

## APPLICATIONS

*Production of casting molds and stamping tools for sheet metal forming foundry patterns, copy patterns, core boxes.*

## PROPERTIES

- High accuracy
- Low shrinkage
- High hardness
- Good compressive strength
- Good abrasion resistance

PHYSICAL PROPERTIES				
		RESIN	HARDENER	MIXING
Mixing ratio by weight		100	10	
Mixing ratio by volume at 25°C		100	27	
Aspect		visquous liquid	liquid	visquous liquid
Color		black	amber	black
Brookfield LVT viscosity at 25°C (mPa.s)	-	75,000	2,500	19,000
Density at 25°C	ISO 1675-75	2.70	0.98	-
Density of the cured product at 23°C	ISO 2781-88	-	-	2.25
Pot life at 25°C on 825 g (min.)	-			100

MECHANICAL PROPERTIES AT 23°C <sup>(1)</sup>			
Hardness	ISO 868-85	Shore D1	90
Compressive yield strength	ISO 604-97	MPa	110
Flexural strength	ISO 178-93	MPa	80
Flexural modulus of elasticity (E <sub>f</sub> )	ISO 178-93	MPa	6,000
Tensile strength	ISO 527-66	MPa	40
CHARPY shock resistance	ISO 179/D3	kJ/m <sup>2</sup>	9

## PROCESSING CONDITIONS

*Mix the resin before using and plasticate until a homogenous mixing is obtained. Then cast.*

## THERMAL (1) AND SPECIFIC PROPERTIES

Temperature of glass transition	T.M.A.-Mettler	°C	74
Coefficient of linear expansion (C <sub>L</sub> TE) [+10, +60]°C	T.M.A.-Mettler	10 <sup>-6</sup> K <sup>-1</sup>	50
Maximal casting thickness		mm	40
Linear shrinkage (250x60x40)	-	‰	1.7
Demolding time of the maximal thickness	-	hr	24
Complete hardening time	-	d	4

(1) : Average values obtained on standard specimens after a 16 hours at 50°C curing.

## STORAGE

Use the resin and hardener before **18 months** according to the manufacturing date.  
Expiration date indicated on the packaging.  
Any open can must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

## SAFETY 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.

## PACKAGING

**RESIN**  
6 x 1.500 kg  
1 x 15,000 kg

**HARDENER**  
6 x 0.15 kg  
1 x 1.50 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.