



**ES-218
EPOXY SURFACE COAT
SERIES
WHITE, SANDABLE**



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DESCRIPTION

ES-218 is white, thixotropic, room temperature cure, sandable epoxy surface coat designed for duplication work. The popular handling properties of ES-218 produce accurate, detailed, chip resistant surface coat duplications in epoxy laminate fabrications. The versatility of this resin system, when used with ES-218-1 Hardener, also doubles as a chemical resistant epoxy coating used to fill surface texture on composite parts. Typically one application applied using brush or roller is all that is required to fill in the texture or weave in cloth fabric. NOTE: Do not topcoat directly over ES-218-1 composite coating applications. Sand ES-218-1 and use surface primer products as recommended by topcoat manufacturer. Typical applications include: masters, models, patterns, duplicating, engineering tooling, checking and drill fixtures and as a composite coating.

TYPICAL HANDLING CHARACTERISTICS @ 77°F (25°C)

	ES-218R/ES-218H	ES-218 R/ES-218-1H
Mix Ratio (parts by weight)	100R/14H	100R/16H
Mix Ratio (parts by volume)	5.9R:1H	5R:1H
Work Life (228-232 gram mass)	22 minutes	16 minutes
Mixed Viscosity	25,000cps	14,500cps
Mixed Density	1.39 g/cc	1.28 g/cc
Cure-to-Demold Time	8-12 hours	8-12 hours
Cure-to-Sanding Time	N/A	4-6 hours
Complete Cure	3-5 days	3-5 days
Mixed Color	White	White
Shelf Life Resin (in original unopened containers)	2 years	2 years
Shelf Life Hardener (in original unopened containers)	2 years	2 years

TYPICAL PHYSICAL PROPERTIES (Testing conducted on cured cast bar samples)

Tensile Strength	4,132psi (29MPa)	5,973psi (41MPa)
Tensile Modulus	868,900psi (5,991MPa)	1,146,000psi (7,901MPa)
Tensile Elongation	0.7%	0.6%
Flexural Strength	7,110psi (49MPa)	10,070psi (69MPa)
Flexural Modulus	414,800psi (2,860MPa)	573,800psi (3,956MPa)
Compressive Strength	7,987psi (55MPa)	13,350psi (92MPa)
Compressive Modulus	149,600psi (1,032MPa)	244,700psi (1,687MPa)
Izod Impact Strength	5.7 in-lb/ft	5.1 in-lb/ft
Shore Hardness	83 Shore D	84 Shore D
Heat Deflection Temperature @ 264 psi	114°F (46°C)	167°F (52°C)
Shrinkage	0.002 in/in	0.002 in/in
Moisture Absorption (ASTM D-570.88)	N/A	0.29%

ES-218 Series Tech/Revised 1/13/15
Supersedes 5/16/14

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