

## APPLICATIONS

High temperature resistance, reinforcement for making molds, negatives, checking fixtures, jigs.

## PROPERTIES

- Easy to mix and apply
- High temperature resistance
- Good dimension stability

<b>PHYSICAL PROPERTIES</b>			
	B 4000 A Resin	B 4000 B Hardener	Mixing
Mix ratio by weight	100	100	
Mix ratio by volume at 25°C	100	100	
Aspect	Putty	Putty	Putty
Colour	Light grey	Grey	Grey
Specific gravity at 23°C	1.07	1.07	-
Specific gravity of cured product at 23°C	-	-	1.08
Pot life at 25°C on 1000 g (min)			55 - 65

## PROCESSING CONDITIONS

The mixing is carried out by hand for quantity below 3kg and with a planetary mixer for larger quantity. 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.

After 24 hours at 23°C (demoulding possible), post cure as follows:

4 hours at 70°C + 2 hours at 100°C + 2 hours at 120°C. Then cool down progressively.

<b>MECHANICAL PROPERTIES at 23°C <sup>(1)</sup></b>		
Hardness	Shore D	78
Tensile strength	MPa	18
Flexural strength	MPa	43
Compressive strength	MPa	53
Impact strength (IZOD)	J/m	28

<b>THERMAL AND SPECIFIC PROPERTIES <sup>(1)</sup></b>		
Heat deflection temperature	°C	200
Coefficient of thermal expansion (CTE) (+10 to +60)	$10^{-6} \cdot K^{-1}$	22
Demoulding time at 23°C	Hours	12 - 16
Maximum laminating thickness	mm	40

(1) : Average values obtained on standard specimens / Hardening 24 - 48 hours at 23°C + post cure

## 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

Shelf life is 12 months in a dry place and in original unopened containers at a temperature between 15 and 25° C. Any open can must be tightly closed under dry nitrogen blanket.

## PACKAGING

<b>B 4000 A</b> 1 × 10 kg	<b>B 4000 B</b> 1 × 10 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.*