

## TECHNICAL DATA SHEET

# EL-302PC

### EPOXY LAMINATING SYSTEM

### WHITE, ROOM TEMPERATURE, TWO HARDENER CHOICES – EL-302PC & EL-302PC-2

#### DESCRIPTION

*EL-302PC is a white room temperature laminating system with excellent handling characteristics, low viscosity and high strength. Its low toxicity makes it ideal for laminated tooling and production applications. EL-302PC exhibits excellent dimensional stability, high mechanical strength and excellent cloth penetration (wet-out) without run-out. Use EL-302PC with epoxy surface coat systems ES-218 or TCC-352 for high early strength properties. EL-302PC Resin is available with two hardener options: EL-302PC Hardener and EL-302PC-2 Hardener (see work life details listed below). **Typical applications include: prototypes, keller models, master models, patterns and core boxes, checking fixtures, production parts, trim fixtures, holding fixtures, duplications and router and drill fixtures.***

- High mechanical properties
- Excellent dimensional stability
- Excellent wet-out
- Low vertical drain off

#### APPLICATIONS

- Prototypes, patterns and core boxes
- Master models, Keller Models
- Production parts
- Trim, holding, and checking fixtures
- Duplication splashes
- Router and drill fixtures

#### PHYSICAL PROPERTIES

Property		EL-302PC Resin	EL-302PC Hardener	EL-302PC-2 Hardener
Composition		Epoxy	Amine	Amine
Mix ratio by weight		100	16	19
Mix ratio by volume		100	23	26
Aspect		Thixotropic Liquid	Liquid	Liquid
Color		White	Clear amber	Clear amber
Mixed viscosity at 77°F (25°C) (mPa.s)	ASTM D2393		2,500 – 3,500	2,500 – 3,500
Specific Gravity at 77°F (25°C)	ASTM D792	1.40	.97	
Pot life at 77°F (25°C) (220 g) (Minutes)	ASTM D2471		28 - 34	55 - 65
Demold time (hours)			16 - 24	24

## Neat - Mechanical and Thermal Properties <sup>(1)</sup>

Properties	Method	Unit	EL 302PC Resin EL-302PC Hardener
Hardness	ASTM D2240	Shore D	85
Tensile Elongation	ASTM D638	%	1.1
Compressive Strength	ASTM D695	psi (MPa)	13,840 (95)
Shrinkage	ASTM D2566	in/in	0.0002
Coefficient of Thermal Expansion	TMA	ppm/° F (° C)	16 (29)
Notched Izod Impact Strength	D256	In-lbs/in (J/m)	13.9 (742)

<sup>(1)</sup> The above properties were obtained under laboratory conditions using standardized specimens. Cured 7 days at room temperature

## HANDLING PRECAUTIONS

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Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheets.

## STORAGE CONDITIONS

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- This product has a shelf life of 24 months for the resin and hardener as indicated by the expiration date on the container when stored in original unopened containers.

## PACKAGING

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Packaging information on request, please contact your local sales representative or find your local contact on [www.sikaadvancedresins.us](http://www.sikaadvancedresins.us)

## LEGAL NOTICE

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## CONTACT

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