

SILPAK E-108 WC

Clear Cast and Coating System

Unfilled epoxy for water clear applications with special additives for impact resistance. This two-component system has several Hardeners (H) available based on part's thickness – *See Hardener section below.*

Features

- Excellent impact resistance
- Low viscosity
- Very tough epoxy
- Water Clear

Applications

E-108 WC is a castable epoxy with good transparency and low viscosity that cures to hard plastic parts or can be used as a clear coat with appropriate hardener. Clear castings such as statues, lens, and prototype pieces can be created as encapsulating products to create an acrylic-like piece.

Physical and Handling Properties

Property	Value
Shore D Hardness	70
Viscosity, cps	800 - unmixed
Color	Transparent
Shrinkage	Nil
Tensile Modulus @ 75F psi x 10 ⁶	0.42
Compressive Modulus psi x 10 ⁶	0.45
Tensile Strength, psi	5,000
Specific Gravity	1.12
Compression Strength psi	5,000
Izod Impact Strength FT-LB/in of notch	0.47

Hardener Selection (by weight) Base E-108 WC @100%

	H-403	H-403A	H-2052
By Weight	@ 40% for thicker than ¼" pieces and under 4" (25cu ³ /lb)	@47% for quicker cure on thick pieces up 2" BAR COAT CLEAR TOP	@45% for ¼" or less pieces (mix in small batches of quart or less) **Color: Clear amber
By Volume	65% E108WC & 35% H403		
Pot Life	2-4 Hours	60-90 Minutes	10 Minutes
Cure Time	48 Hours (accelerated cure @ 125F for 4 hours and allow to cool 1-2 hours @ room temperature)	24 Hours (72 Hours for less than 1")	3-4 Hours



Mixing

Pre-mix epoxy base, then mix in hardener by specified ratio as listed above by weight. Mix well by hand or mechanical mixer. Be sure to scrape sides and bottom or transfer to another container and remix to ensure a thorough mix. For best results, de-air at 29 inches of mercury before pouring. Thick pours may be successful in multiple pours, the first being thin to allow air to flow out. Allow one hour between pours. Pigments are available to color resin: red, yellow, blue and black.

Storage and Shelf Life

Store at room temperatures between 70°F and 90°F. Keep out of sunlight or away from heat.

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