

Type	EL199HP	EL217CM	EL366D	EL420CR	EL600F	PX459E	PX459MC	PX771C
Application	Polyurethane Silicone replacement Mould making	Polyurethane Concrete casting	Polyurethane Rapid prototyping Figurines	Polyurethane Decorative	Polyurethane Foundry patterns	Epoxy Machine parts Pattern making	Epoxy Metal simulation Vacuum forming tools	Epoxy Laminating
Features	Flexibility Toughness Low viscosity Low shrinkage	Self lubricating Abrasion resistant High toughness Low exotherm	Very fast curing Very low viscosity High rigidity High definition	Water white Low shrinkage UV stability Flexibility	Fast curing Low shrinkage Dimensional stability	Low viscosity Low shrinkage High definition	Thermal conductivity Low shrinkage Dimensional stability	Low viscosity High definition Filler can be added
Colour	Natural beige	Natural Beige	Natural beige	Water white	Natural beige	Black	Metallic	Clear amber
Packaging	Twinpacks 1, 5, 10kg kits 8 minutes	Twinpacks 1, 5, 10kg kits 90 minutes	Twinpacks 1, 5, 10kg kits 90 seconds	Twinpacks 1, 5, 10kg kits 15 minutes	Twinpacks 1, 5, 10kg kits 300 seconds	Twinpacks 1, 5, 10, 20kg kits 30 minutes	Twinpacks 1, 5, 10kg kits 60 minutes	Twinpacks 1, 5, 10kg kits 30 minutes
Working life								
* Gel time	12 minutes	4 hours	180 seconds	30 minutes	10 minutes	60 minutes	6 hours	60 minutes
* De-mould time	60 minutes	16 hours	5 minutes	120 minutes	30 minutes	16 hours	16 hours	16 hours
* Minimum cure	3 hours	24 hours	1 hour	6 hours	2 hours	24 hours	24 hours	24 hours
* Full cure time	24 hours	48 hours	6 hours	24 hours	48 hours	48 hours	96 hours	48 hours
Shore hardness	A45	A65	D70	A65	D80	D85	D85	D85
Mix ratio (weight)	5:1	6:1	1:1	10:7	3:1	3.5:1	12.7:1	2.7:1
Mix viscosity (m.Pa.s @ 25.C)	2000	2000	200	800	3000	1500	7500	900
Related products		EL217C – non lubricating	EL366S - slow			PX439N – thermal conductivity		PX771L – low viscosity

\* Dependant on ambient temperature and cross sectional area

