



ROOM TEMPERATURE MASTER MODELS

USING EL-324SC

APPLICATION GUIDE

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Plastic Systems

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RECOMMENDATIONS FOR THE USE OF ADTECH EL-324SC STYLING COMPOUND FOR CONSTRUCTION OF HIGH-TOLERANCE PLASTIC MASTER MODELS.

CONSTRUCTION OF THE SUBSTRUCTURE

1. Construct a square mounting base using 1" Fiberglass Reinforced Honeycomb panels set in a vertical egg crate configuration. The base dimension (length & width) should exceed the dimensions of the model by 10 inches in each direction. This structure is tied together with 4 layers of Style #7500 10oz fiberglass cloth or fiberglass tape laminated with ADTECH EL-302PC Room Temperature Epoxy Laminating Resin, and allowed to cure.
2. Plan ahead for the location of access holes in the bottom of the base panel. This allows for easy installation of lifting and leveling lugs. Lifting and leveling areas should be reinforced with angled aluminum bonded and bolted to the base panel.
3. To the base attach and position contoured header boards of 1/2" to 1" honeycomb panel spaced 10" apart. Areas of extreme contour change require closer spacing of header boards for maximum support of the master surface. Header boards are attached to the base using 4 layers of Style #7500 10oz fiberglass cloth laminated with EL-302PC Room Temperature Epoxy Laminating Resin, and allowed to cure.
4. Attach full size paper plots referenced by locations and dimensions to the appropriate header board. These header boards are cut to a size 3/4" less than the dimension of the finished model using a hand operated saw (jig saw, saws-all).
5. With screw fasteners attach steel wire mesh over the top of the header boards.
6. Laminate 12 layers of Style #7500 10oz fiberglass cloth laminated with EL-302PC Room Temperature Epoxy Laminating Resin. Apply peel ply following the 12th layer and allow to cure.

MASTER MODEL SURFACE

1. Remove peel ply.
2. Catalyze EL-324SC Epoxy Styling Compound and roll out to a 1" thickness using 4" PVC pipe and 1" shim spacers to control thickness.
3. While applying EL-324SC to the sub-structure surface, also continue to lightly coat the substructure with EL-302PC Room Temperature Epoxy Laminating Resin. Apply EL-324SC to a 1" thickness starting at the lowest point of the model surface and work towards the top of the model (a bridge effect). Firmly butt and compress EL-324SC to the substructure surface as you proceed, taking care not to entrap air between the substructure and the EL-324SC.

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4. Allow to cure 3 days at room temperature.
5. CNC to dimension.
6. Seal with Mold Sealer #7.

PLEASE REFERENCE THE FOLLOWING PRODUCT DATA BULLETINS

LAMINATING SYSTEM: EL-302-PC Laminating System
STYLING COMPOUND: EL-324-SC Styling Compound
REPAIR PASTE: P-17 Repair Paste
MOLD RELEASE AND SEALER: Mold Sealer MR #7/ Mold Release MR #10
FIBERGLASS REINFORCED HONEYCOMB PANELS
FIBERGLASS CLOTH: Style #7500 10oz / Fiberglass Tape

Room Temp Master Models using EL-324SC/Revised 2/9/10
Supercedes 7/15/04