
Flexural strength	ISO 178 :2001	10-20 MPa
Compression strength	ISO 604: 2002	15-25 MPa
Tg (curing at 25°C for 7 days)	ISO 11357:2002 (DSC)	>50°C
Tg (25°C 24h+40°C 16h)	ISO 11357:2002 (DSC)	>60°C
Coefficient of thermal expansion (CTE)	ISO 11359:1999	Approx.45*10 ⁻⁶ K ⁻¹
Maximal laying thickness		50 mm

(1) : Average values obtained on standard specimens / Hardening 16hours at 40°C

HANDLING PROCESS

Mix the two components by hand or with a planetary mixer according to the indicated ratio. When homogeneously apply the paste by pressing on the rough form. To make the adhesion of the paste easier on its support it is advised first to apply a thin coat by hand or with a tool. Let it cure for 16 hours to 20 hours at room temperature before machining.

PACKAGING

EPMOLD MP50 RESIN	EPMOLD MP50 HARDENER
1 × 8.0 kg	1 × 8.0 kg

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.