



**EC-426-2
EPOXY CASTING
SYSTEM**
ROOM TEMPERATURE
ABRASION RESISTANT

PRODUCT BULLETIN



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DESCRIPTION

EC-426-2 ABRASION RESISTANT CASTING RESIN is a room-temperature cure system developed for use in the casting of hard tools and dies. EC-426-2 has excellent air release and high physical properties that will produce dimensionally accurate, detailed, durable, void free surface duplications. EC-426-2 can be cast up to 4" without excessive exotherm or shrinkage. EC-426-2 may be cast thicker than 4 inches with the addition of bulk filler. **Typical applications include: sheet metal stamping ties, draw and stretch dies, hammer forms and router and trim fixtures.**

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (parts by weight)	100R/18H
Mix Ratio (parts by volume)	3.186R/1H
Density (Mixed)	13.95 lbs/gal
.....	0.053 lbs/cu in
Specific Gravity	1.47 grams/cc
Mixed Viscosity	24,000 cps
Work Life	200-270 minutes
Demold Time.....	24-36 hours
Complete Cure.....	5-7 days
Color (Resin Black / Hardener Amber.....)	Black
Shelf Life Resin (in original unopened container).....	1 year
Shelf Life Hardener (in original unopened container).....	2 years

PHYSICAL PROPERTIES

Ultimate Tensile Strength	5,824 psi
Tensile Modulus.....	0.59 x 10 ⁶ psi
Ultimate Flexural Strength.....	9936 psi
Flexural Modulus.....	0.4 x 10 ⁶ psi
Ultimate Compressive Strength.....	10,360 psi
Impact Strength.....	5.23 in-lb/in
Shrinkage	0.0005 in/in
Cured Hardness.....	88-92 Shore D
Tensile Elongation	2.338%
Machineability	Excellent

EC-426-2 Tech/Revised 5/20/10
Supersedes 12/13/06

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