



Technical Data Sheet

Freeman 815 Iron-Filled Epoxy Casting Resin

Description

Freeman 815 is an iron-filled epoxy tooling resin that features low shrinkage and good abrasion resistance. Freeman 815 is used for foundry patterns, stretch forms, corebox construction, dies and some metal forming applications. Freeman 815 can be cast up to 2" thick.

Physical Properties

Color	Black
Mix Ratio (by weight)	100:10
Mix Ratio (by volume)	100:26
Viscosity, Mixed (cps)	20,000
Gel Time (minutes @ 77°F)	85
Demold Time (hours)	24
Hardness (Shore D)	87
Specific Gravity (g/cc)	2.24
Volumetric Yield (cu. in./ lb.)	12.4
Deflection Temperature (°F)	135
Tensile strength (psi)	6,100
Compressive Strength (psi)	14,600
Flexural Strength (psi)	7,800
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.

READ SAFETY DATA SHEETS AND PRODUCT LABELS BEFORE USING PRODUCT