

ANCHOR SEAL

8/20/09

Product # SY6018-18

Epoxy 2-Component

Features:

- Aluminum filled
- Easily machined
- Thermally conductive
- Low shrinkage
- Tough-Impact resistant

Applications:

- Epoxy faced tools
- High strength molds
- Tracing masters
- Duplicator forms
- Prototype parts

Mixing & Curing Instructions:

Mix Ratio: 100 Parts A to 11 Parts B by wt.

Cure Schedule: 24 hours @ 77°F, depends on casting size.
Post cure for maximum properties.
4 hrs. @ 160-175°F or
3 hrs. @ 185-212°F or
2 hrs. @ 225-250°F

Properties- Uncured @ 77°F:

Pot Life, 200 gram mass, hours.....	>4
Viscosity, CPS	Part A 250,000..... Part B 75
Viscosity, A:B mixed, CPS.....	10,000
Specific Gravity, Grams/CC.....	Part A 1.75-1.80 Part B ...0.95
Shelf life, factory sealed cans, min. years.....	1

Physical Properties- Cured @77°F:

Color.....	gray
Durometer (Hardness) ASTM D 2240, Shore D.....	90
Specific Gravity, grams/cc.....	1.65-1.71
Density, pounds/cubic inch.....	0.061
Tensile Strength, ASTM D 638, PSI.....	8,000
Cure Shrinkage, ASTM D 2566, in/in.....	0.0015
Compressive Strength, ASTM D 695, PSI	16,000
Flexural Strength, ASTM D 790, PSI.....	10,000
Service Temperature, (300°F), °C.....	150
Coeff. of Thermal Expansion, in/in/°Cx10 ⁻⁵	5.5
Thermal Conductivity, BTU/hr/ft ² /°F/ft.....	1.12

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IMPORTANT INFORMATION: READ BEFORE USING PRODUCT

Directions for Use: *Stir contents prior to use.* Because of differences in density, *pigments and fillers, when present, may separate* from the liquid components during storage. To insure product homogeneity and maximum performance, check the containers for settling. If settling is evident, loosen any settled pigments from the bottom of the container with a screwdriver or similar object. Hand-stir the contents with a metal mixing stick, or power mix at slow speed with a drill press and dispersion blade. *This product might crystallize* in its shipping container during storage. If it appears hard, or has a granular consistency, or if it is normally clear but appears cloudy, warm it thoroughly at 120°F to reconstitute. Remix the product and allow it to cool back to room temperature before using.

Measuring: Carefully weigh Part A and Part B components with an accurate scale. If measuring volumetrically, use precise metering pumps, graduated/pre-marked containers or pre-measured kits. Place the correct proportions of Part A and Part B into a straight-sided container. **Note:** Altering the mix ratio from what is specified on the data sheet is not recommended. Cured properties could be adversely affected.

Mixing: Mix thoroughly with a flat-ended stick or a slow speed drill press with a dispersion blade. Scrape the sides and bottom occasionally to assure a thorough blend. Do not whip excessive air into the mixture. To guard against partially cured sections, never apply material *scraped* from the sides of the original mixing container. For best results, transfer the mixture into a second container and stir it again before application. This will help insure consistent properties and maximum performance.

De-airing: Low viscosity resins will de-air naturally on their own. Some applications require a totally air-free product. If a vacuum pump and chamber are used, evacuate the material for 5-15 minutes @ 28-29 inches of mercury. Allow sufficient space above the liquid for expansion, about four times the liquid volume. Resins slightly warmed are thinner and will de-air faster. Also, the use of an air-out additive will lower the surface tension and hasten air release. **Caution:** Warming a catalyzed mixture will shorten the pot life and decrease gel time.

Surface preparation: To obtain maximum adhesion, the surfaces to be bonded must be free of grease, oil, mold-release, water and dust. Thoroughly clean all surfaces with a strong cleaner/degreaser. Roughen surfaces by grit blasting, grinding or with a sanding disk. Remove all dust and grit prior to application of the product. Consult the factory or your mold release supplier for **mold release** recommendations.

Handling Cautions: Review the Material Safety Data Sheet before using this product.

Warning: For Industrial Use Only. All chemicals must be handled with care. Avoid breathing fumes, mists and dust, they could cause respiratory discomfort or damage. Work in a well-ventilated area. Avoid all contact with the skin. If contact occurs, wash affected area thoroughly with soap and water. Repeated skin contact may cause dermatitis in susceptible individuals. Wear protective clothing and gloves. Severe irritation will result if this product is splashed into the eyes. Always wear eye protection. If eye contact occurs, flood eyes with clear water for 15 minutes and immediately seek medical attention. Always maintain good industrial hygiene when using this product.

Notice To Buyer: All information contained herein is believed to be accurate. However, it is the responsibility of the end user to determine the suitability of this product in his particular application. As the use of this product by others is beyond our control no warranty whether expressed or implied is made by Anchor-Seal, Inc. or any of its representatives as to this product's merchantability or fitness for a particular purpose. Under no circumstances shall Anchor-Seal, Inc. be liable for incidental, consequential or other damages for any reason. The sole liability of Anchor-Seal, Inc. shall be to refund the purchase price or replace materials deemed to be defective by us.