

TECHNICAL DATA SHEET

PRODUCT: Epoxy Mould Making Putty

DESCRIPTION

Also known as *Laminating Paste* this easy to use epoxy-based mould making putty is designed to be used in combination with our Epoxy Tooling Gelcoat to provide a very quick, clean method of making problem free moulds for carbon fibre and fibreglass lamination.

After mixing both components together a smooth consistency is achieved which is easy to spread, particularly into tight corners or intricate shapes.

USES

Being an epoxy based mould making system, the putty is ideally suited for use when making epoxy based end products (like carbon fibre parts or epoxy matrix GRP/FRP). The putty itself already includes both the resin matrix (epoxy) and the reinforcement (finely chopped glass strands) so no additional reinforcement or resin are required.

Epoxy Mould Making Putty can also be used as a reinforcement for flexible silicone casting moulds.

PROPERTIES

| Property | Units | Putty | Hardener | Combined |
|-------------------------|-------------------|-----------------------------------|------------------|------------------------|
| Material | - | Epoxy Resin and Glass Fibre Paste | Formulated Amine | Glass Reinforced Epoxy |
| Appearance | - | Grey Paste | Blue Liquid | Blue/Grey Paste |
| Viscosity @25 °C | mPa.s. | Paste | 40 | Paste |
| Density | g/cm ³ | 0.81 | 0.82 | 0.83 |

POT LIFE & CURE

| Pot-Life, 1000g @ 25°C | Gelation Time @ 25°C | Demould Time @ 25°C |
|------------------------|----------------------|---------------------|
| 100mins | 8hrs | 24hrs |

CURED PROPERTIES

| Property | Method | Units | Value |
|--------------------------|-----------------------------|----------------------|-----------|
| Colour | | | Blue/Grey |
| Density 25°C | ASTM D 792 | g/ml | 0.82 |
| Hardness 25°C | ASTM D 2240 | Shore D/15 | 70-75 |
| Maximum Tg | ASTM D 3418 | °C | 70-80 |
| Flexural strength | ASTM D 790) | RT N/mm ² | 114 |
| Tensile strength | ASTM D 638 | RT N/mm ² | 50 |
| Shrinkage | 7 days at RT 500x20x25mm | % | 0.11 |

MIXING RATIO

100 p.b.w. Epoxy Mould Making Putty
8 p.b.w. Epoxy Mould Making Putty Hardener

MIXING

Protect your hands with Nitrile (vinyl) gloves. Mix the mould making putty with the

INSTRUCTIONS

correct amount of hardener (measured in parts by weight, no volume). Mix thoroughly until the blue die of the hardener is dispersed completely and evenly through the mixed putty and a smooth consistency is achieved. Mixing can be done by hand or by mechanical process (dough mixer).

LAMINATING

When Using as a Reinforcement for an Epoxy Tooling Gel Coat

(The most common application for the putty)

It is absolutely essential that the putty is applied to the epoxy tooling gel whilst the gel coat is at its 'B stage' of cure which is to say that it is still very tacky and a fingernail can be depressed into it, but not so uncured that it will be disturbed by the application of the putty.

If the tooling gel coat has been allowed to cure too far and is now effectively fully cured or does not possess any tack then either another thin application of tooling gel coat (mixed with its appropriate hardener) or a 'coupling coat' of epoxy laminating resin (again mixed with its appropriate hardener) should be applied to the hardened gel coat surface before proceeding immediately with the putty onto the wet gel coat or coupling coat.

Press the putty down firmly onto the partially cured gel coat to create an even layer of reinforcement of between 12 and 25mm. No additional reinforcement should be required. If stiffening battons or additional reinforcement are required, these should be laminated onto the back of the putty using epoxy resin once the putty has fully cured.

STORAGE

The putty and hardener should be stored in original, unopened containers between 15 and 25°C. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.

SHELF LIFE

If stored under the above conditions the resin and hardener will have a shelf life of 12 months, from the date of production.

Our technical advice, whether verbal, or in writing is given in good faith, but without warranty - this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by Easy Composites as to their suitability for the intended processes and uses.

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