

STAR Technology

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515-04**515-06****Laminating Paste****DESCRIPTION**

STAR Technology 515-04 and 515-06 are blue, fiber filled epoxy laminating pasted formulated for the rapid construction of models, tools, and jigs. 515-04 is the faster version and 515-06 is the slower of these sister systems. They are not recommended for tools that require substantial mechanical properties. The overall size, thickness, and layup speed will influence the desirable pot life of the system. The two components mix together rapidly in a dough mixer to form a soft paste consistency that is easily applied. The resin and hardener are colored white and blue respectively to aid in ensuring a thorough mix. They are compatible with STAR surface coats and laminating systems such as 500-01 and 504-01 (surface coats) and 510-01 and 511-02 (laminating systems). These systems allow a warm water cleanup.

BENEFITS

Rapid build	Easy to apply
Excellent consistency	Color coded resin and hardener
Choice of two pot lives	

TYPICAL PROPERTIES (cured 7 days at 75°F)

		<u>TEST METHOD</u>	<u>515-04</u>	<u>515-06</u>
Mix Ratio, Resin to Hardener	Parts by Weight		100:12	100:12
Mixed Viscosity (centipoise)			Dough	Dough
Density (lbs./cu.in.)		ASTM D2393	0.43	0.43
(lbs./gal.)		ASTM1475	12.0	12.0
Pot Life at 75°F (minutes)		ASTM D2471	75	120
Demolding time at 75°F (hours)			16	24
Cure Time at 75°F (days)			7	7
Shore Hardness (D)		ASTM D2240	60	60
Tensile Strength (psi)		ASTM D638	2400	2400
Flexural Strength (psi)		ASTM D790	7500	7100
Flexural Modulus (psi)		ASTM D790	276,000	467,000
Maximum Service Temperature (°F)			180	180
Shrinkage (%)			nil	nil
Coeff or exp. (in/in/°C)			3.2E-5	3.2E-5

APPLICATION PROCEDURES

Carefully weigh out appropriate amounts of resin and hardener into a clean mixing container and thoroughly mix until all streaks and striations are gone. Scrape the sides and bottom frequently to ensure complete mixing.

CAUTION: Unmixed compound from the sides or bottom of the container can cause soft spots or uncured areas in the completed laminate. To prevent this, transfer the entire mixed contents to a second clean container and remix for a short time before using.

To the best of our knowledge, the information contained herein is accurate. However, STAR TECHNOLOGY, Inc., does not assume any liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of the suitability of any material is the sole responsibility of the user. The information contained herein is considered typical properties and is not intended to be used as specifications for our products. This information is offered solely to assist purchaser in selecting the appropriate products for purchaser's own testing. All materials may present unknown hazards and should be used with caution. Although certain hazards are described herein and in the material safety data sheet, we cannot guarantee that these are the only hazards that exist. Repeated and prolonged exposure to epoxy resins can cause sensitization or other allergic responses.



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PRECAUTIONS

For industrial use only. Keep away from children.

Refer to the Safety Data Sheets (SDS forms) pertaining to this product before using.

Avoid contact with skin or eyes. In the event of an eye splash or contact, immediately flush with cold water for 15 minutes and contact a physician. If skin contact occurs, wash with mild soap and water. The wearing of safety glasses with side shields and impervious gloves is recommended.

RESIN WARNING STATEMENT

Warning! Causes irritation. May cause allergic skin reaction. Avoid all contact with skin, eyes, and clothing. Wash thoroughly after handling.

HARDENER WARNING STATEMENT

Danger! Corrosive. Causes burns to eye and skin. May cause allergic skin and/or respiratory reaction or sensitization. Do not get in eyes, on skin or clothing. Keep container closed. Use with adequate ventilation. Wash thoroughly after handling.

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