

Product Bulletin MF-E302

High Temp UnFilled Epoxy Laminating System

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Description:

MF-E302 offers the most outstanding performance of any high temperature laminating system available. The extremely high service temperature (425 F/220C) makes MF-E302 very well suited to high performance autoclave curing. MF-E302 will gel at room temperature; however, an elevated post cure is required to achieve ultimate physical properties.

Uses:

Vacuum Form molds	Prototype Injection Molds
High Temp Bonding Fixtures	Spray Metal Molds
Compression Molds	High Temp Laminating Molds
Parts to be used in High Temp Applications	

Material Handling Properties:

Mix Ratio _____	100R/25H pbw
Density _____	9.6 lbs / gal
Specific gravity _____	(1.15)
Work time @ 25C/77F _____	60 minutes
Demold Time _____	dependant on post cure
Mixed Viscosity _____	3000 cps
Shelf Life (unopened @ 77F) _____	1 year
Ultimate Compressive strength (ASTM D-695) _____	31,000 psi
Ultimate flexural strength (ASTM D-790) _____	47,400 psi
Tg by DSC _____	166C/330F
Flexural Modulus (ASTM D-790) _____	1,820,000 psi
Ultimate Tensile strength (ASTM D-638) _____	36,000 psi

Recommended Cure Schedule:

- 2 hours @ 66C/150F
- 2 hours @ 93C/200F
- 2 hours @ 121C/250F
- 1 hour @ 149C/300F
- 4 hours @ 177C/350F

*ramp rates should be done at 5 to 10 degrees / min F

<p>Important notice: Since the use of this product is beyond the control of the seller, the buyer assumes all risks of the use or handling, whether in accordance with the directions or not, as seller makes no warranty, expressed or implied concerning this product.</p>
