

Product Bulletin

CASS POLYMERS

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EC-426
EPOXY DIE SURFACE CAST
ABRASION RESISTANT
ROOM TEMP

0302

DESCRIPTION

EC-426 ABRASION RESISTANT DIE SURFACE CASTING RESIN is a room temperature cure system developed for the casting of hard surface tools and dies. EC-426 has excellent air release and high physical properties and is ideal for face casting of Kirksite and re-facing other types of substrates. EC-426 will produce detailed, durable, void free and dimensionally accurate surface duplications. EC-426 can be cast up to 3/4" without excessive exotherm or shrinkage. When face casting kirksite a thickness of 1/4" to 3/8" is recommended for ultimate tool life. EC-426 may be cast thicker than 3/8" with the addition of bulk filler.

USES

Sheet Metal Stamping Dies
Draw and Stretch Dies

Hammer Forms
Router and Trim Fixtures

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio: (parts by weight) 100R/16H
(parts by volume) 3.6R/1H
Density (Mixed) 13.95 lbs/gal
..... 0.055 lbs/cu in
Specific Gravity 1.54 gms/cc
Mixed Viscosity 10,000-15,000 cps
Work Life (348 gram mass) 2 hours, 30 minutes
Demold Time 18-24 hours
Complete Cure 7 days
Color Resin - Black Hardener - Amber Mixed - Black
Shelf Life (Storage at ambient temperature) 1 Year

PHYSICAL PROPERTIES

CAST BAR:

Ultimate Tensile Strength 6,304 psi
Tensile Modulus 0.58×10^6 psi
Ultimate Flexural Strength 10,930 psi
Flexural Modulus 0.41×10^6 psi
Ultimate Compressive Strength 10,170 psi
Impact Strength (Notched IZOD) 7.12 in lbs
Hardness 88-92 Shore D
Tensile Elongation 1.85 %

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