HI-POLY 900A/B Clear Epoxy Compound

Product Information Sheet

For reference only, not for specification use

DESCRIPTION:

A two-part Clear Epoxy Compound for decorative coating on rigid substrate.

USES:

Designed for decorative coating on sound substrate. It also serves as adhesive to bond metal, wood, ceramics & glasses.

ADVANTAGES:

- High transparency
- High hardness, can be grinded or burnished
- Able to enlarge the coated figure, doming
- Excellent chemical resistant
- Coated items can be further processed by plating or ultrasonic cleaning
- Low shrinkage

HI-COAT Series:
HI-POLY 900A/B (high viscosity)
HI-POLY 900PA/B (low viscosity)

PACKAGING:

Packaged in kits as pre-proportioned batches for error-free job site mixing and application.

SURFACE PREPARATION:

In general, the surface to be resurfaced or bonded must be clean, sound, dry and above 10°C to assure an optimum bonding. All surface contaminants must first be thoroughly removed by chemical and/or mechanical means.

PHYSICAL PROPERTIES:

Mixing ratio (by weight,): A : B = 100 : 30

	HI-POLY 900A/B	HI-POLY 900PA/B
Viscosity , Brookfield RVT: *Spindle 3, Speed 10 cps*		
i) Part A	9,000	900
ii) PartB	10	10
Viscosity (after mixing) , Brookfield RVT Spindle 3, Speed 10 cps	740	210
Gel Time (20g), minutes	> 280	> 280
Highest Exotherm Temperature (°C)	64	64
Time for reaching the Highest Exotherm Temperature, minutes	396	396
Hardness after curing (Shore D)	85	

** All measurements taken @25°C unless otherwise noted.*

For Industrial Use Only
KEEP OUT OF THE REACH OF CHILDREN.

APPLICATION:

1. By dispenser, dispensing system
2. Weight accurately; any variation in mix ratio will result in degraded properties
3. Use only in ventilated area
4. Use fume mask and gloves
5. Avoid skin contact (Part B is CORROSIVE!)
6. Part B is heat & moisture sensitive. Leaving the can open during long application will lead to yellowing of the coating and decrease in shelf life.

Caution: Avoid large mass., severe exotherm may occur!!

7. Because of the high purity, crystallization may occur if the storage temperature is < 20 °C. Customer can heat the Part A with an oven, until the Part A appears complete transparent. This method will not produce any effect to the properties of the material. Completely cool down the material before mixing.

Suggested Temperature & Time

Weight	Oven Temperature	Time
1 kg	60 °C – 80 °C	1 – 2 hr
10 kg	60 °C – 80 °C	3 – 4 hr

CURE TIMES:

Curing Time	HI-POLY 900A/B	HI-POLY 900PA/B
Set-to-touch @ 25 °C *(thickness: 0.15mm)*	> 10 hr	> 20 hr
Surface Dry @ 25 °C	> 15 hr	> 30 hr
Full Cure @ 25 °C	3 days	7 days
Full Cure in Oven @ 80 °C	2 hr	2 hr

HI-POLY 900A/B & HI-POLY 900PA/B: the gel time can reach 4-5 hrs. It is desirable for large batch production. Heat Cure is recommended.

CLEAN UP:

Tools should be cleaned immediately after use with soap and water. Solvents such as Xylol or paint thinner can also be used. But care should be taken before using any flammable & hazardous solvents.

DISPOSAL:

Dispose in accordance with local regulations. Use licensed hazardous waste company.
Empty containers may contain product residue, including flammable or explosive vapor. Do not cut, puncture or weld on or near container. All label warnings must be observed until the container has been properly disposed of.

Storage:

- Part B is heat & moisture sensitive, store in a cool, dry place.
- Mixed materials cannot be stored for future use.
- Shelf life would be shortened if the container had ever been opened.
- Shelf Life (fulfilling above requirements): approximate 1 year

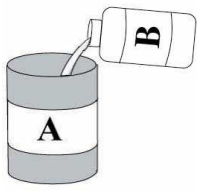
01/09/2007

高科化工有限公司 | CHEMATCO LTD.
香港新界元朗工業邨 宏利街八號 | 8 Wang Lee Street , Yuen Long Industrial Estate , Yuen Long. N.T., Hong Kong
(852) 2391 0371 (852) 2397 6226 www.chematco.com

Mixing & Storage of Epoxy

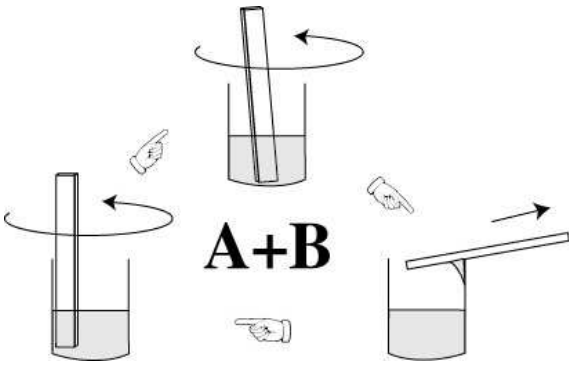
Mix the materials according to the mixing ratio (by weight)

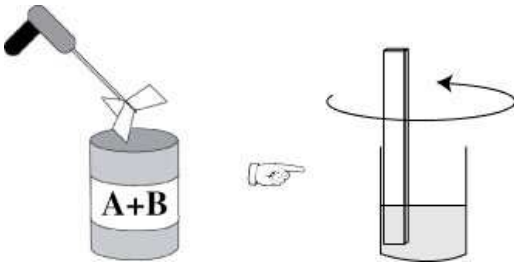
After mixing, curing process will be started. Calculate the ideal mixing amount according to the designated pot life.[P.S.2.]



Empty Part B entirely into the can of Part A

Manual Mixing ◄——► **Electrical Mixing**





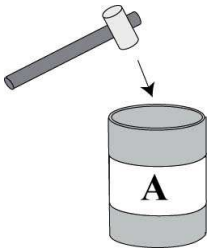
- ∗ Perpendicularly stir with a paint paddle
- ∗ Mix the material thoroughly, including the sediment and material sticking on inner of the can. Repeat thrice
- ∗ Mixing for 2-3 minutes until completely blended

- ∗ Stir with a Jiffy Mixer
- ∗ Scrape the material sticking on the can's inner into the mixed component Repeat mixing

P.S.: **1. Avoiding produce bubbles during mixing. Bubbles can be reduced by vacuumizing.**
2. Pls. refer to the relevant technical data sheet for particular product's pot life.

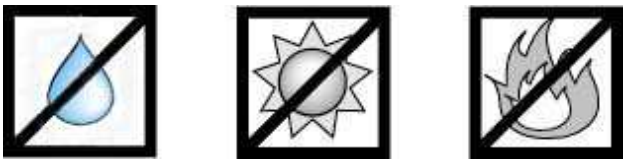
Storage

∗ Unmixed materials should be gastightly stored



Safety

- ∗ Use only in ventilated area
- ∗ Use fume mask and gloves
- ∗ Wear goggles
- ∗ Use within the pot life or the mixed component will produce severe exotherm



高科化工有限公司 | CHEMATCO LTD.
香港新界元朗工業邨 | 8 Wang Lee Street , Yuen Long Industrial Estate , Yuen Long, N.T., Hong Kong
宏利街八號 | (852) 2391 0371 (852) 2789 3346 www.chematco.com