



**resoltech**  
ADVANCED TECHNOLOGY RESINS

# 2200

## EPOXY CASTING SYSTEM

---

RESOLTECH 2200 is an epoxy casting system formulated to be cast in thick films for CNC machining and milling.

RESOLTECH 2200 is a mineral filled system available with different hardeners to adjust reactivity. It cures at ambient temperature.

RESOLTECH 2200 can be used for toolmaking, foundry patterns, working models, duplicate milling models, jigs and fixtures.

---

### MIXING RATIO

The mixing ratio is as follow:

By weight: 100 + 20.

By volume: Not available.

Hardeners available: 2201 (slow) to 2209 (fast).

We advise the use of a mechanical mixing system.

**WARNING:** The mixing ratio must be accurately followed. It is not possible to change the ratio, it would result in lower mechanical properties. The mixture should be thoroughly stirred to ensure full homogeneity.

It is important to note that epoxy systems tend to heat up much faster in a pot than as a thin film. It is therefore necessary to only mix the necessary amount usable within the given pot life. Keeping the mixture in flat open containers reduces the risks of exothermic reaction.

### APPLICATION

The standard procedure of working with epoxy systems applies to the RESOLTECH 2200.

2200 should always be stirred thoroughly before use.

The system is to be used for casting. The system can be applied in one or several layers.

In case of applying over a cured epoxy surface without peel ply, it is required to deglaze, clean and degrease the support prior to laminating.

For more information, please refer to the applications technical bulletins (TechNotes), available on request.

Film thickness: 10 to 100mm depending on the hardener selected.

### CURING

Workshop conditions: 18 to 25°C, 70% humidity maximum. Do not apply in temperatures lower than 10°C.

Pot life	25mn to 2H	(1000ml @ 25°C)
Hard film	10 to 16 Hours	Depending on the hardener selected.
Ready to mill	10 to 16 Hours	

## PHYSICAL PROPERTIES

Resin aspect	Pale yellow liquid
Hardener aspect	Clear liquid
Mixture aspect	Pale yellow liquid
Resin viscosity	100.000 mPas
Hardener viscosity	30 to 70 mPas
Mixture viscosity	4000 to 5000 mPas
Density of mixture	1.6

## CURED PROPERTIES

Thermal dilatation	$45.10^{-6}K^{-1}$
Shore D hardness	85 to 90
Compression strength	85 MPa
Compression modulus	4000 MPa
Flexural strength	60 to 75 MPa
Abrasion (Taber)	90-100mm <sup>3</sup> /100t
Linear shrinkage	1/10,000
Max TG	70°C

## PACKING & STORAGE

Resoltech 2200 is available as follow:  
1kg (0.83+0.17); 12kg (10+2).

Shelf life is one year in sealed containers as provided. Keep containers sealed and away from heat and cold.

## HEALTH AND SAFETY

It is advised to follow basic rules such as avoiding skin contact, wear masks when producing dust. Please read our standard health and safety sheet for more information.  
In case of eye contamination, wash with water and seek medical advice.

More information is available on [www.resoltech.com](http://www.resoltech.com).

The data provided in this document is the result of tests and is believed to be accurate. We do not accept any responsibility over the mishandling of these products and our liability is limited strictly to the value of the products we manufacture and supply.

---

**RESOLTECH SARL**  
resolving your engineering challenges  
[www.resoltech.com](http://www.resoltech.com)

35 Impasse Emeri. Pole d'activites. 13510 Eguilles. France  
export@resoltech.com Tel: +33 (0)442 950195 Fax: +33 (0)442 950198