

# SILPAK, Inc

470 E. BONITA AVE. POMONA, CA 91767  
PH (909) 625-0056 [WWW.SILPAK.COM](http://WWW.SILPAK.COM) FX (909) 625-0082

## Clear Cast and Coating System

### E-108 WC

#### Product Data Sheet

**E-108 WC:** Unfilled epoxy for water clear applications with special additives for impact resistance. This two-component system has several Hardeners (H) available that are selected based on part's thickness—*See Hardener Selection Below.*

**Available Sizes:** Quart Kit Gallon Kit 5 Gallon Kit

- Excellent Impact Resistance
- Low Viscosity
- Very Tough Epoxy
- Water Clear

**Applications:** E-108 WC is a castable epoxy with good transparency and low viscosity that cures to hard plastic part or can be used as a clear coat with appropriate hardener. Clear castings such as statues, lens, and prototype pieces can be created as well as encapsulating products to create an acrylic like piece.

#### Properties:

Shore D Hardness: 70D

Viscosity CPS: 15,000 cps - unmixed

Color: Transparent

Shrinkage: Nil

Tensile Modulus @ 75F psi x 10<sup>6</sup>: 0.42

Compressive Modulus psi x 10<sup>6</sup>: 0.45

Tensile: 5,000

Specific Gravity: 1.12

Compression Strength psi: 5,000

Izod Impact Strength FT-LB/in of notch: 0.47

**Hardener Selection: (By Weight) Base E-108 WC @ 100%**

**H-403 @ 40%** for thicker than ¼ " pieces

By Volume: 65%E108WC & 35% H 403

Pot Life: 2-4 hours

Cure Time: 48 hours, (Accelerated cure @125F for 4 hours & allow to cool 1-2 hours @ Room Temperature)

**H-403A@ 47%** for quicker cure on thick pieces **BAR TOP CLEAR COAT**

Pot Life: 60-90 minutes

Cure Time: 24 hours

**H-2052@ 45%** for ¼" or less pieces (Mix in small batches of Quart or less)

Pot Life: 10 minutes

Cure Time: 3-4 hours

#### **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. Pigments are available to color resin: red, yellow, blue and black.

#### **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.