



## DESCRIPTION

**TECHNO CAST 8023 is a two component epoxy system designed primarily for casting or molding tooling fixtures for industrial application and uses.**

**Its low viscosity and low exothermic reaction make it possible to pour and cure units up to 13 cm thick in normal ambient temperature, depending on the mass and the mold used.**

## CHARACTERISTICS

- Negligible shrinkage
- Good self-adhesion
- Low exothermic reaction
- Easily machinable
- Low viscosity

## APPLICATIONS

As some settling is normal in part **A** on long standing, it is highly recommended to stir in original container before adding the part **B**.

The use of a proper release agent such as **TECHNO RELEASE 110** will facilitate the demolding operation.

The uncured components can easily be cleaned by using **solvent 913**.

Please consult **POLYMERES TECHNOLOGIES** for more details based on your application.

## PHYSICAL PROPERTIES (at 22°C)

		<b>PART A</b>	<b>PART B</b>	<b>MIXED</b>
Viscosity	Brookfield (cps)	7 000	160	3 000
Consistency		Liquid	Liquid	Liquid
Density	g/cm <sup>3</sup>	1.68	0.92	1.56
Mixing Ratio by	1. volume	10	1.8	10/1.8
	2. weight	100	10	100/10
Colour		Grey	Yellow	Grey
Pot Life	masse 200 cc	3 hours 15 minutes		
Gel Time	2" (6"X4" wood)	6 hours 15 minutes		
	1" (6"X4" wood)	6 hours		
	1/2" (6"X4" wood)	5 hours 30 minutes		
Peak Exothermic Temperature (Max.)		31°C		
Full Cure		2 days*		

\* After material has solidified full cure can be accelerated at 51.7°C (125°F).

**PHYSICAL PROPERTIES** (solid state) 7 days after cure at 22°C

TEST	METHOD	RESULTS	
Hardness	ASTM D 785-65	Shore D	86
Compressive Strength	ASTM D 695-80	MPa <sup>1</sup>	104,94
Tensile Strength	ASTM D 638-82	MPa	31.17
Flexural Strength	ASTM D 790-81	MPa	48,96
Deflection Temperature (°C)	ASTM D 648-82	1. 455 kPa <sup>2</sup> 2. 1820 kPa	60 57
Impact Resistance	ASTM D 256-81	J/m <sup>3</sup>	33.4
Linear Shrinkage	ASTM D 2566-79	cm/cm	0.0030
Coefficient of Linear Thermal Expansion	ASTM D 696-79	mm/mm/°C	4.77 X 10 <sup>-5</sup>
Abrasion Resistance	Taber CS 17 - 1000 gr, gm loss/1000 cycle		0.041

## PRECAUTIONS

- Consult Material Safety Data Sheet prior to use.
- Normal health and safety precautions should be observed when handling these products :
  - Ensure good ventilation
  - Wear gloves, safety glasses and waterproof clothes.
- Shelf life of product in original closed containers is **one (1) year**.
- Once the container is opened **POLYMÈRES** has no control or responsibility for the shelf life.
- It is recommended to follow Provincial and Federal safety regulations. In case of eye contact, rinse well with water, in case of skin contact, rinse with soap and water. Keep away from children.

## GUARANTEE

Seller makes no warranty of any kind, express or implied, as to the merchantability, fitness for any particular purpose, or any other matter with respect to the product **TECHNO CAST 8023**. Since conditions of use are beyond seller's control, buyer assumes all risk of use of this product. Under no circumstances will seller be liable for consequential or incidental damages arising out of the use of this product. Seller's sole obligation shall be to replace the product if found to be defective. It is the user's responsibility to determine the suitability for use of this product under the conditions present at the time of application. M.S.D.S. available upon request.

<sup>1</sup> 1 MPa = 145 lb

<sup>2</sup> kPa = .145 psi

<sup>3</sup> 53.4 J/m = 1 ft.blf/inch