

Cured Properties

Properties	Standard	Units	Result (Full Cure)
Hardness (25°C)	BS 2782: Part 3: Method 365B	Shore D	91
Hardness (100°C)	BS 2782: Part 3: Method 365B	Shore D	88
Hardness (140°C)	BS 2782: Part 3: Method 365B	Shore D	84
Hardness (160°C)	BS 2782: Part 3: Method 365B	Shore D	80
Linear Shrinkage	500 x 50 x10 mm	%	0.10
Tensile Strength	BS 2782: Part 3: Method 320A	MPa	12.0 – 17.0
Elongation at break	BS 2782: Part 3: Method 320A	%	2.0 – 3.0
Flexural Strength	BS 2782: Part 3: Method 335A	MPa	56.0 – 61.0
Flexural Modulus	BS 2782: Part 3: Method 335A	MPa	7400 – 7900
Maximum Operating Temperature	Alchemie STM 24	°C	160
Machinability	-	-	Average

Method of Use

Preparation

Ensure that both ALCHEMIX EP 425 and HARDENER H425 are between 15 – 25°C. Before use, mix ALCHEMIX EP 425 thoroughly in order to homogenise the fillers.

Mould surfaces should be clean, dry and treated with ALCHEMIX R7, ALCHEMIX R5 or other suitable release agent. Porous materials should be well sealed. Polish if necessary, to obtain the desired surface finish. Where deep sections occur (more than 75 mm), we recommend coring out the mould using tapered wood cores with edges and corners rounded off and covered in tin foil and treated with release agent. Cores should be at no more than 13 cm centres and a minimum of 35 mm off working resin face. Cores must be removed after curing.

Mixing Instructions

ALCHEMIX EP 425 should be mixed with HARDENER H425 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. After thorough mixing, the material should be poured into the mould. To avoid air entrapment, pour the material slowly, and into one place in the mould. Mixing and pouring must be completed within the stated pot life. Where fine detail is to be reproduced, we advise that the mixed product is first brushed onto the surface using a stippling action. The remainder of the material can then be cast into the mould.

Curing and Post Curing

Demould times will vary with the thickness of casting, for example, thin sections may take 16 to 24 hours before they can be demoulded. 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 1 hour.

To prevent any distortion during the post cure cycle, the unit should be fully supported during the process. 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.

Storage

ALCHEMIX EP 425 and HARDENER H425 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 425 / H425 will have a shelf life of 12 months, from the date of production.

Packaging

ALCHEMIX EP 425 is supplied in 5kg and 10kg containers.
HARDENER H425 is supplied in 500g and 1kg containers.

(Please contact Alchemie Ltd for bulk supply)

Further Information

All data listed relates to typical values. This data should not be considered a product specification.

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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