

## DESCRIPTION

- Large dimension tools / composite tooling and mocks-up production by extrusion process.
- Master Plugs.

## PROPERTIES

- Very good surface aspect.
- Good thermal resistance.
- Good behaviour on vertical support up to 30 mm

PHYSICAL PROPERTIES				
Composition		RESIN	HARDENER	MIXING
Mix ratio by weight		100	100	
Aspect		viscous paste	viscous paste	viscous paste
Colour		grey	white	grey
Viscosity at 25°C 0,9 s <sup>-1</sup> (Pa.s)	RM 100 Lamy	600	700	600
Specific gravity at 25°C (g/cm <sup>3</sup> )	ISO 1675 : 1985	0.80	0.80	-
Specific gravity of cured product at 23°C	ISO 2781 : 1996	-	-	0.82

THERMAL AND MECHANICAL PROPERTIES (1)				
Hardness	7 days at 23°C	ISO 868 : 2003	Shore D1	65
	16 hours at 70°C			67
Glass transition temperature (Tg)	7 days at 23°C	ISO 11359 : 1999	°C	50
	16 hours at 70°C			83
Coefficient of thermal expansion (CTE)	7 days at 23°C	ISO 11359 : 1999	10 <sup>-6</sup> .K <sup>-1</sup>	60
	16 hours at 70°C			
Tensile modulus		ISO 527 : 1993	MPa	1,100
Tensile strength		ISO 527 : 1993	MPa	14
Elongation at break		ISO 527 : 1993	%	2.8
Flexural modulus		ISO 178 : 2001	MPa	1,100
Flexural strength		ISO 178 : 2001	MPa	24

(1) : Average values obtained on standard specimens / Hardening 24 hr at 23°C + 16 hr at 70°C

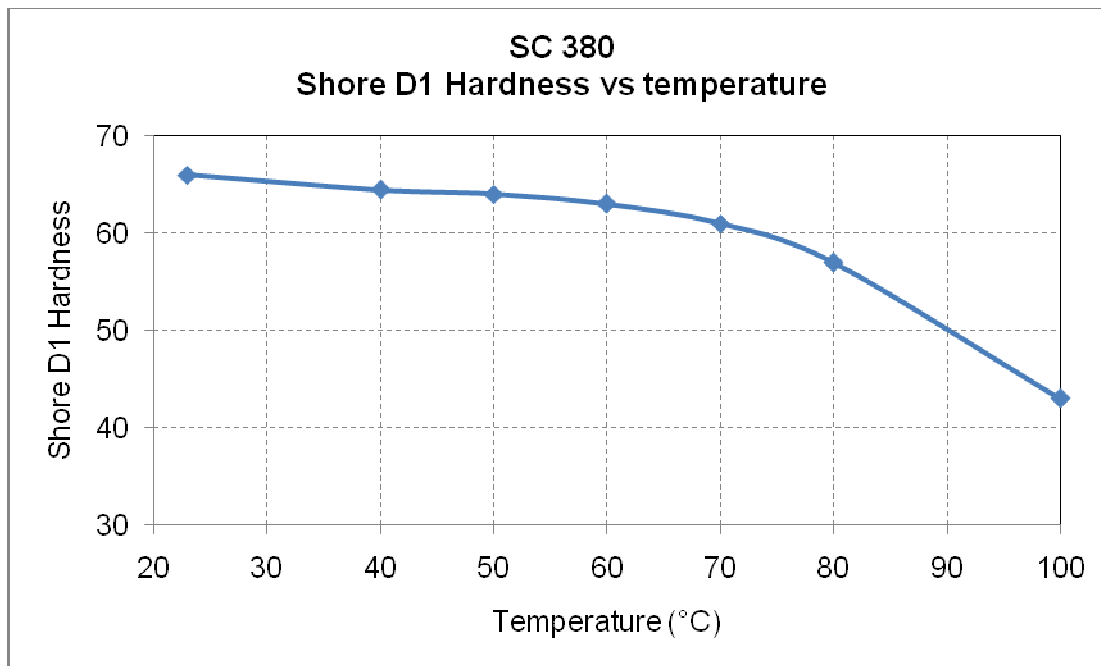
**During processing the dispensing nozzle must be maintained perpendicular to the surface on which the product is applied. Ensure overlap of ribbon.**

**CAUTION : Exotherm mostly depends of the type of machine and of the working parameters such as :**

- Room temperature.
- Insulating property of support.
- The mixture temperature (depending of the type of mixer: static or dynamic) and the speed of mixing and output.
- Applied thickness.

<b>EXOTHERMIC PEAK AND HARDENING TIME *</b>				
Thickness (mm)	Product temperature (°C)	Exothermic peak (hours /temperature)	Workability (hours)	Linear shrinkage (mm/m)
25	27	2.5 / 60	24	<1

\* Room temperature : 20/22 °C ; polystyrene support.



## PROCESSING CONDITIONS

On vertical support, it is sometimes recommended to apply a thin coat of product with a spatula; this will help to reinforce the bonding on the support.

For ceiling application, we recommend 30 mm of maximum thickness.

For dynamic mixing machine, please contact us for parameters : [composite@axson.fr](mailto:composite@axson.fr)

## HANDLING PRECAUTIONS

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

- ensure good ventilation,
- Wear gloves, safety glasses and protective clothes.

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

## STORAGE CONDITIONS

Use within 9 months of the manufacturing date. Expiry date indicated on the packaging.

## PACKAGING

RESIN	HARDENER	INTERNAL DIAMETER OF DRUMS
1 x 35.0 kg	1 x 35.0kg	360 mm
1 x 150.0 kg	1 x 150.0kg	570mm

## GUARANTEE

The information of our technical data sheet is 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.