



Metalset® A-30

Epoxy Casting Compound

Description: Metalset® A-30 is a non-setting, low viscosity casting compound having low overall shrinkage. It is heavily filled with atomized aluminum powder and mineral filler. With room temperature curing agents it can be used for general casting such as models, patterns, jigs and fixtures and short run light metal forming dies. It was designed, however, primarily for use with Sonite® (high temperature) hardener #16 for the production of oven-cured vacuum forming molds. This product has a limited shelf life and should be used as soon as possible.

PROPERTIES: WITH VARIOUS HARDENERS

<u>Sonite® Hardener</u>	<u>16</u>
Parts Hardener to 100 parts A30 by weight	8
Viscosity of mix	12,000
Pot Life- 100 grams: in minutes	250
Recommended Cure Cycle - Hrs/°C	24/25
	+2/80
	+3/150
Max. Recommended thickness of casting	2.5"

PHYSICAL PROPERTIES OF SYSTEMS after RECOMMENDED CURE CYCLE

Hardness (Barcol 935)	90
Tensile Strength, psi x 10 ³	6.0
Tensile Elongation, %	0.5
Tensile Modulus, psi x 10 ⁵	7.2
Heat Distortion Temperature, °C	101
Linear shrinkage, after recommended cure cycle plus 30 days at 25 °C, inch/inch	0.0065
Linear shrinkage, after recommended cure cycle plus 30 days at 100 °C, inch/inch	0.0070
(Shrinkage tests performed per ASTM D 2566-69 using CM ³ mold)	

CAUTION: Epoxy resins are irritating to the eyes and skin. Avoid prolonged or repeated skin contact to prevent possible sensitization. Use only with adequate ventilation. If contaminated, flush eyes with water for 15 minutes and seek medical attention. Remove from skin with waterless hand cleaner, then soap and water.

WARNING: Sonite® 03, Sonite® 07 and Sonite® 16 contain aliphatic amine which is a corrosive material that can cause severe eye and skin irritation. Also, they are skin sensitizers that may cause dermatitis from skin contact or vapor inhalation.

Materials should be stored and used in a warm environment (72° F / 22° C). They also have a limited shelf life and should be used as soon as possible. Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. Use these products only with adequate ventilation. Remove contaminated clothing and wash from skin with soap and water for 15 minutes and get medical attention.

Refer to Material Safety Data Sheets for additional information on individual products. **Because no two applications are quite the same, a small test application to determine suitability for your project is recommended if performance of this material is in question.**

DISCLAIMER: These products have been tested to assure conformance to certain quality control standards. However, since the manufacturer has no control over actual application, no warranty is expressed or implied regarding the results to be obtained from the use thereof. User must determine suitability of these products for the intended applications and assume all risk and liability in connection therewith.

For Technical Help:

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