



ASSYST sprl / A.S.O.W. sprl
Hellegatstraat 13a - 2590 Berlaar - Belgium
Tel: +32 495 50 61 14 / +32 496 83 70 27
Website: www.assyst.org / www.artsuppliesonweb.com
Email: ao@assyst.org / vera.opsommer@assyst.org

KNEADABLE EPOXY PE 640 NA/PE640 A + PE 640 B

DESCRIPTION:

Two-component, low-density epoxy system filled with non-abrasive fillers that allow excellent tool ability. Medium working time, with low exothermic peak. Wait at least 12 hours before continuing processing.

APPLICATION:

Models and stylish models, even large ones.

PROCESSING:

Mix manually or mechanically. Curing at room temperature.

SYSTEM SPECIFICATIONS:

Resin PE 640 NA / PE 640 A

- | | |
|---------------------|----------------|
| ✓ Viscosity at 25°C | paste |
| ✓ Colour | white / brown |
| ✓ Density at 25°C | 0.50-0.55 g/ml |

Harder PE 640 B

- | | |
|---------------------|-----------|
| ✓ Viscosity at 25°C | paste |
| ✓ Colour | beige |
| ✓ Density at 25°C | 0.60 g/ml |

CHARACTERISTICS OF THE TYPICAL SYSTEM:

Processing data:

- | | |
|---|-----------|
| ✓ Mixing ratio by weight | 100:100 |
| ✓ Processing time at 25°C (500ml) | 20-25 min |
| ✓ Processing time with mixer (4 kg, 25°C) | 15-20 min |
| ✓ Gelling time at 25°C (15ml; 5mm) | 2-3 u |
| ✓ Exothermic peak at 25°C (500 ml) | 70-80°C |
| ✓ Curing (15 ml, 5 mm, 25°C) | 15-20 u |
| ✓ Post-curing at 60°C (optional) | 10-15 u |
| ✓ Maximum recommended thickness | 30-40 mm |

TYPICALLY CURED SYSTEM PROPERTIES:

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

- | | |
|---|----------------------|
| ✓ Colour | Straw yellow / brown |
| ✓ Tool machinability | Excellent |
| ✓ Density at 25°C | 0.52-0.57 g/ml |
| ✓ Hardness at 25°C | 70-75 shore D/15 |
| ✓ Glass transition | 75 - 85°C |
| ✓ Maximum recommended operating temperature | 70°C |

INSTRUCTIONS:

Check the components and, if necessary, homogenise them before use.

Mix the two components (resin and hardener) in the correct amounts, avoiding air, until a homogeneous mass is obtained, and then process.

Prepare the surface of the mould with wax-based release agent (see manufacturer's instructions).



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CURING / POST-TREATMENT:

Post hardening 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 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 mask.

BEWARE:

Epoxy resins and hardeners can be stored for more than one year in the original closed packaging in a cool and dry place. Hardeners are moisture-sensitive.

Refer to the safety data sheet for health and safety.