



**ES-204
EPOXY SURFACE
COAT
ROOM TEMP
ABRASION RESISTANT
BLACK**

PRODUCT BULLETIN



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DESCRIPTION

ES-204 ABRASION RESISTANT EPOXY SURFACE COAT is a two component, room temperature curing system commonly referred to as a Die Surface system. It exhibits excellent handling properties which produce dimensionally accurate and void free duplications. Due to its abrasion resistance, machinability is poor; however, the outstanding physical properties create a very strong, long lasting and durable surface. ES-204 can also be used as the surface coat for mass casting duplications, or as a surface casting material up to ½" without bulk fill. Use with ADTECH laminating systems, EL-301 or EL-302 PC. **Typical applications include: nesting and bonding fixtures, draw and stretch dies, foundry patterns and core boxes, router and trim fixtures, hammer and stretch forms and tracing duplications.**

HANDLING CHARACTERISTICS @ 25°C/77°F

Mix Ratio (parts by weight)	100R/10H
Mixed Density	14 lbs/gal
.....	0.059 lbs/cu/in
Specific Gravity	1.68 g/cc
Mixed Viscosity	Thixotropic
Work Life	25 minutes
Demold Time	16-20 hours
Resin Color.....	Black
Hardener Color.....	Amber
Mixed Color	Black
Shelf Life ES-204 Resin (in original unopened containers).....	1 year
Shelf Life ES-204 Hardener (in original unopened containers).....	2 years

PHYSICAL PROPERTIES

Ultimate Tensile Strength (ASTM D-638.91)	5,600 psi
Tensile Modulus (ASTM D-638.91)	1,249,000 psi
Tensile Elongation (ASTM D-638.91)	0.41%
Ultimate Compressive Strength (ASTM D-695.91)	19,200 psi
Compressive Modulus (ASTM D-695.91)	137,300 psi
Ultimate Flexural Strength (ASTM D-790.92)	11,300 psi
Flexural Modulus (ASTM D-790.92).....	543,400 psi
Notched Izod Impact Strength (ASTM D-256.93A)	4.23 in/lbs/ft
Hardness	90 Shore D
Shrinkage	0.0004 in/in

ES-204 Tech/Revised 2/16/10
Supercedes 12/12/06

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