

# STAR Technology

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## 810-01

### Durable Epoxy Model and Tooling Board Adhesive

#### DESCRIPTION

STAR Technology 810-01 has been specially designed to laminate E-65 epoxy tooling board. 810-01 creates a seamless bond line and is specifically designed for durable tooling and model making applications. 810-01 is free machining to produce curled turnings rather than "dust". 810-01 contains no abrasive fillers to damage cutting tools and, 810-01 shows outstanding stability in extreme humidity and has a low coefficient of thermal expansion.

#### Typical Properties

	<u>TEST METHOD</u>	<u>VALUE</u>
Color		Red
Mixed Viscosity (cps)	ASTM D2393	18,000
Density (lb/ft <sup>3</sup> nominal)	ASTM D1475	65
Shore Hardness (D)	ASTM D2240	70
Pot Life	ASTM D2471	17
Heat Distortion Temperature by DSC		80°C
Tensile Strength (psi)	ASTM D638	6,000
Elongation at break		~4 %
CTE (u/u/°C)	ASTM D	7x10 <sup>-5</sup>
Flexural Modulus (psi)		6.53x10 <sup>7</sup>
Compressive Strength (psi)	ASTM D695	8,000
Mix Ratio		100:50 by weight 100:60 by volume
Gel Time		
150 gram mass		15 minutes
Thin Film		60-90 minutes
Shrinkage (%)		nil
CTE. (in/in/°C)	ASTM D696	5x10 <sup>-5</sup>

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