

## DESCRIPTION

- *Negatives and tools*
- *Checking fixtures or positioning models*
- *Designed for fillets and reinforcements*
- *Alternative to liquid lamination techniques for production of laminates*

## PROPERTIES

- *Low odour*
- *Very easy to mix and apply*
- *Low density*
- **Hardener without Toxic label**

PHYSICAL PROPERTIES				
Composition		RESIN	HARDENER	MIXED
Mix ratio by weight		100	14	
Aspect		fibrous paste	liquid	fibrous paste
Colour		grey	green	green
Specific gravity at 25 °C (g/cm <sup>3</sup> )	ISO 1675 : 1985	0.90	0.97	-
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	-	-	0.91
Pot life at 25 °C on 570 g (min)	-			80

## PROCESSING CONDITIONS

*Final properties are guaranty when the products are used and stored between + 18 to 25 °C; If the conditions are different, viscosity and reactivity will change.*

*Processing is carried out by hand for quantities below 1 kg. For larger quantities mix with a planetary mixer like a kneader fitted out with a pigtail agitator. Put the agitator in the tank. Then weigh quantities to be blended and place the whole under the kneader. 50 rev / min is the maximum speed recommended. When mixing at a higher speed product rises in temperature and incurs a higher shrinkage.*

**Remark:** *To obtain a surface finish coat (surface aspect, chemical resistance), apply EPOPAST 400 Resin / EPOPAST 401 Hardener on a gel coat. It is always recommended to apply the laminating paste on a tacky but not cured gel coat.*

*Advised gel coats : GC1 050 , GC1 080*

*Advised binder layer : EPOLAM 2015, EPOLAM 2017, EPOLAM 2020*

<b>MECHANICAL PROPERTIES at 23°C (1)</b>			
Hardness	ISO 868 : 2003	Shore D1 / D15	81/79
Flexural modulus	ISO 178 : 2001	MPa	4,600
Flexural strength	ISO 178 : 2001	MPa	50
Compressive strength	ISO 604 : 2002	MPa	57
<b>THERMAL AND SPECIFIC PROPERTIES (1)</b>			
Glass transition temperature (Tg)	ISO 11359-2 : 1999	°C	64
Coefficient of thermal expansion (CTE) (+10°C to +60°C)	ISO 11359-2 : 1999	10 <sup>-6</sup> K <sup>-1</sup>	22
Linear shrinkage (specimen 250x60x20mm)	-	mm/m	0.5
Maximal casting thickness	-	mm	40
Demoulding time at 25°C		hour	12
Complete hardening time at 25°C		day	5

(1) Average values obtained on standardized specimens / Hardening 16h at 60°C

## HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products :

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes

For further information, please consult the product safety data sheet.

## STORAGE CONDITIONS

Shelf life of both parts is 24 months in a dry place and in their original unopened containers at a temperature between 15 and 25°C

## PACKAGING

<b>EPOPAST 400 RESIN</b>	<b>EPOPAST 401 HARDENER</b>
10 kg	1.4 kg

## GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.