

### DESCRIPTION

Models, and mocks-up production by extrusion process.

### PROPERTIES

- Very good surface aspect.
- Good behaviour on vertical support up to 30 mm.
- High thermal resistance.

PHYSICAL PROPERTIES				
Composition		RESIN	HARDENER	MIXING
Mix ratio by weight		100	100	
Mix ratio by volume at 25 °C		100	100	
Aspect		viscous paste	viscous paste	viscous paste
Colour		grey	white	grey
Viscosity at 25 °C 1 s <sup>-1</sup> (Pa.s)	CVO Bohlin	900	700	700
Specific gravity at 25 °C (g/cm <sup>3</sup> )	ISO 1675 : 1985	0.60	0.62	-
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	-	-	0.63

MECHANICAL AND THERMAL PROPERTIES				
Hardness	7 days at 23 °C 24 hours at 60 °C	ISO 868 : 2003	Shore D1/ D15	52/48 53/49
Glass transition temperature (Tg)	7 days at 23 °C 24 hours at 60 °C	ISO 11359 : 2002	°C	45 83
Coefficient of thermal expansion	24 hours at 60 °C	ISO 11359 : 1999	10 <sup>-6</sup> .K <sup>-1</sup>	70

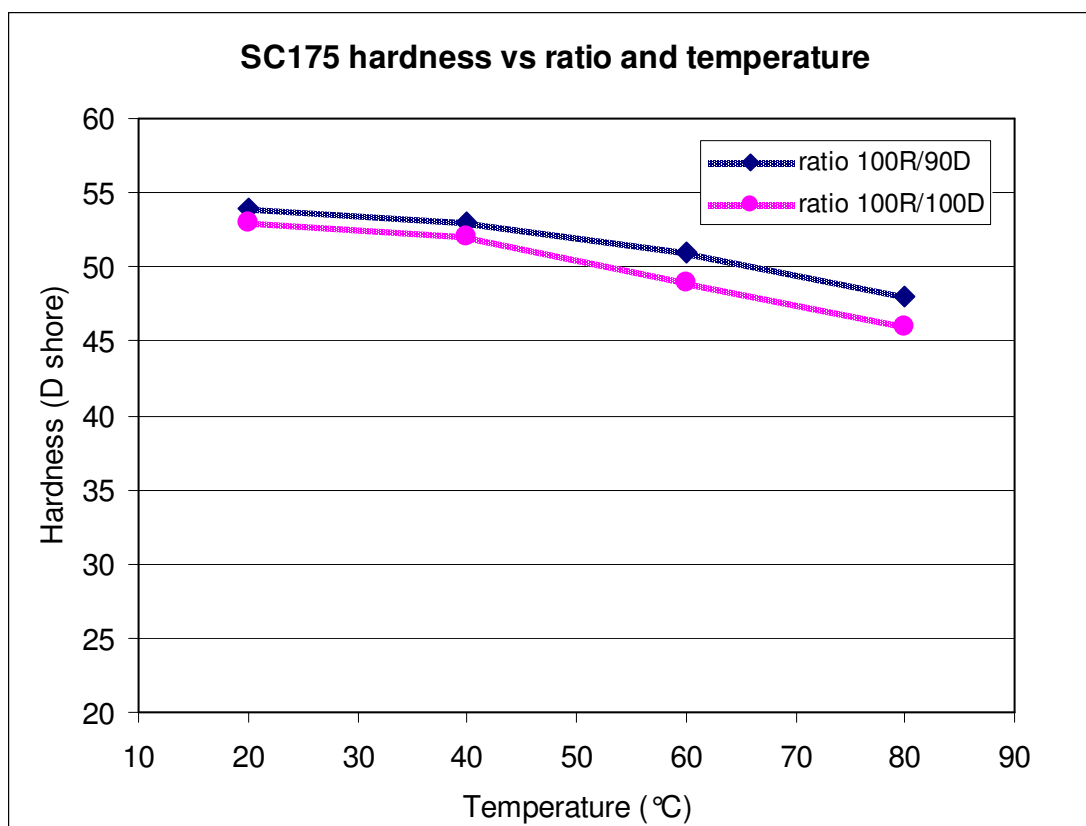
**During processing the dispensing nozzle must be maintained perpendicular to the surface on which the product is applied. Ensure overlap of ribbon.**

**CAUTION : Exotherm mostly depends of the type of machine and of the working parameters such as :**

- Room temperature.
- Insulating property of support.
- The mixture temperature (depending of the type of mixer: static or dynamic) and the speed of mixing and output (chart on page 3).
- Applied thickness.

EXOTHERMIC PEAK AND HARDENING TIME *				
Thickness (mm)	Product temperature (°C)	Exothermic peak (hours)	Exothermic peak (°C)	Workability (hours)
30	25	3	70	24
30	20	3,5	50	48

\*Room temperature: 20/22 °C; polystyrene support.



## PROCESSING CONDITIONS

On vertical support, it is recommended to apply a thin coat of product with a spatula; this will help to reinforce the bonding on the support.

For ceiling application, we recommend 30 mm of maximum thickness.

## HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products :

- ensure good ventilation,
- Wear gloves, safety glasses and protective clothes.

For further information, please consult the product safety data sheet.

### STORAGE CONDITIONS

Use within 9 months of the manufacturing date. Expiry date indicated on the packaging.

### PACKAGING

RESIN	HARDENER	INTERNAL DIAMETER OF DRUMS
1 x 25.0 kg	1 x 25.0kg	360 mm
1 x 114.0 kg	1 x 114.0kg	570mm




### GUARANTEE





The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON refuse any guarantee about the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

Influence of parameters on the quality of the mixed paste (test with dynamic mixer machine)

Débit/V. rotation	1000 tr/mn	1500 tr/mn	2000 tr/mn	2500 tr/mn	3000 tr/mn	3500 tr/mn	4000 tr/mn	4500 tr/mn	5000 tr/mn	5500 tr/mn	6000 tr/mn
1l/mn	27	29	31	34	37	40					
1,25 l/mn											
1,5 l/mn	25	27	29	31	34	36					
1,75 l/mn											
2 l/mn	24	26	28	30	31	33					
2,25 l/mn											
2,5 l/mn		24	27	29	30	32					
2,75 l/mn											
3 l/mn			25	27	29	31					
3,25 l/mn											
3,4 l/mn(max)					25	27					

NB 1 : Temperatures obtained on cells according to flow parameters and speed rotation of  
NB 2 : Initial temperature product : 21/22°C

 Optimum parameters zone up to 40 mm  
 Risk of bad mixing zone  
 Bad mixing zone

 Exotherm risk for >20 mm thickness  
 Exotherm risk for >30 mm thickness  
 Exotherm risk for >35 mm thickness  
 Optimum parameters zone up to 40 mm