

Epoxi-System E25FB

- Mould Covering Resin -



The Epoxy-Mould-System E25FB is a filled, **high-viscous**, 2 components combination of resin and hardener with a 25 minutes working time.

Properties and field of application:

- polishable and sandable surface
- brushable
- can be colored with our color pastes
- creation of fine layers in mould construction
- gelcoat
- basis for EP foams (use additive BEL11)

Product Properties:	
Mix Ratio (by weight)	100 parts resin / 50 parts hardener
Mixed Viscosity	high viscous
Working Time (pot life)	25 min (100g) at 20°C or 68°F
Demouldable after	24 h at 20°C or 68°F
Full Cure	7 days at 20°C or 68°F
Working Temperature	15 °C - 25 °C (64 – 77°F)
Applicable Thickness	0,2 mm – 2,0 mm
Consumption	1,1 kg / qm // 1 mm layer height

Product Specifications:	Wert	Unity	Test method
Viscosity Resin (25°C) Harz	thixotrop	CPS	PM.01.003
Viscosity Resin (25°C) Härter	300 - 600	CPS	PM.01.003

Data of Unreinforced Resin:	Wert	Unity	Test method
Tensile strength	50	N/mm ²	PM.01.004
Hardness shore D	80		PM.01.009
Density	1,1	g/cm ³	PM.01.002
Colour	cloudy		visuell
Tg max	65	°C	PM.01.011

Specifications after curing *recommended tempering (post-curing): 24h / RT // 15h / 60°C.

Safety Instructions:

The safety instructions are to be taken as being of greatest importance. Do not allow children to handle. Prevent inhalation of the fumes and contact with the bare skin. Wear approved protective gloves and goggles. If ingested do not eat, drink or smoke. During the hardening process, energy can be released in the form of heat, hence a cooling/heat exchanging should be provided in order to prevent hot spots. Only mix the components in the recommended proportions in accordance with the instructions.

Application Instructions:

We recommend tests be performed for trials and suitability for the particular type of application. The system should only be used in the optimum temperature conditions. The relative air humidity should not be above 70%. In respect of the safety instructions the epoxy and hardener should be mixed in a suitable mixing vessel in accordance with characteristics given in the data sheet. Deviating from the mixing recommendations can lead to incomplete hardening and through that loss of performance.

Ensure that the edges are well mixed using a stirring stick or a propeller type mixer. Localized signs of hardening indicate insufficient stirring and mixing of the components. Mixing of larger amounts (more than 100g) and higher temperatures (higher than 20°C) reduces the pot lifetime. Notably, if the temperature in the process goes above 40°C then it is not possible to continue further, as the process will lead to a loss of certain characteristics and properties. Temperature increases can be reduced by pouring the mixture into flat painting trays.

By the insertion of material layers these will be cut after the process and prepared accordingly with the separating agent provided, negative or positive forms rendered. After spreading the epoxy mixture over surface, the saturation and de-aeration with approved equipment (de-aeration roller, referred to "bubble buster" or "degasser roller"). Apply release agent (for instructions see corresponding data sheet). When the release agent is dried, bring on the mixed moulding resin of about 0.3 – 2mm. Use a brush or a putty knife. After gelling it is possible to bring on the next layer.

Cleaning Work Tools:

Unhardened product remains can be removed from tools by means of acetone or Thinner XB. Tools should be given a good airing after being cleaned with these solvents, in order to prevent the solvent from being retained until the tool is used again in a process.

Hardened remains can only be removed by mechanical means such as grinding tools. After tempering / post-curing, mould surfaces can be cleaned with thinner XB or acetone.

Storage:

Threaded container tops should be kept free of material remains. Do not exchange tops/lids. With optimal storage conditions, shelf-life should be beyond 12 months.

Disposal:

Do not dispose of through the sewerage system, on areas of open water, or in the soil. Non-hardened remains of the product should be disposed of as hazardous waste. The hardened product waste should be treated as building rubbish or household rubbish.

Further Information:

Further application information can be obtained from our Internet site, by selecting Product Info on the homepage. Please do not hesitate to contact us by telephone if you have further queries.

Information presented herein has been compiled from sources considered to be dependable and is accurate and reliable to the best of our knowledge and belief but is not guaranteed to be so. It is the user's responsibility to determine for himself the suitability of any material for a specific purpose and to adopt such safety precautions as may be necessary. We make no warranty as to the results to be obtained in using any material and, since conditions of use are not under our control, we must necessarily disclaim all liability with respect to the use of any material supplied by us.

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