

DESCRIPTION

Used by hand in 10 to 40 mm coat on a rough form. For style mock-ups, high dimension models, slight checking fixtures

PROPERTIES

- Mixing ratio by weight and volume : 1/1
- Mixing by hand or mechanical mixing
- Can be applied until 40 mm per coat
- Quick hardening in thin coat
- Adhesion on different supports such as wood, foam, machinable slabs, polystyrene, etc.
- Modifications and re-filling possible with SC 258 (support has to be sand first)

PHYSICAL PROPERTIES				
Composition		RESIN	HARDENER	MIXED
Mix ratio by weight		100	100	
Mix ratio by volume at 25°C		100	100	
Aspect		paste	paste	paste
Colour		white	light brown	light brown
Specific gravity at 25°C (g/cm ³)	ISO 1675 : 1985	0.51	0.54	-
Specific gravity of cured product at 23°C	ISO 2781 : 1996	-	-	0.53
Pot life at 25°C on 250 g (min)				55

MECHANICAL PROPERTIES at 23°C (1)			
Hardness	ISO 868 : 2003	Shore D15	55
Compressive strength at yield	ISO 604 : 2002	MPa	25

(1) : Average values obtained on standard specimens / Hardening 7 days at 23°C

PROCESSING

Mix the two components by hand or with a planetary mixer according to the indicated ratio. When homogenising apply the paste by pressing on the rough form. To make the adhesion of the paste easier on its support it is advised first to apply a thin coat by hand or with a tool. The PROCOL 2 primer allows obtaining the same result. Lets cure 12 hours to 16 hours at room temperature before machining. To improve the finishing it is possible to smooth the surface with water or alcohol.

THERMAL AND SPECIFIC PROPERTIES (1)

Glass transition temperature (tg)	ISO 11359 : 2002	°C	53
Coefficient of thermal expansion (CTE) (+10°C à +40°C)	ISO 11359: 1999	10 ⁻⁶ K ⁻¹	46
Maximal casting thickness	-	mm	40
Hardening time before machining		hr	12 - 18
Complete hardening time at 23°C		hr	about 48

HANDLING PRECAUTIONS

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

- . ensure good ventilation
- . wear gloves and safety glasses

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

STORAGE CONDITIONS

Shelf life of both parts is 12 months in a dry place and in their original unopened containers at a temperature between 15 to 25°C.

Any open can must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

PACKAGING

RESIN 1 x 5 kg 1 x 10 kg	HARDENER 1 x 5 kg 1 x 10 kg
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GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories 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 guarantee the conformity of their products with their specifications but cannot guarantee 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 responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications