

ALCHEMIX EP 4062C

Two Part Epoxy Coupling Coat System

For use with GELCOAT EP 4062 and ALCHEMIX EP 4350 Laminating Paste

ALCHEMIX EP 4062C is a two component, thixotropic epoxy resin system specifically formulated to provide excellent adhesion between GELCOAT EP 4062 and ALCHEMIX EP 4350 laminating paste. ALCHEMIX EP 4062C is specifically formulated for high temperature applications.

Special Features

- High heat distortion temperature
- Easy application on vertical surfaces

Mix Ratio

EP 4062C : H4062C
By Weight 100 : 28

Product Data

Property	Units	EP 4062C	H4062C	Mix
Material	-	Epoxy resin	Formulated amine	Epoxy
Appearance	-	Brown thixotropic paste	Amber liquid	Brown thixotropic paste
Viscosity (25 °C)	mPa.s	80,000 – 140,000	100 – 160	9,000 – 14,000
Density (25 °C)	g/cm ³	1.10 – 1.20	0.92 – 0.97	1.00 – 1.10
Pot Life (200g, 25 °C)	Minutes	-	-	60 – 70
Demould Time (200g, 25 °C)	Hours	-	-	24 may be longer in cold conditions

Method of Use

Mixing and Application

ALCHEMIX EP 4062C should be mixed with HARDENER H4062C according to the indicated mixing ratio. Both components should be thoroughly mixed, care should be taken to avoid air entrapment and make certain that material at bottom and sides of container is thoroughly stirred into centre. When the gelcoat has reached a tack free state, the mixed material should be evenly applied onto the gelcoat by brush. Care must be taken to ensure an even coating and to avoid the inclusion of air bubbles. See the technical datasheet for GELCOAT EP 4062 for further details.

Cure and Post Cure

To achieve full high temperature properties, a step wise post cure treatment is recommended. Allow the product to cure at room temperature for at least 24 hours, then heat to 40°C for 1 hour, followed by 60°C for 1 hour, followed by 80°C for 1 hour, followed by 100°C for 1 hour, followed by 120°C for 3 hours.

To prevent any distortion during the post cure cycle, the unit should be placed on a conformer. When post-curing is complete, let the unit cool down slowly to room temperature, preferably in the oven. Sudden change in temperature can cause distortion or warping.

The product can be used without post cure or with partial post cure, but will not achieve full high temperature properties. The product can be post cured at higher temperatures (up to 160°C), however, care should be taken if using the product at these temperatures as any air voids from the laminating process can cause bubbling or delamination between the layers.

Laminating

After ALCHEMIX EP 4062C coupling coat has been applied, ALCHEMIX EP 4350 laminating paste should be applied. See the technical data sheet for ALCHEMIX EP 4350 for full details on the use of this product.

Storage

ALCHEMIX EP 4062C and HARDENER H4062C should be stored in original, unopened containers between 15 and 25°C. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.

If stored under the above conditions, ALCHEMIX EP 4062C / H4062C will have a shelf life of 12 months, from the date of production.

Packaging

ALCHEMIX EP 4062C is supplied in 1kg, 5kg and 10kg containers.
HARDENER H4062C is supplied in 280g, 1.4kg and 2.8kg containers.

(Please contact Alchemie Ltd for bulk supply)

Further Information

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Our technical advice, whether verbal, or in writing is given in good faith, but without warranty – this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use.

Before using any of our products, users should familiarise themselves with the relevant Technical and MSDS provided by Alchemie Ltd.

Alchemie Limited

Alchemie Ltd develop, formulate and distribute Epoxy Resins, Polyurethane Resins, Silicones, Model Boards and Sheet Wax for use in the following applications:

- Electrical encapsulation
- Rapid Prototyping
- Prototypes
- Casting
- Gel Coating
- Laminating
- Model Making
- Master Models
- Flexible and rigid mould making

We offer fast service, technical support, development expertise, innovative products, diverse knowledge and experience.

We are a well-established company, with a high level of investment and experience. We implement BS EN ISO 9001.

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