

**IMT-CE04-3L
EPOXY CASTING MOLD**

MIX RATIO

2 parts by weight of Part A Epoxy Resin
1 part by weight of Part B Epoxy Hardener
5 parts by weight of Part C Aggregate

PRODUCT DESCRIPTION

IMT-CE04-3L is an inorganic filler loaded epoxy casting mold material designed for high temperature tooling applications such as vacuum & thermo forming tools. This epoxy casting mold is a three components, high flow, 100% solid, solvent free system formulated to exhibit high early strength and excellent hard wearing property.

The low mixed viscosity of these three components epoxy system ensures very accurate reproduction of even the finest surface detail.

SHELF LIFE & STORAGE

One year in tightly closed pail & container. Part B epoxy hardener must be tightly sealed when not in use and stored in shelter, dry condition.

TYPICAL PROPERTIES

| | |
|---|----------------|
| Color (Premixed) | Olive |
| Consistency (Premixed) | Flowable Paste |
| Specific Gravity (Premixed) | 2.11 |
| Viscosity of Premixed @20rpm, 25°C | ≤ 7,500cPs |
| Glass Transition Temperature | ≥ 80°C |
| Shore D Hardness | D85 |

ADVANTAGES

- High early strength
- Long working time
- Hard wearing
- Ease in drilling
- High flow
- Overnight RT cure
- Minimal shrinkage
- Prepacked, ready to mix

USES

- Vacuum & thermo forming male tools
- Platen press tools
- Any cast mold

PACKAGING

80Kg set consists of the followings:
Part A Epoxy Resin = 20Kg per 20L PP pail
Part B Epoxy Hardener = 10Kg per 10L PP pail
Part C Aggregate = 2 x 25Kg Bag

POT LIFE & CURE

Pot life is 30 to 45 mins after mixing Part A & B homogenously.

Demold time is 6 to 8 hours and recommended cure time is at least 24 hours at room temperature.

Post cure at 80 to 100°C for an hour after room temperature cure overnight for optimum mechanical strength (optional).

APPLICATION GUIDELINES

SURFACE PREPARATION: All surfaces in contact with epoxy casting mold must be free of oil, grease and other contaminants. Mold surfaces must be clean, sound, dry and smooth to ensure a good molding.

MIXING: Pour Part B Hardener into Part A Resin. Mix 1 to 2 minutes thoroughly by hand with a paddle or slow speed drill with grout stirrer to avoid air entrapment. Keep mixer running and add Part C Aggregate slowly. Continue mixing for a few minutes until obtaining a lump free homogeneous mix.

POURING: Pour premixed epoxy into place from one side only to ensure complete filling without air entrapment.

On area of fine surface detail we recommend painting an amount of premixed epoxy directly onto the detailed area so that the epoxy is in intimate contact with the mold without trapped air before pouring the bulk of premixed epoxy around it.

FIRST AID: In case of skin contact, wash immediately with plenty of soap and water.

CAUTIONS: Please refer to product SDS for proper handling, storage, health, safety and environmental recommendations.

IN-MAT TECHNOLOGIES (S) PTE LTD
623 ALJUNIED ROAD, #05-09, ALJUNIED INDUSTRIAL COMPLEX
SINGAPORE 389835
TEL / WHATSAPP / WECHAT : +65-8688 8711
E-Mail: sales@inmat-tech.com
Website: www.inmat-tech.com

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