

Basis	<b>machinable epoxy lay-up paste</b>
Resin	<b>P 25 resin</b>
Hardener	<b>P 25 hardener</b>
Colour	red brown

### Applications

- Close to final shape models for boat building
- Close to final shape models in the wind energy industry
- Close to final shape models in the aircraft industry
- Close to final shape models in the automotive industry

### Properties

- jointless surface
- 15 - 30 mm layer possible in one step
- low exothermic
- dimensionally stable
- very well workable
- dense surface
- fine structure
- no sagging at vertical surfaces

### Processing data

Product		Mixture P 25 /resin+hardener	Resin P 25 resin	Hardener P 25 hardener
Colour		red brown	brown	beige
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>100</b>
Viscosity at 25°C	mPas	thixotrope	thixotrope	thixotrope
Density at 20°C	g / cm <sup>3</sup>	0,5 ± 0,03	0,5 ± 0,03	0,5 ± 0,03
Pot life 500 g / 20°C	min.	45 - 60	-	-
workable at RT after	-	30 - 36	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	12 ± 1
Flexural strength at breakage	EN ISO 178	%	4 ± 0,2
Flexural modulus	EN ISO 178	MPa	550 ± 80
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	3 ± 0,2
Compressive strength	EN ISO 604	MPa	9 ± 0,5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	50 ± 2
Glass transition temperature TG	methode DSC	°C	72 ± 3
Shore hardness	DIN 53505	Shore D	45 ± 2
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	approx. 100
Linear shrinkage	internal	%	approx. 0,15

### Sales units (packages)

Units	resin	P 25 resin	20,000 kg / 100,000 kg
	hardener	P 25 hardener	20,000 kg / 100,000 kg

## Processing instructions

Although the good miscibility the mixing of the resin paste with the hardener should be made in a mechanical kneader, until a uniform consistency is resulted. Smaller quantities of 2-3 kg can be mixed by hand. This is very easy , when both components are kneaded together like a dough.

The mixture of both components does not stick to the hands and is therefore very good mouldable relating to design. Mixing container, stirrer and hands can be easily cleaned with water. For a good adhesion on subsoil, e.g. wood or Polyurethane boards we recommend to apply first the coupling paste KP 6/TGL or a general purpose resin.

A higher heat resistance of 75°C can be reached after a post-curing of 8 h at 80°C.

## In General

The paste is a good mouldable two-component-epoxy model paste, which can be easily processed without damaging the mould and without considerable dust after curing at room temperature. Due to its dense structure, modelling properties and the smooth consistency it is very suitable for the production of master models.

The dense structure of the finish does not absorb moisture, which makes the master models dimensionally stable.

## Storing

At appropriate storage 18-25°C.

Occuring crystallization due to disadvantageous storage conditions can be made return by warming up the material at approx. 60° C.

Opened containers should be closed immediately after use and be protected against moisture. This material should be used up as soon as possible.

Shelf life is indicated on the labels

## Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

## Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

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