

**Technical Data Sheet**  
**578A Resin /578B Hardener**  
**Tooling Board Adhesive System**

Contact the ebalta UK technical team for further information on this material

The CPD 578 adhesive system is designed for use with blue intermediate temperature epoxy tooling boards. The resin system is carefully matched to the properties of those boards and exhibits toughened properties, as well as superior bonding properties.

Processing Data					
Property	Test Method	Value	SI Units	Value	Imp Units
Colour	Visual	Blue	-	-	-
Mixing ratio	-	100A : 20B	By weight	-	-
Mixed viscosity at 25°C	ASTM D2196	10,000	cP	-	-
Pot life at 25°C, 150g mass	-	75	minutes	-	-
Thin film gel time at 25°C	-	4	hours	-	-

Physical Data					
Property	Test Method	Value	SI Units	Value	Imp Units
Density, cured	ASTM D792	0.65	g/cm <sup>3</sup>	-	-
Coefficient of thermal expansion	TMA	-	-	1.8 x10 <sup>-5</sup>	In/in/ °F
Shore hardness	ASTM D2240	68	Shore D	68	Shore D



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tooling resins

blocks

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## Processing Instructions

### Application and Mixing:

Boards to be repaired must be clean and free of contaminants. Part A contains fillers that are lighter than the resin. The lightweight fillers may rise to the surface of the resin. These ingredients must be thoroughly mixed before combining part A with part B. The use of a mechanical mixer is desirable. Once part A has been completely mixed add part B and thoroughly mix again. Always use clean dry tools for mixing and applying. Mix according to the mix ratio stated for the specific product. Material temperatures should not be below 65°F when mixing.

### Cure Increments:

High temperature epoxy systems require an elevated temperature post cure to enable the resin and hardener to develop their full physical and temperature properties. Select one of the following cure schedules depending upon the physical properties of the master and the desired physical properties of the final tool. Please contact technical service if you find it necessary to have a different post cure schedule.

Cure Schedule	Option I	Option II
24 hrs at 77°F (25°C)	X (S)	X (S)
7 days at 77°F (25°C)	X (U)	
4 hrs at 150°F (66°C)		X (S)
1 hrs at 200°F (93°C)		X (U)
1 hrs at 250°F (121°C)		X (U)

S = Supported U = Unsupported

## In General

### Tool, mould and/or pattern preparation:

Wood structures should be sealed. Gypsum moulds should be dried to remove free moisture and preferably sealed with a PFP process or appropriate sealer. All non-porous tools, moulds or patterns should be treated with release or parting agents which can withstand the temperature that the part will be cured at while remaining in a supported position.

## Storage

Store at 60-100°F in a dry place. After use, tightly reseal. (This product may crystallise during storage. If crystallised, vent container and heat to 125-145°F until crystals dissolve. Stir well after product has been liquefied.) Always use clean dry tools for mixing and applying. Mix according to the mix ratio stated for the specific product as listed on the front page. Mix together thoroughly and use immediately. Material temperatures should not be below 65°F when mixing.

## Safety Measures

Work in well ventilated areas using gloves, eye protection and clothing protection. Avoid contact to the skin and eyes. Avoid clothing contamination. Wash thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult the Material Safety Data Sheets for complete precautions with this product.

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