

EPOXY Mixing Instructions

SUPPLIES NEEDED:

- ▶ Spatula
- ▶ Plastic cups/buckets
- ▶ Gram Scale (accuracy 0.1 g)



It is important to follow the mix ratio exactly to ensure your epoxy cures as expected.

1 WEIGH

Using the mix ratio on the technical data sheet, weigh out the part A to be blended to the nearest gram (g). Add part B using the same weighing method. Mix as closely to the weight mix ratio as possible.

2 MIX

Mix the A/B system for at least 1 minute, while scraping the sides and bottom of the container. Pour contents into a second container, mixing for an additional minute. This ensures any unmixed material on the sides and bottom of the first container will be mixed completely in the second container.

Note: Hand mixing allows air to enter the material. The end result of this will be bubbles in the cured material. Try not to mix so vigorously that air can easily get into the mixture. (An additional step of evacuation can be used to remove air from the mixed material.)

3 POUR

After the material is mixed, pour it into your mold/part.

Recommendation: Add nitrogen or argon blanket to sensitive polyurethanes.

How to Calculate 'Part B' Ratio by Weight for Hand Mixing:

Example 1:

Data sheet labels Part A: 100 & Part B: 8

If you pour 125 g of Part A, to find Part B multiply...
 $125 \times .08$ (from Part B above with changed decimal)
= 10 g of Part B

Example 2:

Data sheet labels Part A: 100 & Part B: 33

If you pour 225 g of Part A, to find Part B multiply...
 $225 \times .33$ (from Part B above with changed decimal)
= 74.25 g of Part B