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MODELLING EPOXY PE 663 + HARDENER IPE 724 BLU

DESCRIPTION:

Epoxy paste with glass fibres and light filler, malleable. Good dimensional stability.

APPLICATION:

Foundry patterns, negatives, tools.

PROCESSING:

Manual or mechanical mixing (recommended), using MI1 mixing machine. Roller or manual application to calibrated thickness. Curing at room temperature.

SYSTEM SPECIFICATIONS:

Resin PE 663

- | | |
|---------------------|----------------|
| ✓ Viscosity at 25°C | paste |
| ✓ Colour | grey |
| ✓ Density at 25°C | 1.15-1.25 g/ml |

Harder IPE 724 blu

- | | |
|---------------------|----------------|
| ✓ Viscosity at 25°C | 180-250 mPas |
| ✓ Colour | blue |
| ✓ Density at 25°C | 0.99-1.01 g/ml |

CHARACTERISTICS OF THE TYPICAL SYSTEM:

Processing data:

- | | |
|---|----------|
| ✓ Mixing ratio by weight | 100:5 |
| ✓ Processing time (500 ml, 80 mm, 25°C) | 2030 min |
| ✓ Gelling time at 25°C (15ml; 5mm) | 3-4 u |
| ✓ Exothermic peak (500 ml, 80 mm, 25°C) | 65-7°C0 |
| ✓ Curing (15 ml, 5 mm, 25°C) | 10-12 u |
| ✓ Post-curing at 60°C (optional) | 12-15 u |
| ✓ Maximum recommended thickness | 15 mm |

TYPICALLY CURED SYSTEM PROPERTIES:

Properties determined on cured samples: 24 h KT (room temperature) + 15 h 60°C

- | | |
|---|------------------|
| ✓ Colour | grey-green |
| ✓ Machinability of tools | poor |
| ✓ Density at 25°C | 1.15-1.25 g/ml |
| ✓ Hardness at 25°C | 82-84 shore D/15 |
| ✓ Glass transition | 56-62°C |
| ✓ Maximum recommended operating temperature | 55°C |

INSTRUCTIONS:

Prepare the surface of the mould by applying detergent 2 or 3 times (refer to the data sheet for the release agent). Mix the two components (resin and hardener), if necessary pre-filled, in the correct mixing ratio to avoid air entrapment until a homogeneous mixture is obtained, and then pour.

CURING / POST-TREATMENT:

Posthardening gives the hardened product the best mechanical and chemical properties and is therefore always recommended; it becomes necessary when the product is working at temperature.

To harden the product, increase the temperature gradually by 10°C every hour until the temperature indicated in the table is reached. Maintain the temperature for the time indicated and then allow to cool slowly. In case



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of large artefacts, the temperature increase should be slower and more gradual to avoid thermal imbalances between the outer surface and the core. For thin layer applications and composites, post-cure on mould.

BEWARE:

Epoxy paste PE 663 can be stored for more than one year, while hardener for two years in the original sealed container in a cool and dry place. Hardeners are very moisture sensitive.
Refer to the product data sheet for health and safety.