THERMOSET EPOXICLEAR

EC3085LV

Product Highlights

- Clear epoxy low viscosity formulation for casting and coating applications
- Designed for applications that require high strength and chemical resistant coatings
- Exhibits good adhesion properties for laminate and potting applications

Mixing Properties:	Part A	Part B
Mix Ratio (Parts by Weight)	100	25
Mix Ratio (Parts by Volume)	100	25
Color	Clear	Clear
Viscosity @ 77F	5,000	400
Mixed Viscosity @ 77F	880	
Specific Gravity @ 77F (mixed)	1.07	
Gel Time @77F	26 minutes +/- 5	
Demold Time (varies w/ mass)	4 hrs (varies based on mass)	
Visual color of cured parts	Clear	

Physical Properties:	ASTM Method	Cure 1
Hardness, Shore D	D-2240	85 +/- 5
Flexural Modulus (PSI)	D-790	550,000
Tensile Strength (PSI)	D-638	10,000
Elongation (%)	D-638	7%
IZOD Impact Notched (ft-lb/in)	D-256	0.8
Shrinkage (in/in) (5" sample)	D-2566	0.002
Color	VISUAL	Clear

Cure 1: Physical properties obtained using ambient room temperature (77°F). Tested after 7 days

Other related products offered

- Silicone rubber
- Mold release agents
- Mix tubes
- Additional products available. Inquire directly for products not listed.

Mixing suggestions

- Precise measurement of part A and part B is the first critical step in a good mix
    - An accurate scale down to the gram (1/10 of a gram if possible) is needed to ensure that your measurements are correct
    - Once the two parts have been combined make sure that you stir the product vigorously and scrape the side walls and bottom to make sure that all the product in the cup is being included in the mixture.
    - If you don't feel like you are getting a good mix you can pour the mixed material into a second cup after you are done stirring and scraping to help ensure the two sides have been completely combined.
    - Drill mixing
    - Meter mixing
    - Vacuum degassing

Pouring suggestions

- Start at the lowest point in the mold and allow the product to fill the mold to level.
- Try to avoid letting the product "fold over" itself as this can cause trapped air bubbles in your final part.

Post pour suggestions

- In order to remove the chance of trapped air bubbles even further the mold can be placed in a pressure pot and taken to 60 psi while it cures.
- Mold temperature is recommended to be 150 °F for faster de-mold, otherwise longer time in room temperature mold will be required.
- A heated post cure is recommended to achieve maximum properties and heat resistance. Depending on geometry, the part may need to remain in the mold or fixtured to maintain part tolerances.

Kit Sizes and Weights:

• Quart Kit	(0.28 gal)	2.5 lbs.
• Gallon Kit	(1.1 gal)	10 lbs.
• Five Gallon Kit	(5.5 gal)	50 lbs.
• Drum Kit	(62.2 gal)	563 lbs.

Safety Precautions:

The safety data sheet (SDS) for this or any Thermoset Solutions, LLC product should be read prior to use and is available upon request from Thermoset Solutions, LLC.
Use in a ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

If Contact Occurs:

- Eyes: Immediately flush with water for at least 15 minutes. Call a physician.
- Skin: Immediately wash with soap and water. Remove contaminated clothing. Do not use solvents to wash skin. Seek medical attention if allergic reaction occurs.
- Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel.

Notice:

The information contained in this tech data sheet is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.