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Aluminum Filled Epoxy E-108 AHT Product Data Sheet

E-108-AHT: Low Viscosity, Aluminum Filled epoxy for High Temperature Resistant Tooling. This two-component system has several Hardeners (H) available that are selected based on part's thickness and service temperature—*See Hardener Selection Below.* **Available Sizes:** Quart Kit Gallon Kit 5 Gallon Kit

- Excellent Impact Resistance
- Good Thermal Shock
- Low Viscosity & Low Shrinkage

Applications: Thermal Forming Tools, Machinable Parts, Low Cost Hard Tooling for Urethane and Thermal Plastics, Prototypes and Models.

Properties:

Hardness, Shore D: 90
Viscosity, CPS: 14,000- unmixed
Color: Grey
Tensile: 6,100 psi
Shrinkage: 0.0045
Specific Gravity: 1.51
Coverage: 18 cu³/lb

Mix Ratio of Hardener: (By Weight)

100% E-108 AHT

H-82R @ 7% Best for High Temperature Resistance—300F

(4"x4"x4" Piece) **Pot Life: 90 min**

Cure Time: 16 Hours

H-403A @ 16% Temperature Resistance—180F

Cure Time: 24 Hours @ 77F

H-2052 @ 15.5% For tools less than 1" thick, Temperature Resistance—250F

**Mix in small batches Quart or Less

(½" Thick Piece) **Pot Life: 60 min**

Cure Time: 4 Hours

H-1922 @ 9%

***Step Post Cure required for constant High Temperature Service

Service Temperature: 200 - 300F Intermittent--dependant on hardener used

**Heat resistance is determined by intermediate of constant temperature factor.

MIXING INSTRUCTIONS:

Pre-mix epoxy base then mix in hardener by specified ratio as listed above by weight. Mix well by hand or mechanical mixer. Be sure to scrape sides and bottom or transfer to another container and remix to ensure a thorough mix. For best results, de-air at 29 inches of mercury before pouring. Thick pours may be successful in multiple pours, the first being thin to allow air to flow out. Allow one hour between pours.

STORAGE:

Store at Room Temperatures between 70F and 90F. Keep out of sunlight or away from heat.

THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. EACH USER OF THE MATERIAL SHOULD THOROUGHLY TEST APPLICATION, AND INDEPENDENTLY CONCLUDE SATISFACTORY PERFORMANCE BEFORE COMMERCIALIZING. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ON ANY PARTICULAR PATENT.