

# SILPAK, Inc

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## E-108 R Product Data Sheet

**E-108-R:** Unfilled epoxy for high temperature cycles with special additives for impact resistance. 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
- Low Viscosity
- Extremely Tough
- Low Shrinkage

**Applications:** Castible epoxy with good transparency and low viscosity which adheres to hard surfaces. A good clear coat when laying up Carbon Fiber—*uses Hardener H-2052.*

### Properties:

Shore Hardness: 80 D  
Viscosity, cps: 15,000 cp, Unmixed  
Color: Translucent/Transparent  
Tensile: 5,000  
Shrinkage: Nil  
Specific Gravity: 1.16  
Heat Deflection Temperature: 275F

Tensile Modulus @ 75F psi x 10<sup>6</sup>: 0.42  
Compression Strength psi: 6,900  
Compressive Modulus psi x 10<sup>6</sup>: 0.45  
Izod Impact Strength FT-LB/in of notch: 0.47

### Mix Ratio of Hardener: (By Weight)

100% E-108 R

H-2052 @ 48% Use for tools less than 1" thick, Temperatures Resistance—250F

Pot Life: 5-10 minutes @ 77F

Cure Time: 2 hours @ 77F

H-82R @ 22% Use for Best Heat Resistances 300F

H-34 @ 50% Cyclo Aliphatic: Good Chemical Resistance

**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.