



SONITE® 16

Hardener For Epoxy Resins

PRODUCT OVERVIEW

SONITE® 16 Hardener is an amine blend castable epoxy curative which will cure epoxy bases (such as Formula 20-136® Part A or A-30® Part A). Room temperature cure is adequate. Post curing is recommended to attain maximum physical and performance properties

TECHNICAL OVERVIEW

Key Values: ~**Mixing Ratio:** See technical bulletin for A-30® or 20-136® Castable Epoxies

<u>Properties</u>	<u>Viscosity</u>	<u>G/CC</u>	<u>Elongation At Break</u>	<u>Tensile Strength</u>
A-30®+Hardener Mixed	10,000 cps	0.98	0.7%	6000 psi
20-136® + Hardner	12,000 cps	1.15	0.65	4500

See technical bulletin for A-30® or 20-136® for additional technical values.

Curing

Post Curing

For Most Applications, room temperature curing (72 F/22 C) for 24-48 hours is adequate. Epoxy will reach ultimate physical properties at room temperature in 5-7 days. At this point, the epoxy is still brittle and should be removed from the mold carefully. Then follow the recommended post cure making certain that casting is on a flat surface to prevent distortion.

Post Curing . . . Epoxy will cure faster and achieve maximum physical properties and heat resistance if post cured. Post Curing is recommended if castings are thin or of a low mass concentration. Castings should be post cured in a mold or support structure.

Post Cure Schedule . . . Allow the material to cure for 24 hours at room temperature (70 F/22 C) for 24 hours followed by 2 hours at 80 C and 3 hours at 150 C. Allow casting or part to cool to room temperature before demolding.

Mixing

Preparation . . . Your mixing tools and containers should be clean and made of metal, glass or plastic. To minimize the introduction of harmful moisture to your mix or unused product, do not use wooden utensils or paper containers. Materials should be stored and used in a warm environment (72° F / 22° C). This product has a limited shelf life and should be used as soon as possible. Product and related accessories should be used in a **well ventilated area.** Wearing latex gloves and long sleeve garments will help minimize skin contact.

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.

Measuring . . . The proper mixing ratio is 8 Parts of Sonite® 16 to 100 Parts of Metalset® A-30 by weight. Mix ratio is 15.5 Parts of Sonite® 16 to 100 Parts of 20-136®. You must use an accurate scale (gram scale or triple beam balance scale) to weigh these components properly. Mix carefully for 3 minutes. Empty contents into a new mixing container and mix for 3 minutes.

Vacuum Degassing – Subject mixture to 29 h.i.g. vacuum until mixture rises and falls.

Pour into mold or over other surface.

Follow cure schedule on enoxv technical bulletin.

Safety First!

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The Material Safety Data Sheet (MSDS) for this or any Smooth-On product should be read prior to use and is available upon request from Smooth-On. All Smooth-On products are safe to use if directions are read and followed carefully.

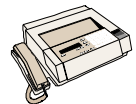
Be Careful! SONITE® 16 Hardener is corrosive, causing severe skin and eye burns. Avoid prolonged or repeated skin contact to prevent possible sensitization. Use only with adequate ventilation. If contaminated flush eyes with water for 15 minutes and seek medical attention. Remove from skin with waterless hand cleaner then soap and water. Refer to MSDS.

Important! The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding this accuracy, the results to be obtained from the use thereof, or that any such will not infringe a patent. User shall determine beforehand the suitability of this product for the intended application and assume all risk and liability in connection therewith.

Smooth-On offers a complete line of Liquid Rubber and Liquid Plastic products for hundreds of industrial and art related applications.



Feel free to call or fax us any time with your questions.



Chances are there is a distributor in your area to offer local support.

Toll-free: (800) 762-0744

Outside The U.S.: (610) 252-5800

Fax: (610) 252-6200

Or visit the Smooth-On Website at: www.smooth-on.com