

DESCRIPTION

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

PROPERTIES

- *Low odour*
- *Low density*
- *Very easy to mix and apply*

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	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)	Gel Timer TECAM			120

MECHANICAL PROPERTIES at 23°C (1)			
Flexural modulus	ISO 178 :2001	MPa	4,400
Flexural strength	ISO 178 :2001	MPa	48
Compressive strength	ISO 604 :2002	MPa	49
Hardness	ISO 868 : 2003	Shore D1 / D15	81 / 79

(1) : Average values obtained on standard specimens / Hardening 16 hr at 60 °C

PROCESSING CONDITIONS

The mixing is carried out by hand for quantities below 1 kg and for larger quantities with a planetary mixer. Obtaining a homogeneous colour means the quality of the mixture obtained. The application on the support is hand made by particularly pressing in sharp and salient angles

Remark: *To obtain a surface coat (surface aspect, chemical resistance), apply EPOPAST 402 on a gel coat. It is always recommended to apply the laminating paste on a tacky but not cured gel coat.*

*Recommended gel coats : GC1 080, GC1 050
Recommended binder layer : EPOLAM 2010*

THERMAL AND SPECIFIC PROPERTIES (1)			
Glass transition temperature	ISO 11359 : 2002	°C	70
Maximal laminating thickness	-	mm	40
Coefficient of thermal expansion (CTE) (+10° to +60°C)	ISO 11359 : 1999	10 ⁻⁶ K ⁻¹	24
Demoulding time at 25°C	-	hours	24
Complete hardening time at 25°C	-	day	7

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

*Use before 24 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.).*

PACKAGING

RESIN 10 kg	HARDENER 1.4 kg
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GUARANTEE

The information of our technical data sheet are based on our present knowledge and the result of tests conducted 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 refuse any guarantee about 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 guarantee conditions are regulated by our general sale conditions.