

Fill Cast 21

Formulated Filler For Tool Making By Casting

Description

Grey powder
Mix of reinforcing mineral fillers and aluminium powder

Advantages

Compatible with polyurethane, polyester, vinylester and epoxy resins.
Low density of the mix Resin/Fill Cast 21
Thermal conductivity close to Aluminium
Gelcoat is not needed:
Before the casting, apply with a brush a mix of resin and Fill Cast 2.1 on the surface of the pattern.
Self levelling epoxy system.

Physical properties

Bulk density : 1.10
Colour : Light grey

Mixing Ratio with resin:

100 g resin + 65 – 70 g Fill Cast 21
Or Resin / FC21: 60 / 40 by weight

Density of a mix epoxy Resin / FC 21 : 1.29 kg / liter

Examples : Epoxy Systems Suitable For Mixing With FC 21

Service Temperature Of The Mould (Tg -30)	Advised Sc Resins	Thickness Of The Casting @ 20 °C Indicative Values
40-50 °C	8500 / 8601 8500 / 7160	7 cm 9 cm
70 °C	8200 / 8203 8200 / 8202	2 cm 3 cm
90 °C	8500 / 8203 8500 / 8202	2 cm 3 cm
110 °C	1700 / 7820	4 cm
120 °C	1660 / 2630 1660 / 7820	9 cm 4 cm
170 °C	1720 / 7840	7 cm

