



## TECHNICAL DATA SHEET

### POLYMARK P152 EPOXY CASTING SYSTEM

#### Product Description:

Polymark P152 is a two-component, fast curing epoxy potting and casting system. It produces a hard, crack-resistant material capable of resisting high temperature and many chemical environments. Polymark P152 provides excellent environmental protection while having tenacious adhesion to various metals, plastics and other common assembly materials. P152 has a neutral, unpigmented appearance but other color variations are available.

Polymark P152 Resin can be preheated and mixed with P152 Hardener to produce molded castings in as little as 1-2 minutes. The castings are resistant to stress cracking even when cured at these fast rates.

#### Typical Material Handling Properties:

<u>CHARACTERISTIC</u>	<u>VALUE</u>
<b>Resin:</b>	
Color	Neutral-Tan
Density (grams/cc)	1.54
Viscosity, 25°C	45,000 cps.
<b>Hardener:</b>	
Color	Clear
Density (grams/cc)	0.98
Viscosity, 25°C	18 cps.
<b>Mixed:</b>	
Mix Ratio (Resin to Hardener)	
by weight	100 : 12.7
by volume	5 : 1
Geltime @ 25°C	20 minutes
Cure Schedule* @100°C	5 minutes
Demolding time (100°C)	1-2 minutes

\*The reaction's exotherm will drive the cure to completion when cured with sufficient mass and temperature.

**Important Notice to Users:** Typical properties are shown in this technical bulletin and should not be used or taken as specifications. Contact Polymark prior to establishing specifications. The information given for product description, handling properties and cured physical properties are offered solely to assist the purchaser's own testing. Polymark, its sales agents and distributors make NO WARRANTY OF MERCHANTABILITY OF THE PRODUCT OR THE FITNESS OF THE PRODUCT FOR ANY PARTICULAR PURPOSE. This product and all information supplied in connection with it is used at the purchaser's own risk, conditions of use being beyond Polymark's knowledge or control. The purchaser assumes all risk of use or handling of the product, whether in accordance with directions or not.

#### Typical Material Cured Properties

<u>CHARACTERISTIC</u>	<u>VALUE</u>
Color (unpigmented)	Tan
Cured Density (gram/cc)	1.45
Cured Hardness (Shore D)	D90
Glass Transition Temperature (Tg)	140°C

#### Product Features:

- **Fast Curing**
- **Fracture and Chemical Resistance**
- **High Temperature Service**
- **Low Cost**

#### Processing:

Polymark P152 can be proportioned by weight or volume. These ratios are stoichiometrically calculated and should be closely followed. Automated meter-mix dispensing equipment may be used for high volume production.

#### Handling Safeguards:

Closely follow instructions on the labels of Polymark materials containing information on the hazards associated with each particular product. Most epoxy resin systems are skin and eye irritants and may even be corrosive to the skin and eyes. Other problems, such as skin sensitization and more serious health hazards may exist. Consult the Safety Data Sheet (SDS) for further information.

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