



Freeman 815-2 Iron-Filled Epoxy Casting Resin

Description

Freeman 815-2 is an iron-filled epoxy tooling resin that features low shrinkage and good abrasion resistance. May be used for foundry patterns, stretch forms, corebox construction, dies and some metal forming applications. Recommended casting thickness for the Freeman 815-2 is a minimum of 2" and a maximum of 6" in non-conductive molds. May be cast up to 9" thick in metal or conductive-type molds.

Physical Properties

| | |
|----------------------------------|--------|
| Color | Black |
| Mix Ratio (by weight) | 12:1 |
| Mix Ratio (by volume) | 4.5:1 |
| Viscosity, Mixed (cps) | 35,000 |
| Gel Time (minutes @ 77°F) | 240 |
| Demold Time (hours) | 24 |
| Hardness (Shore D) | 85 |
| Specific Gravity (g/cc) | 2.27 |
| Volumetric Yield (cu. in./ lb.) | 12.2 |
| Heat Distortion Temperature (°F) | 123 |
| Tensile strength (psi) | 5,400 |
| Compressive Strength (psi) | 12,600 |
| Flexural Strength (psi) | 7,400 |
| Shrinkage (in/in) | 0.001 |

The user shall determine the suitability of this product for their application and assumes all risks and liabilities associated with the use of this product. The exclusive remedy for all proven claims is replacement of our materials only and in no event shall Freeman Mfg. & Supply Co. be liable for special, incidental, or consequential claims.