

resoltech 8010 W

Hardener 8015 W
Water based sprayable epoxy filler



- Models/patterns making
- Direct moulds
- Room temperature curing
- 1.7mm thick max by layer
- Very easy to sand
- No COV and CMR component
- Polystyrene compatible

INTRODUCTION

RESOLTECH 8010 W / 8015 W system results of the latest advances in epoxy chemistry formulation and **eliminates all solvents** used normally with sprayable primers and fillers, replacing them with water, thus improving the **H&S conditions** for workers.

8010 W enables to produce models or direct moulds on any type of support previously milled by CNC or by hand.

This filler can be applied on all supports, composite, wood, foam, calibrated wax, polystyrene. It is recommended to apply a layer of **1010 ECO / 1014** on porous substrate as wood, this limit water absorption of this and avoid crack of 8010 W / 8015 W.

The 8010 W maybe **sprayed with gravity spray guns with (3,5 mm nozzle) and pressure return on the roller, applied by brush or with a flat spatula**. The fast drying characteristics and ease of sanding make it possible to apply various layers per day. Dilution ratio can be adapted to uses, 5% of water on mix for brush or roller apply, 20% of water on mix for spray gun apply.

It is best to apply the water based epoxy paint **4030W BLANC / 4034W** as topcoat to close the surface and enable to laminate on the 8010 W. For a mat finish, use **4036 WM**. This paint can be applied by brush, roller or spray gun. This result in hard finish with excellent chemical resistance.

MIXING RATIO

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.

System	8010 W / 8015 W
Mixing ratio by weight	100/21

APPLICATION

- It is recommended to use products at a temperature close to 18-25°C in order to facilitate the mixing and the reinforcements impregnation.
- Lower temperatures will increase the viscosity of the mixture and the gel time, but the resin will not crystallize at low temperatures.
- On the contrary, a higher temperature will reduce the viscosity of the mixture as well as the pot life.
- It is recommended to conduct a preliminary test before validation at industrial level.

PHYSICAL CHARACTERISTICS

1 Visual aspect

8010 W :

Light grey paste

8015 W :

Yellow viscous liquid

Mix :

Light grey viscous liquid

2 Density

References	8010 W	8015 W
Density at 23°C	0.60	1.05
Mix density at 23°C	-	0.67

ISO 1675, ± 0.05 tolerance

3 Viscosity

System	8010 W / 8015 W			
Dilution in weight of mix	0%	5%	10%	15%
Mix viscosity at 23°C (mPa.s)	7500	3800	2200	1500

Measured with Brookfield viscometer, shear rate : 25s⁻¹, measured after 10sec

REACTIVITIES

System	8010 W / 8015 W			
Dilution in weight of mix	0%	5%	10%	15%
Potlife on 70mL	5h	-	-	-
Dry to touch*	45min	45min	1h15	1h45
Hard and sandable*	12h to 24h			

* on polystyrene substrate
Drying time may vary depending on dilution ratio with water.

RETICULATION & POST-CURING

RESOLTECH 8010 W / 8015 W system cures at room temperature. Like for all water based products, curing time will depend on the local conditions: well ventilated / dry conditions will favour the cure speed.

System		8010 W / 8015 W	
Dilution in weight of mix		0%	15%
7j at 23°C	T _g	50°C	50°C
	Shore A Hardness	85	78

T_g measured by DSC, 10°C/min, inflexion point
Shore A hardness measured at 23°C according to ISO 868

PACKAGING

- Plastic pot of 0.5kg + 0.105kg
- Plastic bucket of 3kg + 0.63kg
- Plastic bucket of 10kg + 2.1kg
- Plastic bucket of 15kg + 3.15kg

TRANSPORT & STORAGE

Keep containers sealed and away from heat and cold preferably between 10°C and 30°C in a well ventilated area. Our products are guaranteed in their original packaging (check expiry date on the label).

HEALTH & SAFETY

Skin contact must be avoided by wearing protective nitrile gloves & overalls or other protective clothing. Eye protection should be worn to avoid risk of resin, hardener, solvent or dust entering the eyes. If this occurs flush the eye with water for 15 minutes, holding the eyelid open, and seek medical attention.

Ensure adequate ventilation in work areas. Respiratory protection should be worn with ABEKP coded filters.

Resoltech issues full Material Safety Data Sheet for all hazardous products. Please ensure that you have the correct MSDS to hand for the materials you are using before commencing work.

! 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.

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