

EPMOLD MP65 Epoxy Repair Paste

APPLICATIONS

EPMOLD MP65 is a quick repair epoxy paste on surface of EP65 and EP72. MP65 has short Pot-life and fast curing, which is designed for the repair of extrudable paste of EP65/EP72.

PHYSICSL PROPERTY

	Test Standard	RESIN	HARDENER
Mix ratio by weight		100	100
Aspect	visual	Paste	Paste
Color	visual	Grey	White
Specific gravity at 25°C (g/cm ³)	ISO 1675 : 1985	Approx. 0.64	Approx. 0.76
Specific gravity of cured product at 25°C	ISO 2781 :1996	Approx. 0.70 g/cm ³	
Pot-life at 25°C (500g)		Approx. 20 min	
Time to milling at 25 °C		Approx. 4 hours	

MECHANICAL PROPERTY

Property	Test standard	EPMOLD MP65
Hardness	ISO 868 : 2003	Shore D 65±2
Flexural strength	ISO 178:2001	≥15 MPa
Compressive strength	ISO 604:2002	≥20 MPa
Glass Transition Temperature	ISO 11357 :2002(DSC)	≥55 °C
Coefficient of linear thermal expansion	ISO 11359-2:1999	45±5*10 ⁻⁶ K ⁻¹

(1) : Average values obtained on standard specimens / Hardening 10hrs at 40°C

working procedure

- 1) Weigh the resin and hardener in the correct proportions, mix them thoroughly by hand, and use it immediately. It is recommended to complete application within two-thirds of the working time to prevent the material from hardening and becoming unusable or losing its wetting properties, which would reduce the adhesion between cured material and the repair paste.

- 2) To ensure good adhesion of MP65 repair paste to the original EP65 surface, increase the notch depth and design a conical notch. This ensures that the repair paste MP65 retain a thickness of at least 4 mm after milling. Before laying new MP65 repair paste, apply a laminating resin to the original EP72 to enhance bonding between them.
- 3) After curing at room temperature for approximately 4 hours, machining can be performed.

PACKAGE

EPMOLD MP65 RESIN	EPMOLD MP65 HARDENER
7 kg x 3	7 kg x 3

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

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.